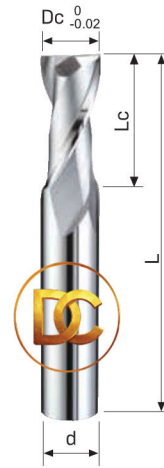


Code No. E132-Dc

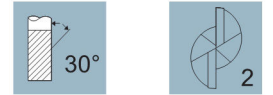
Dc 0 -0.02	Lc mm	L mm	d h6	Blank E132
1.0	3	50	4	●
1.5	5	50	4	●
2.0	6	50	4	●
2.5	8	50	4	●
3.0	8	50	6	●
4.0	11	50	6	●
5.0	13	50	6	●
6.0	16	50	6	●
8.0	20	60	8	●
10.0	22	72	10	●
12.0	26	75	12	●



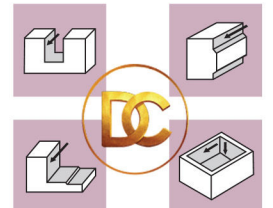
Aluminium

P	H	M	K	N	S
				●	

MG Carbide	Uncoated Blank
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Type of Operation

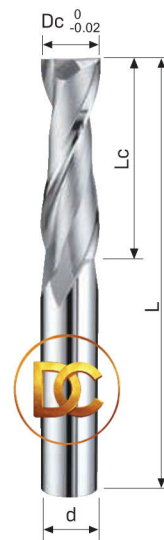


Work Material

P	GR1	碳鋼 Carbon Steel	
	GR2	低合金鋼鐵<24HRC Low-alloyed Steel	
	GR3	高合金鋼鐵<30HRC Hi-alloyed Steel	
H	GR4	硬化鋼 30-38HRC Hardened Steel	
	GR5	硬化鋼 38-48HRC Hardened Steel	
	GR6	硬化鋼 48-56HRC Hardened Steel	
	GR7	硬化鋼 56-68HRC Hardened Steel	
M	GR8	不銹鋼 Stainless Steel	
K	GR9	鑄鐵 Cast Iron	
N	GR10	鋁 Aluminium	●
	GR11	銅 Copper	○
	GR12	塑膠 Plastics	
	GR13	複合材料 FRP CFRP Composite Material	
S	GR14	石墨 Graphite	
	GR15	鈦合金 Titanium	
	GR16	鎳 Nickel	
	GR17	耐熱鋼 Heat-resistant Steel	

Code No. E134-Dc

Dc 0 -0.02	Lc mm	L mm	d h6	Blank E134
3	12	50	6	●
4	17	50	6	●
5	20	60	6	●
6	20	60	6	●
8	28	70	8	●
10	34	80	10	●
12	40	90	12	●





Slotting 溝切削

被削材 Work Material		GR.10 鋁 Aluminium	
切削速度 Vc m/min		100	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/min)
E132-1	1	31,500	200
E132-1.5	1.5	21,000	200
E132-2	2	15,500	200
E132-2.5	2.5	13,000	250
E132/E134-3	3	10,500	300
E132/E134-4	4	8,000	300
E132/E134-5	5	6,350	300
E132/E134-6	6	5,300	300
E132/E134-8	8	4,000	300
E132/E134-10	10	3,200	300
E132/E134-12	12	2,650	300
切入深度 (mm)		ap:1.0D	

※ Notice: E134 is Long Length series End Mills. Please adjust the parameter according.

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.

※ 注意E134為加長柄系列銑刀，請按照適當的伸長度調整刀具的參數。

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。

