

GARR TOOL Application Guide for VRX Series End Mills

Fractional

Material	Rc	SFM (Vc)	CHIPLOAD PER FLUTE Recommendations (Fz)									*Profiling	Slotting
			1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	Radial	Axial
Stainless Steel: 303		290-375	.0004"-.0008"	.0008"-.0010"	.0010"-.0015"	.0013"-.0020"	.0015"-.0020"	.0020"-.0030"	.0025"-.0035"	.0030"-.0040"	.0035"-.0045"	1 x D	1 x D
Stainless Steel: 304, 316, 400 Series, Kovar, Invar		250-300	.0003"-.0006"	.0006"-.0010"	.0008"-.0015"	.0010"-.0020"	.0012"-.0020"	.0015"-.0020"	.0020"-.0025"	.0025"-.0030"	.0025"-.0035"	1 x D	1 x D
Stainless Steel: 304L, 316L, 8620, 17/4, 15/5, 13/8, PH Mat'l	< 35	250-300	.0003"-.0006"	.0006"-.0008"	.0007"-.0010"	.0010"-.0015"	.0015"-.0020"	.0015"-.0025"	.0020"-.0030"	.0025"-.0035"	.0030"-.0040"	1 x D	1 x D
	> 35	200-250	.0003"-.0006"	.0006"-.0008"	.0007"-.0010"	.0008"-.0010"	.0010"-.0015"	.0010"-.0020"	.0015"-.0025"	.0020"-.0030"	.0020"-.0030"	0.5 x D	0.5 x D
High Temperature Alloys: Inconel 625/718, A286	< 35	125-175	.0004"-.0008"	.0008"-.0010"	.0010"-.0015"	.0012"-.0020"	.0020"-.0025"	.0025"-.0030"	.0030"-.0035"	.0030"-.0035"	.0030"-.0040"	0.5 x D	0.3 x D
	> 35	80-100	.0003"-.0006"	.0007"-.0010"	.0008"-.0010"	.0010"-.0015"	.0010"-.0015"	.0010"-.0015"	.0012"-.0020"	.0015"-.0025"	.0015"-.0025"	0.2 x D	0.2 x D
Titanium: 6AL4V, CP		150-200	.0004"-.0008"	.0008"-.0010"	.0010"-.0015"	.0010"-.0020"	.0015"-.0020"	.0020"-.0030"	.0025"-.0030"	.0030"-.0035"	.0030"-.0040"	1 x D	1 x D
Carbon Steels: 1000 Series	< 35	400-600	.0004"-.0008"	.0008"-.0010"	.0010"-.0015"	.0010"-.0020"	.0015"-.0020"	.0020"-.0030"	.0025"-.0035"	.0030"-.0040"	.0035"-.0045"	0.3 x D	0.5 x D
	> 35	275-425	.0003"-.0006"	.0006"-.0008"	.0008"-.0012"	.0010"-.0015"	.0010"-.0020"	.0015"-.0025"	.0020"-.0025"	.0020"-.0030"	.0025"-.0035"	0.3 x D	0.5 x D
High Strength Tool Steel: 4130, 4140, A2, D2, P20, H13	< 30	250-400	.0003"-.0006"	.0006"-.0010"	.0008"-.0015"	.0010"-.0020"	.0012"-.0020"	.0015"-.0022"	.0020"-.0025"	.0025"-.0030"	.0025"-.0035"	0.5 x D	0.5 x D
	30-38	250-400	.0003"-.0006"	.0006"-.0008"	.0007"-.0010"	.0008"-.0010"	.0010"-.0015"	.0010"-.0020"	.0015"-.0025"	.0020"-.0030"	.0020"-.0030"	0.3 x D	0.5 x D
	> 38	(SEE HIGH ROCKWELL CHART - PAGE 268)											
Gray Cast Iron		400-500	.0005"-.0010"	.0010"-.0020"	.0010"-.0020"	.0015"-.0020"	.0015"-.0025"	.0020"-.0035"	.0025"-.0035"	.0030"-.0040"	.0040"-.0050"	1 x D	1 x D

Metric

Material	Rc	M/Min. (Vc)	CHIPLOAD PER FLUTE - Metric Recommendations (Fz)									*Profiling	Slotting
			3.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0	Radial	Axial
Stainless Steel: 303		90-115	.010-.020	.020-.025	.025-.038	.033-.050	.038-.050	.050-.076	.063-.089	.076-.102	.089-.114	1 x D	1 x D
Stainless Steel: 304, 316, 400 Series, Kovar, Invar		75-90	.008-.015	.015-.025	.020-.038	.025-.050	.030-.050	.038-.050	.050-.063	.063-.076	.063-.089	1 x D	1 x D
Stainless Steel: 304L, 316L, 17/4, 15/5, 13/8, PH Materials	< 35	75-85	.008-.015	.015-.020	.018-.025	.025-.038	.038-.050	.038-.063	.050-.076	.063-.089	.076-.102	1 x D	1 x D
	> 35	60-75	.008-.015	.015-.020	.018-.025	.020-.025	.025-.038	.025-.050	.038-.063	.050-.076	.050-.076	0.5 x D	0.5 x D
High Temperature Alloys: Inconel 625/718, A286	< 35	40-55	.010-.020	.020-.025	.025-.038	.030-.050	.050-.063	.063-.076	.076-.089	.076-.089	.076-.102	0.5 x D	0.3 x D
	> 35	25-30	.008-.015	.018-.025	.020-.025	.025-.038	.025-.038	.025-.038	.030-.050	.038-.063	.038-.063	0.2 x D	0.2 x D
Titanium: 6AL4V, CP		45-60	.010-.020	.020-.025	.025-.038	.025-.050	.038-.050	.050-.076	.063-.076	.076-.089	.076-.102	1 x D	1 x D
Carbon Steels: 1000 Series	< 35	125-185	.010-.020	.020-.025	.025-.038	.025-.050	.038-.050	.050-.076	.063-.089	.076-.102	.089-.114	0.3 x D	0.5 x D
	> 35	85-130	.008-.015	.015-.020	.020-.030	.025-.038	.025-.050	.038-.063	.050-.063	.050-.076	.063-.089	0.3 x D	0.5 x D
High Strength Tool Steel: 4130, 4140, A2, D2, P20, H13	< 30	75-125	.008-.015	.015-.025	.020-.038	.025-.050	.030-.050	.038-.056	.050-.063	.063-.076	.063-.089	0.5 x D	0.5 x D
	30-38	75-125	.006-.015	.015-.020	.018-.025	.020-.025	.025-.038	.025-.050	.038-.063	.050-.076	.050-.076	0.3 x D	0.5 x D
	> 38	(SEE HIGH ROCKWELL CHART - PAGE 269)											
Gray Cast Iron		125-150	.013-.025	.025-.050	.025-.050	.038-.050	.038-.063	.050-.089	.063-.089	.076-.102	.102-.127	1 x D	1 x D

* For profiling, axial = 1xD

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