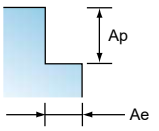
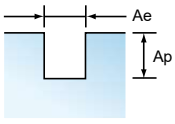
**AE5**
產 品 規格表 P156-157
Specification page

**AET**
產 品 規格表 P160-161
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## • AE5,AET 2T Series Side Milling 側銑切削

| Work Material 被削材 | COPPER,COPPER ALLOY 銅・銅合金 | | Aluminum alloy expanding material A7075 Aluminum alloy casting<Sil 13% 鋁合金 | |
|---|---|---|---|---|
| Max Cutting Speed(V) 最大切削速度(V) | 140m/min | | 380m/min | |
| Diameter 直徑 (mm) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) |
| 3 | 14,770 | 2,100 | 39,910 | 6,380 |
| 4 | 11,080 | 1,580 | 29,940 | 4,790 |
| 5 | 8,860 | 1,260 | 23,950 | 3,830 |
| 6 | 7,380 | 1,060 | 19,960 | 3,190 |
| 8 | 5,550 | 790 | 15,000 | 2,400 |
| 10 | 4,430 | 630 | 11,980 | 1,920 |
| 12 | 3,690 | 530 | 9,980 | 1,600 |
| 16 | 2,770 | 400 | 7,490 | 1,200 |
| 20 | 2,220 | 320 | 5,980 | 960 |
| 25 | 1,780 | 260 | 4,790 | 770 |
| Depth of cut 切削基準量 (D=直徑Dia) | *Side milling（側銑） Ap=2.0D Ae=0.5D | | | |
| | V線速度 | 140 | V線速度 | 380 |
| | Z刃數 | 2 | Z刃數 | 2 |
| | Fz | 0.07 | Fz | 0.08 |

## • AE5,AET 2T Series Slotting 溝銑切削

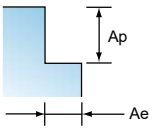
| Work Material 被削材 | COPPER,COPPER ALLOY 銅・銅合金 | | Aluminum alloy expanding material A7075 Aluminum alloy casting<Sil 13% 鋁合金 | |
|---|---|---|---|---|
| Max Cutting Speed(V) 最大切削速度(V) | 90m/min | | 310m/min | |
| Diameter 直徑 (mm) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) |
| 3 | 9,740 | 700 | 32,910 | 2630 |
| 4 | 7,300 | 520 | 24,680 | 1970 |
| 5 | 5,850 | 420 | 19,750 | 1580 |
| 6 | 4,870 | 350 | 16,450 | 1320 |
| 8 | 3,660 | 260 | 12,340 | 990 |
| 10 | 2,960 | 210 | 9,870 | 790 |
| 12 | 2,440 | 180 | 8,230 | 660 |
| 16 | 1,820 | 130 | 6,170 | 490 |
| 20 | 1,460 | 100 | 4,940 | 400 |
| 25 | 1,170 | 90 | 3,950 | 320 |
| Depth of cut 切削基準量 (D=直徑Dia) | *Slotting（溝銑） Ap=2.0D Ae=1.0D | | | |
| | V線速度 | 90 | V線速度 | 310 |
| | Z刃數 | 2 | Z刃數 | 2 |
| | Fz | 0.04 | Fz | 0.04 |

Unit/單位: mm

**AEL5**
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**ALET**
產 品 規格表 P164
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## • AEL5,ALET 2T Series Side Milling 側銑切削

