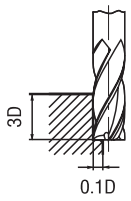
Cutting Conditions
Standard Milling Conditions
VICTORY Mills 4 Flutes Long L6418

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Work Material / Milling Condition / Dia. of Mill mm	Structural Steels, Carbon Steels SS, S C		Alloy Steels, Pre Hardened Steels SCM, NAK, HPM		Mold Steels Stainless Steels SKD, SUS		Nickel Alloys Titanium Alloys		Cast Irons FC, FCD		Alumium Alloys Copper Alloys Nonferrous 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	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

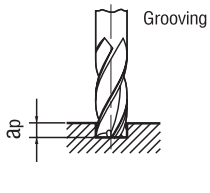


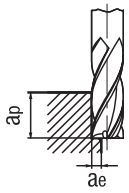
D : Dia. of Mill
Side Milling

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.

GSSLT / GS MILL SLOT L9432
• Side Milling & Grooving

Work Material / Milling Condition / Dia. of Mill mm		SS, S C Structural Steels, Carbon Steels (150~250HB)		FC, FCD Cast Irons		SCM, NAK, HPM Alloy Steels, Pre Hardened Steels (25~35HRC)		Hardened Steels (45~50HRC)		Stainless Steels (SUS304, 316)		Nickle Alloys, Titanium Alloys, (20~45HRC)	
		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
4		6000	500	6000	500	5800	350	3600	190	3300	130	2000	70
6		4600	580	4600	580	4300	390	2500	200	2200	140	1400	80
8		3400	580	3400	580	3200	390	1850	200	1600	140	1000	80
10		2800	590	2800	590	2600	390	1500	200	1300	140	800	80
12		2300	590	2300	590	2200	400	1250	200	1100	140	700	80
16		1700	470	1700	470	1600	380	900	190	800	130	500	70
Side Milling	ap	1.5D						1.0D		1.5D		1.0D	
	ae	0.1D						0.05D		0.1D		0.05D	
Grooving	ap	1D						0.2D		0.3D		0.2D	





1. Use highly rigid machining center.
2. Use in wet condition in case of Stainless Steels, Nickel Alloys, Titanium Alloys.

• Slotting

Work Material / Milling Condition / Dia. of Mill mm	SS, S C Structural Steels, Carbon Steels (150~250HB)		FC, FCD Cast Irons		SCM, NAK, HPM Alloy Steels, Pre Hardened Steels (25~35HRC)		Hardened Steels (45~50HRC)		Stainless Steels (SUS304, 316)		Nickle Alloys, Titanium Alloys, (20~45HRC)	
	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
4	4000	150	4000	150	2400	90	2000	60	2400	70	1600	40
6	2700	150	2700	150	1600	90	1300	60	1600	70	1100	40
8	2000	140	2000	140	1200	90	1000	60	1200	70	800	40
10	1600	130	1600	130	1000	80	800	50	1000	60	640	40
12	1300	110	1300	110	800	70	660	40	800	50	530	30
16	1000	100	1000	100	600	70	500	40	600	50	400	30

1. Use highly rigid machining center.
2. Use in wet condition in case of Stainless Steels, Nickel Alloys, Titanium Alloys.
3. Drilling condition assumes use in thin sheet or #30 taper spidle machining center.