

切削條件表 MILLING CONDITIONS

AESR

被切削材 Work Material		鋁合金 Aluminum Alloy : 5052 / 6061 / 7075						
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 ⁻¹)	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	
AESR0305	16	90	9500~10000	2000~2500	0~0.4	1~3	溝銑 SLOTTING	
AESR0305	16	90	9500~10000	1200~1600	0.5~0.8	1~3	溝銑 SLOTTING	
AESR0305	16	90	9500~10000	600~800	0.9~1.2	1~3	溝銑 SLOTTING	
AESR0305	16	90	9500~10000	1000~1400	0.05~0.1	1~3	溝銑 SLOTTING	
AESR0305	16	90	9500~10000	2000~2500	3	0~0.4	側銑 SIDE MILLING	
AESR0305	16	90	9500~10000	1500~2000	3	0.5~0.8	側銑 SIDE MILLING	
AESR0305	16	90	9500~10000	1000~1200	3	0.9~1.2	側銑 SIDE MILLING	
AESR0305	16	90	9500~10000	1000~1400	3	0.05~0.1	側銑 SIDE MILLING	
AESR0405	16	120	9500~10000	3000~3500	0~0.6	2~4	溝銑 SLOTTING	
AESR0405	16	120	9500~10000	1500~2000	0.7~1.2	2~4	溝銑 SLOTTING	
AESR0405	16	120	9500~10000	1000~1500	1.3~2	2~4	溝銑 SLOTTING	
AESR0405	16	120	9500~10000	1000~1400	0.05~0.12	2~4	溝銑 SLOTTING	
AESR0405	16	120	9500~10000	3000~3500	4	0~0.6	側銑 SIDE MILLING	
AESR0405	16	120	9500~10000	1500~2000	4	0.7~1.2	側銑 SIDE MILLING	
AESR0405	16	120	9500~10000	1000~1500	4	1.3~2	側銑 SIDE MILLING	
AESR0405	16	120	9500~10000	1000~1400	4	0.05~0.12	側銑 SIDE MILLING	
AESR0605	20	175	9000~9500	3500~4000	0~1	4~6	溝銑 SLOTTING	
AESR0605	20	175	9000~9500	2500~3000	2~3	4~6	溝銑 SLOTTING	
AESR0605	20	175	9000~9500	1700~2200	3.5~6	4~6	溝銑 SLOTTING	
AESR0605	20	175	9000~9500	1200~1600	0.05~0.15	4~6	溝銑 SLOTTING	
AESR0605	20	175	9000~9500	3500~4000	6	0~1	側銑 SIDE MILLING	
AESR0605	20	175	9000~9500	2500~3000	6	2~3	側銑 SIDE MILLING	
AESR0605	20	175	9000~9500	1700~2200	6	3.5~6	側銑 SIDE MILLING	
AESR0605	20	175	9000~9500	1200~1600	6	0.05~0.15	側銑 SIDE MILLING	
AESR0610	20	175	9000~9500	3500~4000	0~1	4~6	溝銑 SLOTTING	
AESR0610	20	175	9000~9500	2500~3000	2~3	4~6	溝銑 SLOTTING	
AESR0610	20	175	9000~9500	1700~2200	3.5~6	4~6	溝銑 SLOTTING	
AESR0610	20	175	9000~9500	1200~1600	0.05~0.15	4~6	溝銑 SLOTTING	
AESR0610	20	175	9000~9500	3500~4000	6	0~1	側銑 SIDE MILLING	
AESR0610	20	175	9000~9500	2500~3000	6	2~3	側銑 SIDE MILLING	
AESR0610	20	175	9000~9500	1700~2200	6	3.5~6	側銑 SIDE MILLING	
AESR0610	20	175	9000~9500	1200~1600	6	0.05~0.15	側銑 SIDE MILLING	
AESR0805	25	290	11000~12000	5000~5500	0~1.5	6~8	溝銑 SLOTTING	
AESR0805	25	220	8500~9000	3000~3500	2~4	6~8	溝銑 SLOTTING	
AESR0805	25	220	8500~9000	2000~2500	5~8	6~8	溝銑 SLOTTING	
AESR0805	25	220	8500~9000	1400~1800	0.05~0.15	6~8	溝銑 SLOTTING	
AESR0805	25	290	11000~12000	5500~6000	8	0~2	側銑 SIDE MILLING	
AESR0805	25	220	8500~9000	3500~4000	8	2.5~4	側銑 SIDE MILLING	
AESR0805	25	220	8500~9000	2000~2500	8	5~8	側銑 SIDE MILLING	
AESR0805	25	220	8500~9000	1600~2000	8	0.05~0.15	側銑 SIDE MILLING	

