Series 4V05 • VariMill I • Victory Grades

WIDIA VICTORY

Material Group		Side Milling (A) and Slotting (B)			WP15PE			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.											
		A		B	Cutting Speed — vc SFM				D1 — Diameter										
								frac.	1/8	3/16	1/4	5/16	7/16	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	dec.	.1250	.1875	.2500	.3125	.4375	.3750	.5000	.6250	.7500	1.0000	1.2500
P	0	1.5 x D	0.5 x D	1 x D	490	–	660	IPT	.0009	.0013	.0018	.0023	.0031	.0027	.0034	.0039	.0044	.0049	.0049
	1	1.5 x D	0.5 x D	1 x D	490	–	660	IPT	.0009	.0013	.0018	.0023	.0031	.0027	.0034	.0039	.0044	.0049	.0049
	2	1.5 x D	0.5 x D	1 x D	460	–	620	IPT	.0009	.0013	.0018	.0023	.0031	.0027	.0034	.0039	.0044	.0049	.0049
	3	1.5 x D	0.5 x D	1 x D	390	–	520	IPT	.0007	.0011	.0015	.0020	.0026	.0023	.0029	.0034	.0039	.0045	.0048
	4	1.5 x D	0.5 x D	0.75 x D	300	–	490	IPT	.0007	.0010	.0014	.0017	.0023	.0020	.0026	.0030	.0034	.0039	.0040
	5	1.5 x D	0.5 x D	1 x D	200	–	330	IPT	.0006	.0009	.0012	.0016	.0021	.0018	.0023	.0027	.0031	.0036	.0039
	6	1.5 x D	0.5 x D	0.75 x D	160	–	250	IPT	.0005	.0008	.0010	.0013	.0017	.0015	.0019	.0022	.0025	.0028	.0029
M	1	1.5 x D	0.5 x D	1 x D	300	–	380	IPT	.0007	.0011	.0015	.0020	.0026	.0023	.0029	.0034	.0039	.0045	.0048
	2	1.5 x D	0.5 x D	1 x D	200	–	260	IPT	.0006	.0009	.0012	.0016	.0021	.0018	.0023	.0027	.0031	.0036	.0039
	3	1.5 x D	0.5 x D	1 x D	200	–	230	IPT	.0005	.0008	.0010	.0013	.0017	.0015	.0019	.0022	.0025	.0028	.0029
K	1	1.5 x D	0.5 x D	1 x D	390	–	490	IPT	.0009	.0013	.0018	.0023	.0031	.0027	.0034	.0039	.0044	.0049	.0049
	2	1.5 x D	0.5 x D	1 x D	360	–	460	IPT	.0007	.0011	.0015	.0020	.0026	.0023	.0029	.0034	.0039	.0045	.0048
	3	1.5 x D	0.5 x D	1 x D	360	–	430	IPT	.0006	.0009	.0012	.0016	.0021	.0018	.0023	.0027	.0031	.0036	.0039
S	1	1.5 x D	0.3 x D	0.3 x D	160	–	300	IPT	.0007	.0011	.0015	.0020	.0026	.0023	.0029	.0034	.0039	.0045	.0048
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0014	.0012	.0015	.0018	.0021	.0024	.0026
	3	1.5 x D	0.5 x D	1 x D	200	–	260	IPT	.0006	.0009	.0012	.0016	.0021	.0018	.0023	.0027	.0031	.0036	.0039
	4	1.5 x D	0.5 x D	1 x D	160	–	200	IPT	.0005	.0008	.0011	.0014	.0019	.0017	.0021	.0025	.0028	.0033	.0036
H	1	1.5 x D	0.5 x D	0.75 x D	260	–	460	IPT	.0007	.0010	.0014	.0017	.0023	.0020	.0026	.0030	.0034	.0039	.0040
	2	1.5 D	0.2 x D	0.5 x D	230	–	390	IPT	.0005	.0008	.0010	.0013	.0017	.0015	.0019	.0022	.0025	.0028	.0029

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.