

# 切削條件表 MILLING CONDITIONS

# AET-2T

被切削材 Work Material		鋁合金 Aluminum Alloy : 5052 / 6061 / 7075					建議機器轉速RPM=10000 (min <sup>-1</sup> ) 以下 Be used under the machine of RPM=10000 (min <sup>-1</sup> )		
冷卻方式 Coolant Type		濕式切削 Wet coolant							
型號 Type No.	刀具伸長量 Extension Length (mm)	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type		
AET0052	13	15	9500~10000	500~700	0.04~0.06	0.1~0.5	溝銑 SLOTTING		
AET0052	13	15	9500~10000	300~500	1	0.04~0.06	側銑 SIDE MILLING		
AET0102	13	30	9500~10000	800~1000	0.05~0.08	0.5~1	溝銑 SLOTTING		
AET0102	13	30	9500~10000	600~800	2	0.05~0.08	側銑 SIDE MILLING		
AET0152	13	45	9500~10000	1000~1200	0.05~0.08	0.5~1.5	溝銑 SLOTTING		
AET0152	13	45	9500~10000	800~1000	3	0.05~0.08	側銑 SIDE MILLING		
AET0202	14	60	9500~10000	1800~2200	0~0.2	0.5~2	溝銑 SLOTTING		
AET0202	14	60	9500~10000	1000~1200	0.05~0.08	0.5~2	溝銑 SLOTTING		
AET0202	14	60	9500~10000	2000~2400	4	0~0.2	側銑 SIDE MILLING		
AET0202	14	60	9500~10000	800~1000	4	0.05~0.08	側銑 SIDE MILLING		
AET0302	14	90	9500~10000	2200~2600	0~0.4	1~3	溝銑 SLOTTING		
AET0302	14	90	9500~10000	1000~1400	0.05~0.1	1~3	溝銑 SLOTTING		
AET0302	14	90	9500~10000	2600~3000	6	0~0.4	側銑 SIDE MILLING		
AET0302	14	90	9500~10000	800~1200	6	0.05~0.1	側銑 SIDE MILLING		
AET0402	16	120	9500~10000	2800~3200	0~0.6	2~4	溝銑 SLOTTING		
AET0402	16	120	9500~10000	1200~1600	0.05~0.12	2~4	溝銑 SLOTTING		
AET0402	16	120	9500~10000	3000~3400	8	0~0.6	側銑 SIDE MILLING		
AET0402	16	120	9500~10000	1000~1400	8	0.05~0.12	側銑 SIDE MILLING		
AET0502	18	150	9500~10000	3400~3800	0~0.7	3~5	溝銑 SLOTTING		
AET0502	18	150	9500~10000	1400~1800	0.05~0.15	3~5	溝銑 SLOTTING		
AET0502	18	150	9500~10000	3400~3800	10	0~0.7	側銑 SIDE MILLING		
AET0502	18	150	9500~10000	1000~1400	10	0.05~0.15	側銑 SIDE MILLING		
AET0602	20	170	9000~9500	3400~3800	0~1	4~6	溝銑 SLOTTING		
AET0602	20	170	9000~9500	1400~1800	0.05~0.15	4~6	溝銑 SLOTTING		
AET0602	20	170	9000~9500	3400~3800	12	0~1	側銑 SIDE MILLING		
AET0602	20	170	9000~9500	1000~1400	12	0.05~0.15	側銑 SIDE MILLING		
AET0802	26	215	8500~9000	3400~3800	0~1.5	6~8	溝銑 SLOTTING		
AET0802	26	215	8500~9000	1600~2000	0.05~0.15	6~8	溝銑 SLOTTING		
AET0802	26	215	8500~9000	3600~4000	16	0~2	側銑 SIDE MILLING		
AET0802	26	215	8500~9000	1400~1800	16	0.05~0.15	側銑 SIDE MILLING		
AET1002	30	245	7800~8200	4000~4500	0~2	8~10	溝銑 SLOTTING		
AET1002	30	245	7800~8200	1400~1800	0.05~0.15	8~10	溝銑 SLOTTING		
AET1002	30	245	7800~8200	4000~4500	20	0~2	側銑 SIDE MILLING		
AET1002	30	245	7800~8200	1400~1800	20	0.05~0.15	側銑 SIDE MILLING		
AET1202	36	295	7800~8200	4000~4500	0~2	10~12	溝銑 SLOTTING		
AET1202	36	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑 SLOTTING		
AET1202	36	295	7800~8200	3200~3600	24	0~2	側銑 SIDE MILLING		
AET1202	36	295	7800~8200	1200~1600	24	0.05~0.15	側銑 SIDE MILLING		

