AUE 切削條件表 P408 Cutting Condition

AUEL 切削條件表 P409 Cutting Condition

High Feed U-Type For Aluminum - 3 flutes

■ 3刃超高速鋁用立銑刀

600 Nano

50°

- Micro Grain Carbide
- WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm

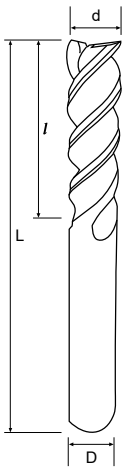


MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 刃徑	l 刃長	L 全長	D 柄徑	Z 刃數
AUE0253	2.5	8	50	6	3
AUE0303	3	9	50	6	3
AUE0403	4	12	50	6	3
AUE0503	5	15	50	6	3
AUE0603	6	18	50	6	3
AUE0803	8	20	60	8	3
AUE1003	10	30	75	10	3
AUE1203	12	32	75	12	3
AUE1603	16	45	100	16	3
AUE2003	20	45	100	20	3

Long Flute - 長刃

MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 刃徑	l 刃長	L 全長	D 柄徑	Z 刃數
AUEL0603	6	30	75	6	3
AUEL0803	8	40	100	8	3
AUEL1003	10	42	100	10	3
AUEL1203	12	52	100	12	3



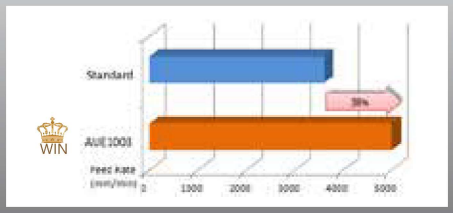


※Special U-Type design:
Material removal rate (MRR) and surface finishes are greatly improved due to effective chip removal at high rate

※Strong tooth with double relief angles:
Excellent production rates become 100% possible due to the Improvement of tooth hardness.

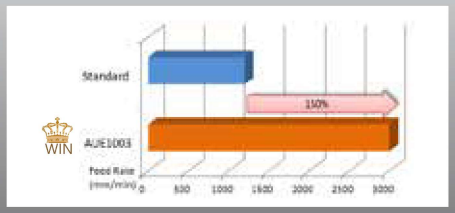
※Sharp aluminum alloy tooth design Applicable for roughing and finishing

Feed Rate Comparsion (Side Milling)



Work piece material: Aluminum alloy expanding material 6061
Speed: 15000 min-1, Depth of Cut: AP=2.0D, AE=0.5D

Feed Rate Comparsion (Slotting)



Work piece material: Aluminum alloy expanding material 6061
Speed: 10000 min-1, Depth of Cut: AP=2.0D, AE=1.0D

Application 適用材質：

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
							◎	★

Unit/單位: mm