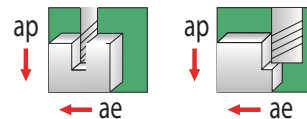


# GARR TOOL Milling Guide for ARC Series 3-Flute Rougher

ISO Material	SFM (Vc)	CHIPLOAD PER TOOTH (Fz)								
		3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	
<b>S</b>	<b>TITANIUM ALLOYS</b>									
	Titanium: 6AL4V, CP	150 - 250	.0005" - .0008"	.0007" - .0010"	.0008" - .0013"	.0012" - .0018"	.0015" - .0023"	.0018" - .0028"	.0020" - .0035"	.0025" - .0045"
<b>N</b>	<b>NON-FERROUS</b>									
	Aluminum	700 - 1000	.0010" - .0020"	.0015" - .0025"	.0020" - .0030"	.0025" - .0035"	.0030" - .0040"	.0040" - .0050"	.0050" - .0060"	.0060" - .0070"
	Copper, Brass, Bronze	300 - 500	.0008" - .0013"	.0012" - .0018"	.0015" - .0023"	.0018" - .0028"	.0020" - .0035"	.0025" - .0045"	.0030" - .0050"	.0040" - .0060"

ISO Material	M/Min. (Vc)	CHIPLOAD PER TOOTH (Fz)								
		4.0mm	6.0mm	8.0mm	10.0mm	12.0mm	16.0mm	20.0mm	25.0mm	
<b>S</b>	<b>TITANIUM ALLOYS</b>									
	Titanium: 6AL4V, CP	40 - 80	.010 - .020	.015 - .025	.020 - .035	.025 - .050	.035 - .055	.045 - .075	.050 - .090	.060 - .115
<b>N</b>	<b>NON-FERROUS</b>									
	Aluminum	200 - 350	.025 - .050	.040 - .065	.050 - .075	.060 - .090	.075 - .100	.100 - .125	.125 - .150	.150 - .180
	Copper, Brass, Bronze	80 - 150	.020 - .035	.025 - .050	.035 - .055	.045 - .075	.050 - .090	.060 - .115	.075 - .125	.100 - .150

	Slotting	Profiling
Axial (ap)	1xD	2xD
Radial (ae)	1xD	0.5xD



**ARC SERIES TOOLS ARE NOT DESIGNED FOR OVER 28Rc MATERIALS**

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