AESR

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 ⁻¹)	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
AESR0810	25	220	8500~9000	4000~4500	0~1.5	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	3000~3500	2~4	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	2000~2500	5~8	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	1400~1800	0.05~0.15	6~8	溝銑 SLOTTING
AESR0810	25	220	8500~9000	4500~5000	8	0~2	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	3500~4000	8	2.5~4	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	2000~2500	8	5~8	側銑 SIDE MILLING
AESR0810	25	220	8500~9000	1600~2000	8	0.05~0.15	側銑 SIDE MILLING
AESR1005	32	250	7800~8200	4500~5000	0~2	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	2000~2500	3~5	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	1000~1500	6~10	8~10	溝銑 SLOTTING
AESR1005	32	180	5500~6000	1200~1600	0.05~0.15	8~10	溝銑 SLOTTING
AESR1005	32	250	7800~8200	4500~5000	10	0~2	側銑 SIDE MILLING
AESR1005	32	180	5500~6000	2000~2400	10	3~5	側銑 SIDE MILLING
AESR1005	32	180	5500~6000	1000~1400	10	6~10	側銑 SIDE MILLING
AESR1005	32	250	7800~8200	1200~1600	10	0.05~0.15	側銑 SIDE MILLING
AESR1010	32	250	7800~8200	4500~5000	0~2	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	2000~2500	3~5	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	1000~1500	6~10	8~10	溝銑 SLOTTING
AESR1010	32	180	5500~6000	1200~1600	0.05~0.15	8~10	溝銑 SLOTTING
AESR1010	32	250	7800~8200	4500~5000	10	0~2	側銑 SIDE MILLING
AESR1010	32	180	5500~6000	2000~2400	10	3~5	側銑 SIDE MILLING
AESR1010	32	180	5500~6000	1000~1400	10	6~10	側銑 SIDE MILLING
AESR1010	32	250	7800~8200	1200~1600	10	0.05~0.15	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	5000~5500	0~2	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	3000~3500	3~6	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	2300~2800	7~12	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	1500~2000	0.05~0.15	10~12	溝銑 SLOTTING
AESR1205	37	295	7800~8200	5000~5500	24	0~2	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	3000~3500	24	3~6	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	2300~2800	24	7~12	側銑 SIDE MILLING
AESR1205	37	295	7800~8200	1500~2000	24	0.05~0.15	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	4500~5000	0~2	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	2700~3200	3~6	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	2000~2500	7~12	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	1500~2000	0.05~0.15	9~12	溝銑 SLOTTING
AESR1210	37	295	7800~8200	4500~5000	12	0~2	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	2700~3200	12	3~6	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	2000~2500	12	7~12	側銑 SIDE MILLING
AESR1210	37	295	7800~8200	1500~2000	12	0.05~0.15	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	3000~3500	0~2	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	2000~2500	3~5	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	1400~1800	6~7	14~16	溝銑 SLOTTING
AESR1605	55	325	6200~6700	1000~1400	0.05~0.2	14~16	溝銑 SLOTTING

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AESR1605	55	325	6200~6700	3500~4000	16	0~2	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	2000~2500	16	3~5	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	1500~2000	16	6~7	側銑 SIDE MILLING
AESR1605	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	2700~3200	0~2	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1800~2300	3~5	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1200~1600	6~7	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	1000~1400	0.05~0.2	13~16	溝銑 SLOTTING
AESR1610	55	325	6200~6700	3000~3500	16	0~2	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1800~2300	16	3~5	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1200~1600	16	6~7	側銑 SIDE MILLING
AESR1610	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	2300~2800	0~2	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1600~2000	3~5	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1000~1400	6~7	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	1000~1400	0.05~0.2	9~16	溝銑 SLOTTING
AESR1630	55	325	6200~6700	2500~3000	16	0~2	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1600~2000	16	3~5	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1000~1400	16	6~7	側銑 SIDE MILLING
AESR1630	55	325	6200~6700	1000~1400	16	0.05~0.2	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	2700~3200	0~2	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1700~2200	3~5	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1000~1400	6~7	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	1000~1400	0.05~0.2	18~20	溝銑 SLOTTING
AESR2005	65	315	5000~5400	2700~3200	20	0~2	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1700~2200	20	3~5	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1000~1400	20	6~7	側銑 SIDE MILLING
AESR2005	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	2400~2900	0~2	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	1500~2000	3~5	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	900~1200	6~7	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	1000~1400	0.05~0.2	16~20	溝銑 SLOTTING
AESR2010	65	315	5000~5400	2400~2900	20	0~2	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	1500~2000	20	3~5	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	900~1200	20	6~7	側銑 SIDE MILLING
AESR2010	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	2000~2500	0~2	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	1300~1700	3~5	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	800~1100	6~7	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	1000~1400	0.05~0.2	13~20	溝銑 SLOTTING
AESR2030	65	315	5000~5400	2000~2500	20	0~2	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	1300~1700	20	3~5	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	800~1100	20	6~7	側銑 SIDE MILLING
AESR2030	65	315	5000~5400	1000~1400	20	0.05~0.2	側銑 SIDE MILLING

2000~4000

0.07~0.1

12000~16000

1

0.0

12000~16000

1

0.0

5000~8000

1

0.0