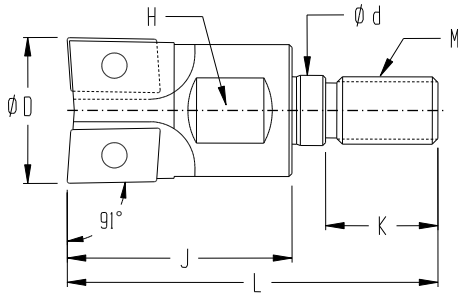


91° 端銑刀 (接合式&直柄)

END MILLING CUTTER (91°)



規格 SPECIFICATION	φD	J	φd	L	M	K	H	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
AEM13AD09M06	13	20	6.5	35	M6	11	9	ADKT0903PDER	IS255535	T 8	1
AEM17AD09M08	17	30	8.5	50	M8	15	12		IS250635		2
AEM21AD09M10	21	35	10.5	56	M10	15	15				
AEM26AP16M12	26	40	12.5	66	M12	20	21	APMT1604PDER	IS401055	T15	2
AEM33AP16M16	33	40	17	68	M16	22	27		IS401155		3
AEM40AP16M22	40	40	25	75	M22	25	35				



規格 SPECIFICATION	φD	J	φd	L	刀片規格 INSERTS	刀片螺絲 INSERT SCREW	板手 WRENCH	刃數 NO. OF INSERT
AEM13AD09ST12	13	-	12	120	ADKT0903PDER	IS255535	T8	1
AEM17AD09ST16	17	30	16	150		IS250635		2
AEM21AD09ST20	21	35	20	165				
AEM26AP16ST25	26	40	25	185	APMT1604PDER	IS401055	T 15	2
AEM33AP16ST32	33	40	32	210		IS401155		3
AEM40AP16ST32	40	130	32	210				

建議切削條件一覽表

Recommended Cutting Conditions

工件材質 Workpiece Material	Roughing 粗加工			Semi-Finishing 中加工			Finishing 精加工		
	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)	速度 Speed Vc (m/min)	每刃進給 Feed (mm/tooth)	切削深度 D.O.C (mm)
	Unalloyed steels 一般碳鋼	180 - 220	0.14 - 0.25	4.5 ↑	220 - 260	0.12 - 0.30	2.0 - 4.5	220 - 300	0.08 - 0.35
Alloyed steels 合金鋼	70 - 110	0.12 - 0.20	4.5 ↑	100 - 150	0.10 - 0.25	2.0 - 4.5	100 - 195	0.08 - 0.30	0.2 - 2.0
Stainless steels 不鏽鋼	100 - 160	0.10 - 0.20	4.5 ↑	140 - 180	0.08 - 0.20	2.0 - 4.5	180 - 230	0.05 - 0.25	0.2 - 2.0
Cast Irons 鑄鐵	140 - 280	0.10 - 0.15	4.5 ↑	180 - 300	0.10 - 0.20	2.0 - 4.5	200 - 350	0.05 - 0.25	0.2 - 2.0
Non-ferrous metal 鋁, 銅, 鎂等非鐵金屬	275 - 450	0.05 - 0.20	4.5 ↑	400 - 750	0.05 - 0.20	2.0 - 4.5	700 - 1000	0.05 - 0.25	0.2 - 2.0