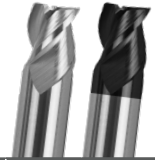
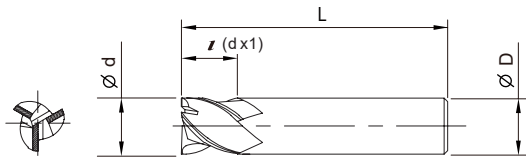


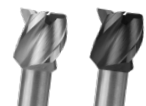
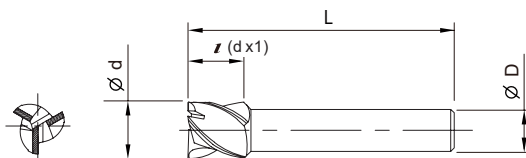
# Aluminum Application for Turning & Machine Center - 3 Flutes 車銑複合機用鋁用立銑刀 - 3刃



切削條件表 **P185**  
Cutting Condition



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flute	Coating	
型號	d 刃徑	l 刃長	L 全長	D 柄徑	z 刃數		TB
TSAE0203	2	2	40	6	3	.00	TB
TSAE0253	2.5	2.5	40	6	3	.00	TB
TSAE0303	3	3	40	6	3	.00	TB
TSAE0403	4	4	40	6	3	.00	TB
TSAE0503	5	5	40	6	3	.00	TB
TSAE0603	6	6	40	6	3	.00	TB
TSAE0803	8	8	40	8	3	.00	TB
TSAE1003	10	10	45	10	3	.00	TB



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flute	Coating	
型號	d 刃徑	l 刃長	L 全長	D 柄徑	z 刃數		TB
TAE0703	7	7	40	6	3	.00	TB
TAE0803	8	8	40	6	3	.00	TB
TAE1003	10	10	45	6	3	.00	TB
TAE1203	12	12	50	10	3	.00	TB
TAE1603	16	16	60	10	3	.00	TB

Application 適用材質：

★ Perfect 最推薦

◎ Excellent 適合

○ Good 佳


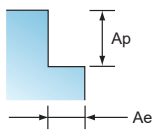

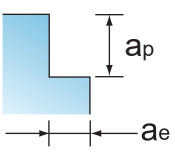
Coating 塗層	Carbon steel, Alloy steel 炭素鋼, 合金鋼	Pre-hardened steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium alloy 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金, 銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
										○	◎
										○	◎

## TSAE/TAE 3 Flutes Series TSAE/TAE 3 刃 系列

TSAE/TAE

產品規格表 **P26**

Specification page

Side Milling 	COPPER, COPPER ALLOY 銅 · 銅合金		Aluminum alloy expanding material A7075 Aluminum alloy casting<Si13% 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 <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	3,160	39,910	9,580
4	11,080	2,370	29,940	7,180
5	8,860	1,900	23,950	5,750
6	7,380	1,580	19,960	4,790
8	5,550	1,190	15,000	3,600
10	4,430	940	11,980	2,870
12	3,690	790	9,980	2,390
16	2,770	590	7,490	1,800
20	2,220	470	5,980	1,440
25	1,780	380	4,790	1,150
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	3	Z刃數	3
	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	
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	1,040	32,910	3950
4	7,300	780	24,680	2960
5	5,850	620	19,750	2370
6	4,870	520	16,450	1970
8	3,660	390	12,340	1480
10	2,960	320	9,870	1180
12	2,440	260	8,230	990
16	1,820	190	6,170	740
20	1,460	150	4,940	590
25	1,170	130	3,950	470
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	3	Z刃數	3
	Fz	0.04	Fz	0.04