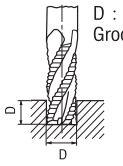
Cutting Conditions

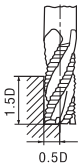
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• VICTORY Mills Roughing Medium L6412

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
6	2100	180	1600	120	1300	75	1100	50	2400	220	4500	800
8	1600	200	1200	130	1000	80	800	55	1800	240	3400	900
10	1300	200	960	130	800	80	640	59	1400	240	2700	900
12	1100	200	800	130	660	86	530	59	1200	240	2300	920
15	850	200	640	130	530	86	420	59	960	240	1800	920
20	640	180	480	120	400	81	320	55	720	240	1400	890
25	510	190	380	130	320	85	250	58	570	260	1100	950
30	420	170	320	120	270	76	210	52	480	240	900	860
40	320	110	240	76	200	49	160	34	360	150	680	560
50	250	71	190	48	160	31	130	21	290	100	540	350



D : Dia. of Mill
Grooving

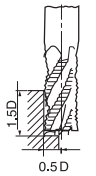


Side Milling

L6412

• VICTORY MILLS ROUGHING LONG L6414

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
6	2100	130	1600	90	1300	60	1100	40	2400	170	4500	650
8	1600	150	1200	100	1000	65	800	45	1800	180	3400	700
10	1300	150	960	100	800	65	640	45	1400	180	2700	700
12	1100	150	800	100	660	65	530	45	1200	180	2300	700
15	850	150	640	100	530	66	420	45	960	180	1800	700
20	640	140	480	95	400	61	320	42	720	180	1400	670
25	510	150	380	98	320	64	250	44	570	200	1100	710
30	420	130	320	88	270	57	210	39	480	180	900	650
40	320	85	240	57	200	37	160	25	360	120	680	420
50	250	53	190	36	160	23	130	16	290	73	540	260



D : Dia. of Mill
Side Milling

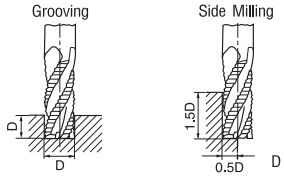
• VICTORY MILLS ROUGHING SHORT L6482

Work Material / Milling Condition / Dia. of Mill mm	Rolled Steels SS Carbon Steels S C		Alloy Steels SCM Pre-Hardended Steels		Mold Steels Stainless Steels		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Aluminium Aluminium Alloys Copper 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
6	2100	230	1600	150	1300	100	1100	70	2400	290	4500	1100
8	1600	230	1200	150	1000	100	800	68	1800	280	3400	1100
10	1300	230	960	160	800	100	640	70	1400	290	2700	1100
12	1100	280	800	190	660	120	530	84	1200	340	2300	1300
15	850	280	640	190	530	120	420	84	960	340	1800	1300
20	640	260	480	180	400	110	320	78	720	340	1400	1300
25	510	290	380	200	320	130	250	87	570	390	1100	1400
30	420	260	320	180	270	110	210	78	480	360	900	1300

1) When dry milling, reduce the rotation and feed to 70% of table values.
2) Adjust milling condition when an unusual vibration, different sound Occur by cutting.

New Introduction

1.5 times longer tool life than
conventional coated End Mills
ทนทานกว่าดอกเอ็นมิลล์ HSS-Co ปกติ มากกว่า 1.5 เท่า



D : Dia of Mill

Features

- Compound Multi-layered TiAlN coating.
- Designed for high-speed milling and long tool life.
- Excellent cost-performance.