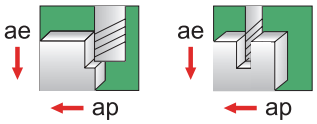
GARR TOOL Milling Guide for V4 End Mills in Titanium, Inconel, and Stainless

Metric

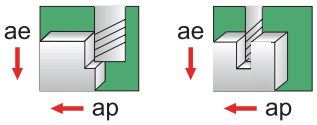
	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)
	SMM = 30 - 60	SMM = 15 - 30	SMM = 30 - 70
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)
4.0 - 7.0	.010 - .020	.005 - .008	.010 - .025
7.0 - 8.0	.012 - .025	.010 - .020	.015 - .030
8.0 - 10.0	.015 - .030	.012 - .025	.020 - .040
10.0 - 13.0	.020 - .040	.015 - .030	.025 - .045
13.0 - 16.0	.025 - .045	.020 - .040	.030 - .050
16.0 - 19.0	.030 - .050	.025 - .045	.035 - .055
19.0 - 22.0	.035 - .055	.030 - .050	.045 - .065
22.0 - 25.0	.045 - .065	.035 - .055	.055 - .075

	Profiling Side Cutting	Slotting Pocket Milling
Axial (ae)	1xD	100% of Dia.
Radial (ap)	100% of Dia.	1xD



	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)
	SMM = 45 - 75	SMM = 20 - 40	SMM = 45 - 90
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)
4.0 - 7.0	.020 - .030	.010 - .020	.020 - .030
7.0 - 8.0	.025 - .040	.013 - .025	.025 - .045
8.0 - 10.0	.030 - .045	.018 - .030	.030 - .050
10.0 - 13.0	.030 - .050	.020 - .040	.035 - .055
13.0 - 16.0	.035 - .060	.025 - .045	.045 - .075
16.0 - 19.0	.045 - .075	.030 - .050	.050 - .080
19.0 - 22.0	.050 - .080	.035 - .055	.055 - .095
22.0 - 25.0	.060 - .090	.045 - .065	.065 - .105

	Profiling Side Cutting	Slotting Pocket Milling
Axial (ae)	1xD	50% of Dia.
Radial (ap)	50% of Dia.	1xD



NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.