

# AET-3T

## 切削條件表 MILLING CONDITIONS

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		
AET0203	14	60	9500~10000	2200~2600	0~0.2	0.5~2	溝銼 SLOTTING		
AET0203	14	60	9500~10000	1200~1600	0.05~0.08	0.5~2	溝銼 SLOTTING		
AET0203	14	60	9500~10000	2400~2800	4	0~0.2	側銼 SIDE MILLING		
AET0203	14	60	9500~10000	1200~1600	4	0.05~0.08	側銼 SIDE MILLING		
AET0303	16	90	9500~10000	2800~3200	0~0.4	1~3	溝銼 SLOTTING		
AET0303	16	90	9500~10000	1600~2000	0.05~0.1	1~3	溝銼 SLOTTING		
AET0303	16	90	9500~10000	3000~3400	6	0~0.4	側銼 SIDE MILLING		
AET0303	16	90	9500~10000	1400~1800	6	0.05~0.1	側銼 SIDE MILLING		
AET0403	18	115	9000~9500	3400~3800	0~0.6	2~4	溝銼 SLOTTING		
AET0403	18	115	9000~9500	1600~2000	0.05~0.12	2~4	溝銼 SLOTTING		
AET0403	18	115	9000~9500	3400~3800	8	0~0.6	側銼 SIDE MILLING		
AET0403	18	115	9000~9500	1400~1800	8	0.05~0.12	側銼 SIDE MILLING		
AET0503	20	125	7800~8300	3800~4200	0~0.7	3~5	溝銼 SLOTTING		
AET0503	20	125	7800~8300	1600~2000	0.05~0.15	3~5	溝銼 SLOTTING		
AET0503	20	125	7800~8300	3800~4200	10	0~0.7	側銼 SIDE MILLING		
AET0503	20	125	7800~8300	1200~1600	10	0.05~0.15	側銼 SIDE MILLING		
AET0603	22	150	7800~8200	4200~4600	0~0.9	4~6	溝銼 SLOTTING		
AET0603	22	150	7800~8200	1600~2000	0.05~0.15	4~6	溝銼 SLOTTING		
AET0603	22	150	7800~8200	4200~4600	12	0~0.9	側銼 SIDE MILLING		
AET0603	22	150	7800~8200	1600~2000	12	0.05~0.15	側銼 SIDE MILLING		
AET0803	26	175	7000~7500	3000~3400	0~1.5	6~8	溝銼 SLOTTING		
AET0803	26	215	8500~9000	1800~2200	0.05~0.15	6~8	溝銼 SLOTTING		
AET0803	26	215	8500~9000	1600~2000	16	0~1	側銼 SIDE MILLING		
AET0803	26	215	8500~9000	1600~2000	16	0.05~0.15	側銼 SIDE MILLING		
AET1003	30	245	7800~8200	4500~5000	0~2	8~10	溝銼 SLOTTING		
AET1003	30	245	7800~8200	1600~2000	0.05~0.15	8~10	溝銼 SLOTTING		
AET1003	30	245	7800~8200	4000~4500	20	0~2	側銼 SIDE MILLING		
AET1003	30	245	7800~8200	1600~2000	20	0.05~0.15	側銼 SIDE MILLING		
AET1203	36	295	7800~8200	5000~5500	0~2	10~12	溝銼 SLOTTING		
AET1203	36	295	7800~8200	1600~2000	0.05~0.15	10~12	溝銼 SLOTTING		
AET1203	36	295	7800~8200	4500~5000	24	0~2	側銼 SIDE MILLING		
AET1203	36	295	7800~8200	1600~2000	24	2	側銼 SIDE MILLING		
AET1603	55	325	6400~6800	4400~4800	0~2	14~16	溝銼 SLOTTING		
AET1603	55	325	6400~6800	1400~1800	0.05~0.2	14~16	溝銼 SLOTTING		
AET1603	55	325	6400~6800	4600~5000	32	0~2	側銼 SIDE MILLING		
AET1603	55	325	6400~6800	1400~1800	32	0.05~0.2	側銼 SIDE MILLING		

