

AUE

切削
條件表 **P408**
Cutting Condition

AUEL

切削
條件表 **P409**
Cutting Condition



High Feed U-Type For Aluminum - 3 flutes

■ 3刃超高速鋁用立銑刀



● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm

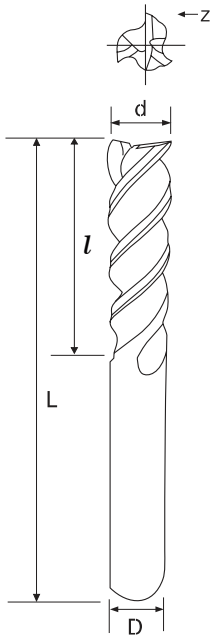


MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 刃徑	ℓ 刃長	L 全長	D 柄徑	Z 刃數
AUE0253	2.5	8	50	6	3
AUE0303	3	9	50	6	3
AUE0403	4	12	50	6	3
AUE0503	5	15	50	6	3
AUE0603	6	18	50	6	3
AUE0803	8	20	60	8	3
AUE1003	10	30	75	10	3
AUE1203	12	32	75	12	3
AUE1603	16	45	100	16	3
AUE2003	20	45	100	20	3

- HRC ▶ 40
- HRC ▶ 45
- HRC ▶ 50
- HRC ▶ 55
- HRC ▶ 60
- HRC ▶ 65
-
-
-
-
-
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-
-

Long Flute - 長刃

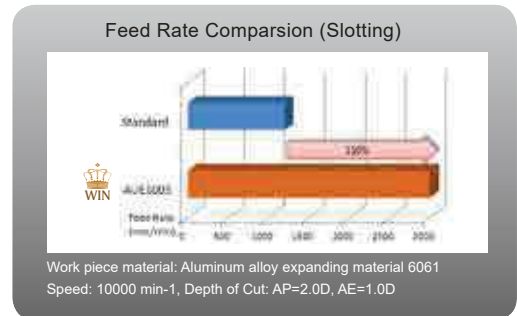
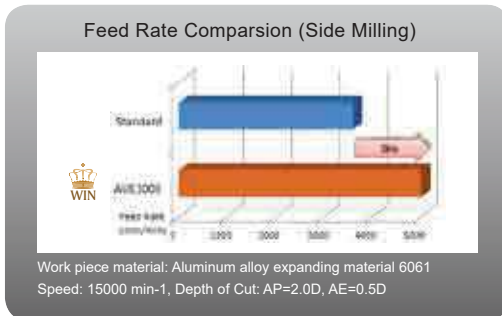
MODE	Diameter	Flute Length	Full Length	Shank Diameter	Flutes
型號	d 刃徑	ℓ 刃長	L 全長	D 柄徑	Z 刃數
AUEL0603	6	30	75	6	3
AUEL0803	8	40	100	8	3
AUEL1003	10	42	100	10	3
AUEL1203	12	52	100	12	3



※ Special U-Type design:
Material removal rate (MRR) and surface finishes are greatly improved due to effective chip removal at high rate

※ Strong tooth with double relief angles:
Excellent production rates become 100% possible due to the Improvement of tooth hardness.

※ Sharp aluminum alloy tooth design Applicable for roughing and finishing



Application 適用材質 :

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

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	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC			
							◎	★

Work Material

Aluminum alloy expanding material A7075
Aluminum alloy casting<Sil 13%

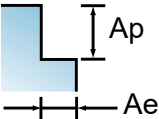
Copper

Slotting

Max Cutting Speed(V)

240m/min

87m/min

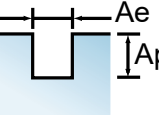
TYPE NO.	Diameter (mm)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)
AUE0603	6	12,500	4,150	4,650	2,000
AUE0803	8	9,400	3,150	3,500	1,520
AUE1003	10	7,500	2,500	2,800	1,200
AUE1203	12	6,250	2,100	2,300	1,000
Depth of cut (D=Dia)	$A_p=2.0D$ $A_e=0.5D$ 	V	235.5	V	87.92
		Z	3	Z	3
		Fz	0.11	Fz	0.10

Side Milling

Max Cutting Speed(V)

250m/min

90m/min

TYPE NO.	Diameter (mm)	Speed (min ⁻¹)	Feed Rate (mm/min)	Speed (min ⁻¹)	Feed Rate (mm/min)
AUE0603	6	12,000	4,000	4,960	1,350
AUE0803	8	10,000	3,040	3,680	1,050
AUE1003	10	8,000	2,400	2,960	850
AUE1203	12	6,660	2,000	2,480	700
Depth of cut (D=Dia)	$A_p=1.5D$ $A_e=1.0D$ 	V	251.2	V	92.944
		Z	3	Z	3
		Fz	0.10	Fz	0.14