| Work Material 被削材 | COPPER,COPPER ALLOY 銅・銅合金 | | Aluminum alloy expanding material A7075<br>Aluminum alloy casting<Sil 13%<br>鋁合金 | |
|---|---|---|---|---|
| Max Cutting Speed(V) 最大切削速度(V) | 70m/min | | 190m/min | |
| Diameter 直徑 (mm) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) |
| 3 | 7,540 | 650 | 20,380 | 1,960 |
| 4 | 5,660 | 480 | 15,290 | 1,460 |
| 5 | 4,530 | 390 | 12,230 | 1,180 |
| 6 | 3,770 | 320 | 10,190 | 980 |
| 8 | 2,780 | 240 | 7,500 | 720 |
| 10 | 2,260 | 190 | 6,110 | 580 |
| 12 | 1,890 | 160 | 5,100 | 490 |
| 16 | 1,420 | 120 | 3,820 | 370 |
| 20 | 1,130 | 100 | 3,060 | 300 |
| 25 | 900 | 80 | 2,450 | 230 |
| Depth of cut 切削基準量 (D=直徑Dia) | *Side milling（側銑）<br><br><br>Ap=4.5D<br>Ae=0.05D | | | |
| | V線速度 | 70 | V線速度 | 190 |
| | Z刃數 | 2 | Z刃數 | 2 |
| | Fz | 0.04 | Fz | 0.05 |

1.When Slotting, reduce the feed by 60% from above values.
2.Length of overhang is 4 times dia. as standard. When it is longer then 4 times dia., follow figures of above table.
3. Recommend Oil-mist coolant or Air blow.
4.If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
5.Use a rigid machine and holder.

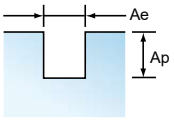
1. 溝加工時之進給速度，請設定為上述值之 60%。
2. 刀具夾持突出量以 4D 為基準，超出上述場合時，請將切削條件作適度之調整。
3. 請使用油霧 (Oil-mist) 冷卻或吹氣方式 (Air blow) 進行切削。
4. 機械設備或工件的夾持剛性不足、出現震動時，請以相同比例按上表降低回轉數及進給速度。
5. 請使用較具剛性之機械設備及夾頭。

Unit/單位: mm

**AEL5**
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**ALET**
產 品 規格表 P164
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## • AEL5,ALET 2T Series Slotting 溝銑切削

| Work Material 被削材 | COPPER,COPPER ALLOY 銅・銅合金 | | Aluminum alloy expanding material A7075 Aluminum alloy casting<Sil 13% 鋁合金 | |
|---|---|---|---|---|
| Max Cutting Speed(V) 最大切削速度(V) | 50m/min | | 160m/min | |
| Diameter 直徑 (mm) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) | Speed 迴轉數 ($min^{-1}$) | Feed Rate 進給速度 (mm/min) |
| 3 | 5,030 | 220 | 16,990 | 820 |
| 4 | 3,770 | 160 | 12,740 | 610 |
| 5 | 3,020 | 130 | 10,190 | 490 |
| 6 | 2,510 | 110 | 8,490 | 410 |
| 8 | 1,890 | 80 | 6,370 | 310 |
| 10 | 1,480 | 60 | 5,100 | 240 |
| 12 | 1,260 | 60 | 4,250 | 200 |
| 16 | 940 | 40 | 3,180 | 150 |
| 20 | 750 | 30 | 2,550 | 120 |
| 25 | 600 | 20 | 2,040 | 100 |
| Depth of cut 切削基準量 (D=直徑Dia) | *Slotting（溝銑）<br><br><br>Ap=2.0D<br>Ae=1.0D | | | |
| | V線速度 | 50 | V線速度 | 160 |
| | Z刃數 | 2 | Z刃數 | 2 |
| | Fz | 0.02 | Fz | 0.02 |

1.When Slotting, reduce the feed by 60% from above values.
2.Length of overhang is 4 times dia. as standard. When it is longer then 4 times dia., follow figures of above table.
3. Recommend Oil-mist coolant or Air blow.
4.If the rigidity of the machine or the work material installation is very low, or chattering is generated, please reduce the revolution and the feed rate proportionately.
5.Use a rigid machine and holder.

1. 溝加工時之進給速度，請設定為上述值之 60%。
2. 刀具夾持突出量以 4D 為基準，超出上述場合時，請將切削條件作適度之調整。
3. 請使用油霧 (Oil-mist) 冷卻或吹氣方式 (Air blow) 進行切削。
4. 機械設備或工件的夾持剛性不足、出現震動時，請以相同比例按上表降低回轉數及進給速度。
5. 請使用較具剛性之機械設備及夾頭。

Unit/單位: mm