

Soft Materials Cutting Series

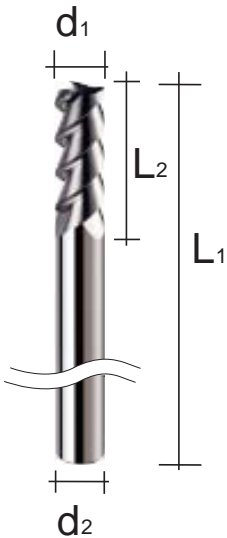
3 Flutes Aluminum Square End Mills



鋁合金專用 3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 0103	1.0	3	50	4
AE 0203	2.0	6	50	4
AE 0303	3.0	8	50	4
AE 0403	4.0	10	50	4
AE 0503	5.0	13	50	6
AE 0603	6.0	15	50	6
AE 0803	8.0	20	60	8
AE 1003	10.0	30	75	10
AE 1203	12.0	30	75	12
AE 1603	16.0	40	100	16
AE 2003	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	2400(950)	16000	1000(380)	20000	1300(500)
3	35000	2400(1050)	14000	1000(500)	18000	1300(600)
4	26000	2400(1200)	11000	1000(600)	13000	1300(720)
5	21000	2400(1200)	9000	1000(600)	10000	1300(720)
6	17000	2400(1200)	7000	1000(600)	9000	1300(720)
8	13000	2400(1200)	5500	1000(700)	7000	1300(880)
10	11000	2400(1400)	7000	1000(700)	5500	1300(880)
12	8800	2400(1400)	3600	1000(880)	4500	1300(880)
16	6500	2400(1200)	3000	1000(600)	3500	1300(1000)
20	5300	2400(1200)	2200	1000(600)	2500	1300(700)

DEPTH OF CUT

