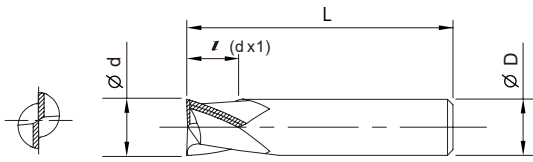


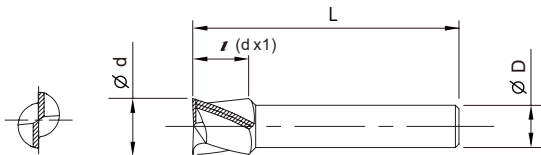
## Aluminum Application for Turning & Machine Center - 2 Flutes 車銑複合機用鋁用立銑刀 - 2刃



切削條件表 **P184**  
Cutting Condition



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flute	Coating	
型號	d 刃徑	z 刃長	L 全長	D 柄徑	z 刃數		TB
TSAE0202	2	2	40	6	2	.00	TB
TSAE0252	2.5	2.5	40	6	2	.00	TB
TSAE0302	3	3	40	6	2	.00	TB
TSAE0402	4	4	40	6	2	.00	TB
TSAE0502	5	5	40	6	2	.00	TB
TSAE0602	6	6	40	6	2	.00	TB
TSAE0802	8	8	40	8	2	.00	TB
TSAE1002	10	10	45	10	2	.00	TB



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flute	Coating	
型號	d 刃徑	z 刃長	L 全長	D 柄徑	z 刃數		TB
TAE0702	7	7	40	6	2	.00	TB
TAE0802	8	8	40	6	2	.00	TB
TAE1002	10	10	45	6	2	.00	TB
TAE1202	12	12	50	10	2	.00	TB
TAE1602	16	16	60	10	2	.00	TB

Application 適用材質：


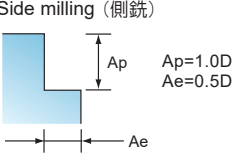

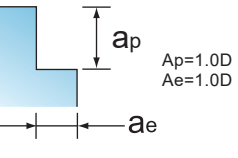
★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳

Coating 塗層	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	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
										○	◎

**TSAE/TAE 2 Flutes Series**  
**TSAE/TAE 2 刃 系列**

Side Milling 	COPPER, COPPER ALLOY 銅 · 銅合金		Aluminum alloy expanding material A7075 Aluminum alloy casting <Si13% 鋁合金	
	140m/min		380m/min	
Max Cutting Speed(V) 最大切削速度(V)	140m/min		380m/min	
Diameter 直徑 (mm)	Speed 迴轉數 (min <sup>-1</sup> )	Feed Rate 進給速度 (mm/min)	Speed 迴轉數 (min <sup>-1</sup> )	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 	*Side milling (側銑) Ap=1.0D 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
Slotting 	COPPER, COPPER ALLOY 銅 · 銅合金		Aluminum alloy expanding material A7075 Aluminum alloy casting <Si13% 鋁合金	
	90m/min		310m/min	
Max Cutting Speed(V) 最大切削速度(V)	90m/min		310m/min	
Diameter 直徑 (mm)	Speed 迴轉數 (min <sup>-1</sup> )	Feed Rate 進給速度 (mm/min)	Speed 迴轉數 (min <sup>-1</sup> )	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) 	ap=1.0D 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