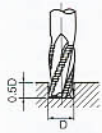


Standard Milling Conditions

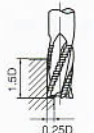
● VICTORY Mills HEAVY

| Work Materials Milling Condition | 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 Nonferrous Alloys | |
|-------------------------------------|--|-------------------------------|--|-------------------------------|---------------------------------|-------------------------------|----------------------------------|-------------------------------|-----------------------|-------------------------------|---|-------------------------------|
| | Dia. of Mill (mm) | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ |
| 3 | 5000 | 290 | 3800 | 190 | 3200 | 130 | 2500 | 90 | 5800 | 770 | 10800 | 1320 |
| 5 | 3000 | 290 | 2300 | 190 | 1900 | 130 | 1600 | 90 | 3500 | 770 | 6500 | 1320 |
| 6 | 2500 | 290 | 1900 | 190 | 1600 | 130 | 1300 | 90 | 2900 | 790 | 5400 | 1320 |
| 8 | 1900 | 290 | 1400 | 190 | 1200 | 130 | 1000 | 90 | 2200 | 790 | 4100 | 1320 |
| 10 | 1500 | 300 | 1200 | 200 | 1000 | 130 | 800 | 90 | 1700 | 800 | 3200 | 1320 |
| 12 | 1250 | 290 | 1000 | 200 | 800 | 130 | 600 | 90 | 1400 | 790 | 2800 | 1320 |
| 15 | 1000 | 290 | 800 | 200 | 600 | 130 | 500 | 90 | 1200 | 790 | 2200 | 1320 |
| 20 | 750 | 260 | 600 | 180 | 500 | 120 | 400 | 80 | 900 | 740 | 1700 | 1320 |
| 25 | 600 | 220 | 500 | 150 | 400 | 90 | 300 | 60 | 700 | 580 | 1300 | 980 |
| 30 | 500 | 200 | 400 | 120 | 300 | 80 | 250 | 50 | 600 | 510 | 1100 | 860 |

D: Dia. of Mill
Grooving



Side Milling

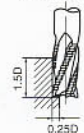


1. In dry milling (recommend air blow), reduce the rotation and feed to 70% of table values.
2. Adjust milling condition when unusual vibration, different sound occur by cutting.

● VICTORY Mills HEAVY Long

| Work Materials Milling Condition | 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 Nonferrous Alloys | |
|-------------------------------------|--|-------------------------------|--|-------------------------------|---------------------------------|-------------------------------|----------------------------------|-------------------------------|-----------------------|-------------------------------|---|-------------------------------|
| | Dia. of Mill (mm) | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ | Feed mm/min | Rotation min ⁻¹ |
| 3 | 5000 | 180 | 3800 | 120 | 3200 | 80 | 2500 | 50 | 5800 | 470 | 10800 | 840 |
| 5 | 3000 | 180 | 2300 | 120 | 1900 | 80 | 1600 | 50 | 3500 | 470 | 6500 | 840 |
| 6 | 2500 | 180 | 1900 | 120 | 1600 | 80 | 1300 | 50 | 2900 | 480 | 5400 | 840 |
| 8 | 1900 | 180 | 1400 | 120 | 1200 | 80 | 1000 | 50 | 2200 | 480 | 4100 | 840 |
| 10 | 1500 | 180 | 1200 | 120 | 1000 | 80 | 800 | 50 | 1700 | 490 | 3200 | 840 |
| 12 | 1250 | 180 | 1000 | 120 | 800 | 80 | 600 | 50 | 1400 | 480 | 2800 | 840 |
| 15 | 1000 | 180 | 800 | 120 | 600 | 80 | 500 | 50 | 1200 | 480 | 2200 | 800 |
| 20 | 750 | 160 | 600 | 110 | 500 | 70 | 400 | 50 | 900 | 460 | 1700 | 700 |
| 25 | 600 | 140 | 500 | 100 | 400 | 60 | 300 | 40 | 700 | 350 | 1300 | 600 |
| 30 | 500 | 120 | 400 | 90 | 300 | 60 | 250 | 40 | 600 | 300 | 1100 | 560 |

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.