

DC 3T

建議機器轉速 RPM = 10000 (min⁻¹) 以下
 < Be used under the machine of RPM = 10000 (min⁻¹) >

切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 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
DC0203	14	60	9500~10000	600~1000	0.05~0.1	2	溝銑 (Slotting)
DC0203	14	60	9500~10000	1000~1400	0.2	2	溝銑 (Slotting)
DC0203	14	60	9500~10000	600~1000	2	0.05~0.1	側銑 (Side milling)
DC0203	14	60	9500~10000	1200~1600	2	0.4	側銑 (Side milling)
DC0203	14	60	9500~10000	400~800	4	0.05~0.1	側銑 (Side milling)
DC0203	14	60	9500~10000	700~1100	4	0.2	側銑 (Side milling)
DC0303	16	90	9500~10000	700~1100	0.05~0.1	3	溝銑 (Slotting)
DC0303	16	90	9500~10000	1200~1600	0.3	3	溝銑 (Slotting)
DC0303	16	90	9500~10000	700~1100	3	0.05~0.1	側銑 (Side milling)
DC0303	16	90	9500~10000	1400~1800	3	0.4	側銑 (Side milling)
DC0303	16	90	9500~10000	400~800	6	0.05~0.1	側銑 (Side milling)
DC0303	16	90	9500~10000	800~1200	6	0.3	側銑 (Side milling)
DC0403	16	120	9500~10000	800~1200	0.05~0.1	4	溝銑 (Slotting)
DC0403	16	120	9500~10000	1200~1600	0.4	4	溝銑 (Slotting)
DC0403	16	120	9500~10000	800~1200	4	0.05~0.1	側銑 (Side milling)
DC0403	16	120	9500~10000	1400~1800	4	0.4	側銑 (Side milling)
DC0403	16	120	9500~10000	400~800	8	0.05~0.1	側銑 (Side milling)
DC0403	16	120	9500~10000	800~1200	8	0.4	側銑 (Side milling)
DC0503	16	155	9500~10000	800~1200	0.05~0.15	5	溝銑 (Slotting)
DC0503	16	155	9500~10000	1400~1800	0.4	5	溝銑 (Slotting)
DC0503	16	155	9500~10000	800~1200	5	0.05~0.15	側銑 (Side milling)
DC0503	16	155	9500~10000	1600~2000	5	0.4	側銑 (Side milling)
DC0503	16	155	9500~10000	400~800	10	0.05~0.15	側銑 (Side milling)
DC0503	16	155	9500~10000	1000~1400	10	0.4	側銑 (Side milling)

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DC0603	20	175	9000~9500	800~1200	0.05~0.15	6	溝銑 (Slotting)
DC0603	20	185	9500~10000	1600~2000	0.5	6	溝銑 (Slotting)
DC0603	20	175	9000~9500	800~1200	6	0.05~0.15	側銑 (Side milling)
DC0603	20	185	9500~10000	1800~2200	6	0.5	側銑 (Side milling)
DC0603	20	175	9000~9500	600~800	12	0.05~0.15	側銑 (Side milling)
DC0603	20	185	9500~10000	1200~1600	12	0.5	側銑 (Side milling)
DC0803	25	230	8800~9300	1000~1400	0.05~0.15	8	溝銑 (Slotting)
DC0803	25	230	8800~9300	1800~2200	0.5	8	溝銑 (Slotting)
DC0803	25	230	8800~9300	1000~1400	8	0.05~0.15	側銑 (Side milling)
DC0803	25	230	8800~9300	2000~2400	8	0.5	側銑 (Side milling)
DC0803	25	230	8800~9300	800~1200	8	1	側銑 (Side milling)
DC0803	25	230	8800~9300	800~1200	16	0.05~0.15	側銑 (Side milling)
DC0803	25	230	8800~9300	1400~1800	16	0.5	側銑 (Side milling)
DC1003	30	285	8800~9300	1000~1400	0.05~0.15	10	溝銑 (Slotting)
DC1003	30	285	8800~9300	2000~2400	0.5	10	溝銑 (Slotting)
DC1003	30	285	8800~9300	1000~1400	10	0.05~0.15	側銑 (Side milling)
DC1003	30	285	8800~9300	1600~2000	10	0.5~1	側銑 (Side milling)
DC1003	30	285	8800~9300	1000~1400	10	1.5~2	側銑 (Side milling)
DC1003	30	285	8800~9300	800~1200	20	0.05~0.15	側銑 (Side milling)
DC1003	30	285	8800~9300	600~1000	20	0.5~1	側銑 (Side milling)
DC1203	35	275	7000~7500	800~1200	0.05~0.15	12	溝銑 (Slotting)
DC1203	35	275	7000~7500	1600~2000	0.5	12	溝銑 (Slotting)
DC1203	35	275	7000~7500	1000~1400	12	0.05~0.15	側銑 (Side milling)
DC1203	35	275	7000~7500	1600~2000	12	0.5	側銑 (Side milling)
DC1203	35	275	7000~7500	1200~1600	12	1~1.5	側銑 (Side milling)
DC1203	35	275	7000~7500	800~1200	24	0.05~0.15	側銑 (Side milling)
DC1203	35	275	7000~7500	800~1200	24	1~1.5	側銑 (Side milling)

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DC1603	55	265	5000~5500	600~1000	0.05~0.15	16	溝銑 (Slotting)
DC1603	55	265	5000~5500	1000~1400	0.5	16	溝銑 (Slotting)
DC1603	55	265	5000~5500	600~1000	16	0.05~0.15	側銑 (Side milling)
DC1603	55	265	5000~5500	1000~1400	16	0.5	側銑 (Side milling)
DC1603	55	265	5000~5500	400~800	32	0.05~0.15	側銑 (Side milling)
DC1603	55	265	5000~5500	300~700	32	0.5	側銑 (Side milling)