**切削條件表 MILLING CONDITIONS**

# AET-3T

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**

 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>)

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
AET0203	14	115	18000~20000	3400~3800	0~0.2	0.5~2	溝銑 SLOTTING
AET0203	14	115	18000~20000	1800~2200	0.05~0.08	0.5~2	溝銑 SLOTTING
AET0203	14	115	18000~20000	3400~3800	4	0~0.2	側銑 SIDE MILLING
AET0203	14	115	18000~20000	1800~2200	4	0.05~0.08	側銑 SIDE MILLING
AET0303	16	160	17000~18000	3800~4200	0~0.4	1~3	溝銑 SLOTTING
AET0303	16	160	17000~18000	2400~2800	0.05~0.1	1~3	溝銑 SLOTTING
AET0303	16	160	17000~18000	3800~4200	6	0~0.4	側銑 SIDE MILLING
AET0303	16	160	17000~18000	2000~2400	6	0.05~0.1	側銑 SIDE MILLING
AET0403	18	165	13000~14000	4200~4600	0~0.6	2~4	溝銑 SLOTTING
AET0403	18	165	13000~14000	2400~2800	0.05~0.12	2~4	溝銑 SLOTTING
AET0403	18	165	13000~14000	4200~4600	8	0~0.6	側銑 SIDE MILLING
AET0403	18	165	13000~14000	2000~2400	8	0.05~0.12	側銑 SIDE MILLING
AET0503	20	175	11000~12000	5000~5400	0~0.7	3~5	溝銑 SLOTTING
AET0503	20	175	11000~12000	2600~3000	0.05~0.15	3~5	溝銑 SLOTTING
AET0503	20	175	11000~12000	5000~5400	10	0~0.7	側銑 SIDE MILLING
AET0503	20	175	11000~12000	1800~2200	10	0.05~0.15	側銑 SIDE MILLING
AET0603	22	255	13000~14000	6000~6500	0~0.9	4~6	溝銑 SLOTTING
AET0603	22	255	13000~14000	2400~2800	0.05~0.15	4~6	溝銑 SLOTTING
AET0603	22	255	13000~14000	6500~7500	12	0~0.9	側銑 SIDE MILLING
AET0603	22	255	13000~14000	2200~2600	12	0.05~0.15	側銑 SIDE MILLING
AET0803	26	280	11000~12000	4000~4500	0~1	6~8	溝銑 SLOTTING
AET0803	26	355	14000~15000	2400~2800	0.05~0.15	6~8	溝銑 SLOTTING
AET0803	26	355	14000~15000	2800~3200	16	0~1	側銑 SIDE MILLING
AET0803	26	355	14000~15000	2200~2600	16	0.05~0.15	側銑 SIDE MILLING
AET1003	30	360	11000~12000	5500~6000	0~2	8~10	溝銑 SLOTTING
AET1003	30	360	11000~12000	2400~2800	0.05~0.15	8~10	溝銑 SLOTTING
AET1003	30	360	11000~12000	5500~6000	20	0~2	側銑 SIDE MILLING
AET1003	30	360	11000~12000	2200~2600	20	0.05~0.15	側銑 SIDE MILLING
AET1203	36	295	7800~8200	5000~5500	0~2	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	1600~2000	0.05~0.15	10~12	溝銑 SLOTTING
AET1203	36	295	7800~8200	4500~5000	24	0~2	側銑 SIDE MILLING
AET1203	36	295	7800~8200	1600~2000	24	2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	4400~4800	0~2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	1400~1800	0.05~0.2	14~16	溝銑 SLOTTING
AET1603	55	325	6400~6800	4600~5000	32	0~2	側銑 SIDE MILLING
AET1603	55	325	6400~6800	1400~1800	32	0.05~0.2	側銑 SIDE MILLING