

## List of recommended milling conditions for **VRV**

Work Material	HRC40-80		HRC48-55		HRC55-65	
Velocity	V=160m/min		V=140m/min		V=110m/min	
DIAMETER	SPEED (mm <sup>-1</sup> )	FEED (mm/mim)	SPEED (mm <sup>-1</sup> )	FEED (mm/mim)	SPEED (mm <sup>-1</sup> )	FEED (mm/mim)
6	8500	5100	7400	4450	5800	3000
8	6400	4400	5580	3800	4400	2600
10	5100	3800	4450	3350	3500	2300
12	4250	3450	3700	3000	2900	2100
16	3200	3200	2800	2800	2200	2200
D : Diameter	Side Milling 					