

# VICTORY MILL Series

High efficiency milling by HSS with TiAlN coating

## Standard Milling Conditions

### ● VICTORY Mills 2 Flutes Long

Work Materials Milling Condition	Structural Steels Carbon Steels SS, SC		Alloy Steels Pre-Hardened Steels SCM, NAK, HPM		Mold Steels Stainless Steels SKD, SUS		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminum Alloys Copper Alloys Nonferrous Alloys	
	Dia. of Mill (mm)	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>
3	4200	80	3200	55	2700	35	2100	25	4800	220	9000	380
5	2500	80	1900	55	1600	35	1300	25	2900	220	5400	380
6	2100	80	1600	55	1300	35	1100	25	2400	220	4500	380
8	1600	80	1200	55	1000	35	800	25	1800	220	3400	380
10	1300	80	960	55	800	35	640	25	1400	220	2700	390
12	1100	80	800	55	660	35	530	25	1200	220	2300	380
15	850	80	640	55	530	35	420	25	960	220	1800	380
20	640	75	480	50	400	30	320	25	720	210	1400	360

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.

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	Dia. of Mill (mm)	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>
3	4200	110	3200	75	2700	45	2100	33	4800	290	9000	510
5	2500	110	1900	75	1600	45	1300	33	2900	290	5400	490
6	2100	110	1600	75	1300	45	1100	33	2400	290	4500	500
8	1600	110	1200	75	1000	45	800	33	1800	290	3400	500
10	1300	110	960	75	800	45	640	33	1400	300	2700	510
12	1100	110	800	75	660	45	530	33	1200	290	2300	510
15	850	110	640	75	530	45	420	33	960	290	1800	510
20	640	100	480	70	400	45	320	30	720	280	1400	480
25	510	80	380	55	320	35	250	25	570	210	1100	370
30	420	65	320	40	270	25	210	20	480	170	900	290

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Side Milling



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