



# ALOSTAR 無橫向拉紋鋁用銑刀系列

ALOSTAR series-End mill for Aluminum  
(For high glossy and no lateral scratch surface demand)

# ALOSTAR



## 特點

### SPECIAL FEATURES

採用雙刀刃設計，去屑快，加工鋁件更俐落!!

Dual blades shape design, remove aluminum chips faster than normal type.

獨有的拋光刃口與平整的刀刃，完全實現加工無橫向拉痕。

Unique polished process leads the work piece with no lateral marks milling result.

專為表面要求高光亮的鋁件加工所設計。

Designed for all aluminum work piece with better surface demand.

粗精加工

皆可

## 實績測試

### Benchmark test:

### AL10 - SEM3100

機台 Machine: CAMPRO- By Coolant

工件 Work Piece: ALUMINUM -6061 (HRC 25)

轉速 Spindle Speed: 7600 RPM

進給 Feed Rate: 1000 mm/min

單刃切削量 Feed Rate Per tooth: 0.05mm

深度 Depth: 1.5D

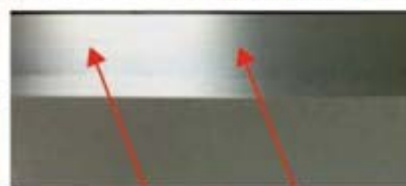
寬度 Width: 0.1mm

切削方式 Milling Method: 側銑Side milling

### Lateral scratch Testing result

#### 橫向拉痕測試

ALOSTAR - NO SCRATCH Work piece OTHER BRAND - WITH SCRATCH



Scratch mark

### AL10 - SEM3100

機台 Machine: CAMPRO- By Coolant

工件 Work Piece: ALUMINUM -6061 (HRC 25)

轉速 Spindle Speed: 9000 RPM

進給 Feed Rate: 3500 mm/min

單刃切削量 Feed Rate Per tooth: 0.05mm

深度 Depth: 2D

寬度 Width: 4mm

切削方式 Milling Method: 溝側銑Slot / Side milling

### LIFE TIME Test

ALOSTAR

OTHER BRAND

#### AL10 - SEM3100



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## 規格表

編號 (Number)	外徑 (D)	刃長 (H)	刃數 (T)	柄徑 (d)	全長 (L)
AL04-SEM 3020	2	6	3	4	50
AL04-SEM 3030	3	9	3	4	50
AL04-SEM 3040	4	12	3	4	50
AL06-SEM 3020	2	6	3	6	50
AL06-SEM 3030	3	9	3	6	50
AL06-SEM 3040	4	12	3	6	50
AL06-SEM 3050	5	15	3	6	50
AL06-SEM 3060	6	18	3	6	50
AL08-SEM 3080	8	24	3	8	60
AL10-SEM 3100	10	30	3	10	75
AL12-SEM 3120	12	36	3	12	75
AL16-SEM 3160	16	50	3	16	100
AL20-SEM 3200	20	55	3	20	110

## 切削條件表

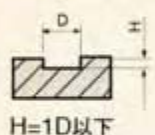
### Recommended Milling Conditions

Cutting Conditions 切削條件	ULTRA micro grain carbide used for ALOSTAR End mills 粉末微粒碳化鎢 3刃立銑刀 ALOSTAR	Cutting Materials 被切削材	Aluminum 鋁合金 -all the Aluminum type	The hardness of the material cut 被切削材 硬度	HRC20-30
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立銑刀刃徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min	立銑刀刃徑 mm	轉速-spindle speed RPM	進給-feed rate mm/min
D3.0	10500	1200	D3.0	10500	1200
D4.0	8000	1100	D4.0	8000	1100
D5.0	9500	1700	D5.0	9500	1700
D6.0	9500	1700	D6.0	9500	1700
D8.0	8000	2300	D8.0	8000	2300
D10.0	8000	2800	D10.0	8000	2800
D12.0	6600	2400	D12.0	6600	2400
D16.0	5000	1800	D16.0	5000	1800
D20.0	4000	1400	D20.0	4000	1400

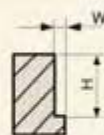
最大切削量 / Max Cutting Range.

Slot Milling- below 1D depth.



H=1D以下

最大切削量 / Max Cutting Range.



Depth= H is within 2D  
W= 0.2D