

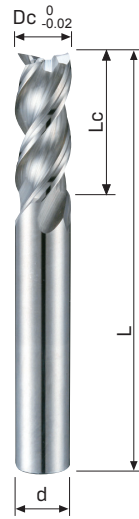
## E143 超微粒鎢鋼強力鋁用立銑刀

## End Mills For Aluminium

**MG Carbide**  
**Uncoated Bright**



### Type of Operation



Code No. E143-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	Bright E143
1	3	50	4	●
1.5	5	50	4	●
2	6	50	4	●
2.5	8	50	4	●
3	8	50	6	●
4	11	50	6	●
5	13	50	6	●
6	16	50	6	●
8	20	60	8	●
10	25	72	10	●
12	30	75	12	●
14	35	100	16	●
16	40	100	16	●
18	40	100	20	●
20	40	100	20	●

### Work Material

P	H	M	K	N	S
				●	

N	鋁 Aluminium
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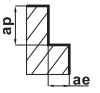
### Feature of product:

3刃鋁合金用立銑刀  
 刀口鋒利且高移除率刀形幾何設計  
 及細緻抗沾黏性。  
 刀口精磨細緻度高。  
 切削後表面粗糙度良好。  
 適用於粗、精切削應用於各種鋁合  
 金。


## E143 切削條件參考表

## Recommended Milling Conditions

## Side Milling 側面切削

被削材 Work Material		GR.10 鋁 Aluminium	
切削速度 Vc m/min		400	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E143-1	1	63,000	1,890
E143-1.5	1.5	50,000	1,500
E143-2	2	45,000	1,755
E143-2.5	2.5	42,000	1,800
E143-3	3	42,000	1,900
E143-4	4	31,000	2,200
E143-5	5	25,000	2,200
E143-6	6	21,000	2,400
E143-7	7	18,500	2,400
E143-8	8	16,000	2,600
E143-9	9	14,500	2,800
E143-10	10	12,700	3,000
E143-12	12	10,600	3,200
E143-14	14	9,100	3,200
E143-16	16	8,000	3,200
E143-18	18	7,000	3,100
E143-20	20	6,300	3,100
切入深度 (mm)		ap:1.5D	
		ae:0.1D	

## Slotting 溝切削

被削材 Work Material		GR.10 鋁 Aluminium	
切削速度 Vc m/min		400	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E143-1	1	63,000	1,320
E143-1.5	1.5	50,000	1,050
E143-2	2	45,000	1,230
E143-2.5	2.5	42,000	1,260
E143-3	3	42,000	1,340
E143-4	4	31,000	1,400
E143-5	5	25,000	1,480
E143-6	6	21,000	1,640
E143-7	7	18,500	1,640
E143-8	8	16,000	1,720
E143-9	9	14,500	1,800
E143-10	10	12,700	1,940
E143-12	12	10,600	2,100
E143-14	14	9,100	2,100
E143-16	16	7,900	2,100
E143-18	18	7,000	2,100
E143-20	20	6,300	2,100
切入深度 (mm)		0.5D	

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.

1. 請使用剛性好、精度高的設備和夾具。
2. 請選擇適用於工件材料的切削液。
3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
5. 切削加工時如果發生振顫，請降低切削條件。