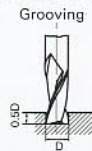


## Standard Milling Conditions

### ● VICTORY Mills 2 Flutes

Work Materials Milling Condition Dia. of Mill (mm)	Rolled Steels Carbon Steels SS, SC		Alloy Steels Pre-Hardened Steels SCM, NAK, HPM		Mold Steels Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminum Alloys Copper Alloys	
	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min
2	6400	150	4800	110	4000	68	3200	45	7200	420	14000	720
3	4200	160	3200	110	2700	72	2100	49	4800	440	9000	760
5	2500	160	1900	110	1600	69	1300	47	2900	430	5400	740
6	2100	160	1600	110	1300	71	1100	49	2400	440	4500	760
8	1600	160	1200	110	1000	70	800	49	1800	440	3400	760
10	1300	170	960	110	800	72	640	49	1400	450	2700	770
12	1100	160	800	110	660	71	530	49	1200	440	2300	760
15	850	160	640	110	530	71	420	49	960	440	1800	760
20	640	150	480	100	400	67	320	46	720	410	1400	720
25	510	120	380	80	320	50	250	35	570	320	1100	550
30	420	95	320	65	270	40	210	30	480	250	900	440

D: Dia. of Mill



Side Milling



1. In dry milling(recommend air blow), reduce the rotation and feed to 70% of table values.
2. Adjust milling condition when unusual vibration, different sound occur by cutting.

### ● VICTORY Mills 4 Flutes

Work Materials Milling Condition Dia. of Mill (mm)	Rolled Steels Carbon Steels SS, SC		Alloy Steels Pre-Hardened Steels SCM, NAK, HPM		Mold Steels Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminum Alloys Copper Alloys	
	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min	Rotation min <sup>-1</sup>	Feed mm/min
3	4200	200	3200	140	2700	86	2100	61	4800	550	9000	950
5	2500	200	1900	140	1600	88	1300	59	2900	550	5400	920
6	2100	200	1600	140	1300	88	1100	61	2400	550	4500	950
8	1600	200	1200	140	1000	90	800	60	1800	550	3400	950
10	1300	210	960	140	800	89	640	62	1400	560	2700	970
12	1100	200	800	140	660	89	530	61	1200	550	2300	950
15	850	200	640	140	530	84	420	61	960	550	1800	950
20	640	190	480	130	400	84	320	57	720	520	1400	890
25	510	150	380	100	320	65	250	45	570	400	1100	690
30	420	120	320	80	270	50	210	35	480	320	900	550

D: Dia. of Mill

Side Milling



1. In dry milling(recommend air blow), reduce the rotation and feed to 70% of table values.
2. Adjust milling condition when unusual vibration, different sound occur by cutting.