

E145 超微粒鎢鋼強力鋁用立銑刀

End Mills For Aluminium

MG Carbide
Uncoated Bright



Type of Operation



Work Material

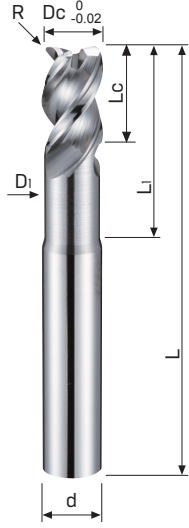
P	H	M	K	N	S
				●	

N 鋁
Aluminium

N 銅
Copper

N 石墨
Graphite

Feature of product:
 3刃短刃長頸鋁合金用R角立銑刀
 刀口鋒利且高移除率刀形幾何設計及細緻抗沾黏性。
 刃口精磨細緻度高。
 切削後表面粗糙度良好。
 刀尖部R值可有效提升壽命。
 適用於粗、精切削應用於各種鋁合金。



Code No. E145-Dc×R

Dc 0 -0.02	R ±0.01	Lc mm	L mm	d h6	L1 mm	D1 mm	Bright E145
3	—	4.5	50	6	9	2.8	●
3	R0.1	4.5	50	6	9	2.8	●
3	R0.2	4.5	50	6	9	2.8	●
3	R0.3	4.5	50	6	9	2.8	●
3	R0.5	4.5	50	6	9	2.8	●
4	—	6	50	6	12	3.7	●
4	R0.1	6	50	6	12	3.7	●
4	R0.2	6	50	6	12	3.7	●
4	R0.3	6	50	6	12	3.7	●
4	R0.5	6	50	6	12	3.7	●
5	—	7.5	60	6	15	4.6	●
5	R0.1	7.5	60	6	15	4.6	●
5	R0.2	7.5	60	6	15	4.6	●
5	R0.3	7.5	60	6	15	4.6	●
5	R0.5	7.5	60	6	15	4.6	●
6	—	9	60	6	18	5.5	●
6	R0.2	9	60	6	18	5.5	●
6	R0.3	9	60	6	18	5.5	●
6	R0.5	9	60	6	18	5.5	●
6	R0.8	9	60	6	18	5.5	●
6	R1.2	9	60	6	18	5.5	●
6	R1.5	9	60	6	18	5.5	●
6	R1.6	9	60	6	18	5.5	●
6	R2	9	60	6	18	5.5	●
8	—	12	70	8	24	7.3	●
8	R0.2	12	70	8	24	7.3	●
8	R0.3	12	70	8	24	7.3	●
8	R0.5	12	70	8	24	7.3	●
8	R0.8	12	70	8	24	7.3	●
8	R1	12	70	8	24	7.3	●
8	R1.2	12	70	8	24	7.3	●
8	R1.5	12	70	8	24	7.3	●
8	R1.6	12	70	8	24	7.3	●
8	R2	12	70	8	24	7.3	●
8	R3	12	70	8	24	7.3	●
10	—	15	80	10	30	9.2	●
10	R0.2	15	80	10	30	9.2	●
10	R0.3	15	80	10	30	9.2	●
10	R0.5	15	80	10	30	9.2	●
10	R0.8	15	80	10	30	9.2	●
10	R1	15	80	10	30	9.2	●
10	R1.2	15	80	10	30	9.2	●
10	R1.5	15	80	10	30	9.2	●
10	R1.6	15	80	10	30	9.2	●
10	R2	15	80	10	30	9.2	●
10	R3	15	80	10	30	9.2	●
12	—	18	90	12	36	11	●
12	R0.2	18	90	12	36	11	●
12	R0.3	18	90	12	36	11	●
12	R0.5	18	90	12	36	11	●
12	R0.8	18	90	12	36	11	●
12	R1	18	90	12	36	11	●
12	R1.2	18	90	12	36	11	●
12	R1.5	18	90	12	36	11	●
12	R1.6	18	90	12	36	11	●
12	R2	18	90	12	36	11	●
12	R3	18	90	12	36	11	●
16	—	24	110	16	48	14.5	●
16	R0.5	24	110	16	48	14.5	●
16	R1	24	110	16	48	14.5	●
16	R2	24	110	16	48	14.5	●
16	R3	24	110	16	48	14.5	●
16	R4	24	110	16	48	14.5	●
20	—	30	125	20	60	18.2	●
20	R0.5	30	125	20	60	18.2	●
20	R1	30	125	20	60	18.2	●
20	R2	30	125	20	60	18.2	●
20	R3	30	125	20	60	18.2	●
20	R4	30	125	20	60	18.2	●

E145 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)
E145-3	3	42,000	1,900
E145-4	4	31,000	2,200
E145-5	5	25,000	2,200
E145-6	6	21,000	2,400
E145-8	8	16,000	2,600
E145-10	10	12,700	3,000
E145-12	12	10,600	3,200
E145-16	16	8,000	3,200
E145-20	20	6,300	3,100
切入深度 (mm)		ap:0.75D	
		ae:0.3D	

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)
E145-3	3	42,000	1,340
E145-4	4	31,000	1,400
E145-5	5	25,000	1,480
E145-6	6	21,000	1,640
E145-8	8	16,000	1,720
E145-10	10	12,700	1,940
E145-12	12	10,600	2,100
E145-16	16	7,900	2,100
E145-20	20	6,300	2,100
切入深度 (mm)		0.75D	

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。