**切削條件表 MILLING CONDITIONS**

# AET-2T

被切削材 Work Material		鋁合金 Aluminum Alloy : 5052 / 6061 / 7075					建議機器轉速RPM=20000 (min <sup>-1</sup> ) 以下 Be used under the machine of RPM=20000 (min <sup>-1</sup> )		
冷卻方式 Coolant Type		濕式切削 Wet coolant							
型號 Type No.	刀具伸長量 Extension Length (mm)	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type		
AET0052	13	30	18000~20000	600~800	0.04~0.06	0.1~0.5	溝銑 SLOTTING		
AET0052	13	30	18000~20000	400~600	1	0.04~0.06	側銑 SIDE MILLING		
AET0102	13	60	18000~20000	1200~1400	0.05~0.08	0.5~1	溝銑 SLOTTING		
AET0102	13	60	18000~20000	1000~1200	2	0.05~0.08	側銑 SIDE MILLING		
AET0152	13	85	18000~20000	1400~1600	0.05~0.08	0.5~1.5	溝銑 SLOTTING		
AET0152	13	85	18000~20000	1200~1400	3	0.05~0.08	側銑 SIDE MILLING		
AET0202	14	110	17000~18000	2200~2600	0~0.2	0.5~2	溝銑 SLOTTING		
AET0202	14	110	17000~18000	1400~1600	0.05~0.08	0.5~2	溝銑 SLOTTING		
AET0202	14	110	17000~18000	2600~3000	4	0~0.2	側銑 SIDE MILLING		
AET0202	14	110	17000~18000	1400~1600	4	0.05~0.08	側銑 SIDE MILLING		
AET0302	14	160	17000~18000	2600~3000	0~0.4	1~3	溝銑 SLOTTING		
AET0302	14	160	17000~18000	1800~2200	0.05~0.1	1~3	溝銑 SLOTTING		
AET0302	14	160	17000~18000	3000~3400	6	0~0.4	側銑 SIDE MILLING		
AET0302	14	160	17000~18000	1600~2000	6	0.05~0.1	側銑 SIDE MILLING		
AET0402	16	200	16000~17000	3400~3800	0~0.6	2~4	溝銑 SLOTTING		
AET0402	16	200	16000~17000	2000~2400	0.05~0.12	2~4	溝銑 SLOTTING		
AET0402	16	200	16000~17000	3400~3800	8	0~0.6	側銑 SIDE MILLING		
AET0402	16	200	16000~17000	1600~2000	8	0.05~0.12	側銑 SIDE MILLING		
AET0502	18	235	15000~16000	4400~4800	0~0.7	3~5	溝銑 SLOTTING		
AET0502	18	235	15000~16000	2400~2800	0.05~0.15	3~5	溝銑 SLOTTING		
AET0502	18	235	15000~16000	4400~4800	10	0~0.7	側銑 SIDE MILLING		
AET0502	18	235	15000~16000	1600~2000	10	0.05~0.15	側銑 SIDE MILLING		
AET0602	20	285	15000~16000	4400~4800	0~1	4~6	溝銑 SLOTTING		
AET0602	20	285	15000~16000	2400~2800	0.05~0.15	4~6	溝銑 SLOTTING		
AET0602	20	285	15000~16000	4400~4800	12	0~1	側銑 SIDE MILLING		
AET0602	20	285	15000~16000	1600~2000	12	0.05~0.15	側銑 SIDE MILLING		
AET0802	26	355	14000~15000	4500~5000	0~1.5	6~8	溝銑 SLOTTING		
AET0802	26	355	14000~15000	2200~2600	0.05~0.15	6~8	溝銑 SLOTTING		
AET0802	26	355	14000~15000	5000~5500	16	0~2	側銑 SIDE MILLING		
AET0802	26	355	14000~15000	2000~2400	16	0.05~0.15	側銑 SIDE MILLING		
AET1002	30	380	12000~13000	5500~6000	0~2	8~10	溝銑 SLOTTING		
AET1002	30	380	12000~13000	2000~2400	0.05~0.15	8~10	溝銑 SLOTTING		
AET1002	30	380	12000~13000	6000~6500	20	0~2	側銑 SIDE MILLING		
AET1002	30	380	12000~13000	1800~2200	20	0.05~0.15	側銑 SIDE MILLING		
AET1202	36	295	7800~8200	4000~4500	0~2	10~12	溝銑 SLOTTING		
AET1202	36	295	7800~8200	1200~1600	0.05~0.15	10~12	溝銑 SLOTTING		
AET1202	36	295	7800~8200	3200~3600	24	0~2	側銑 SIDE MILLING		
AET1202	36	295	7800~8200	1200~1600	24	0.05~0.15	側銑 SIDE MILLING		