B

Cutting Conditions

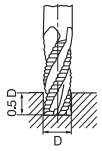
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• VICTORY Mills HEAVY L6408

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels Carbon Steels SS, SC		Alloy Steels, Pre-Hardended Steels SCM, NAK, HPM		Mold Steels Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminium Alloys Copper Alloys Nonferous Alloys	
	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}	Feed mm/min
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

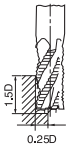


• VICTORY Mills HEAVY Long L6410

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels Carbon Steels SS, SC		Alloy Steels, Pre-Hardended Steels SCM, NAK, HPM		Mold Steels Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminium Alloys Copper Alloys Nonferous Alloys	
	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}	Feed mm/min
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	480	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	840
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



K catalog