

Soft Materials Cutting Series

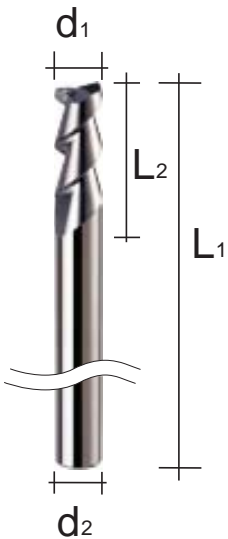
2 flutes Aluminum Square End Mills



鋁合金專用 2刃立銑刀 超微粒碳化鎢 軟金屬系列



型號 type No.	直徑(D1) Diameter	刃長(L2) Flute Length	全長(L1) O.A.L	柄徑(d2) Shank Dia
AE 0102	1.0	3	50	4
AE 0202	2.0	6	50	4
AE 0302	3.0	8	50	4
AE 0402	4.0	10	50	4
AE 0502	5.0	13	50	6
AE 0602	6.0	15	50	6
AE 0802	8.0	20	60	8
AE 1002	10.0	30	75	10
AE 1202	12.0	30	75	12
AE 1602	16.0	40	100	16
AE 2002	20.0	40	100	20



Recommended cutting condition for Square End Mills

Material	Aluminum 1070		Aluminum alloy 2014/4032/5052/6061/7075		Aluminum alloy AC85	
	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min	SPEED (mm-1)	FEED mm/min
DIAMETER 2	37000	2000(800)	16000	850(350)	20000	1100(450)
3	35000	2000(900)	14000	850(450)	18000	1100(550)
4	26000	2000(1100)	11000	850(550)	13000	1100(660)
5	21000	2000(1100)	9000	850(550)	10000	1100(660)
6	17000	2000(1100)	7000	850(550)	9000	1100(660)
8	13000	2000(1100)	5500	850(650)	7000	1100(800)
10	11000	2000(1300)	7000	850(650)	5500	1100(800)
12	8800	2000(1300)	3600	850(800)	4500	1100(800)
16	6500	2000(1100)	3000	850(550)	3500	1100(900)
20	5300	2000(1100)	2200	850(550)	2500	1100(650)

DEPTH OF CUT

