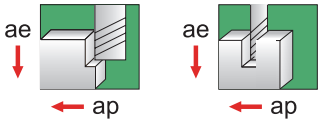
GARR TOOL Milling Guide for V4 End Mills in Titanium, Inconel, and Stainless

Fractional

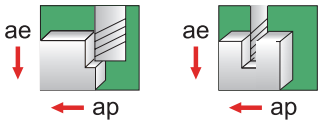
	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)	Carbon Steels
	SFM = 100 - 200	SFM = 50 - 100	SFM = 100 - 225	SFM = 250 - 400
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
.1575" - .2755"	.0004" - .0008"	.0003" - .0006"	.0005" - .0010"	.0008" - .0010"
.2756" - .3124"	.0005" - .0010"	.0004" - .0008"	.0007" - .0012"	.0010" - .0015"
.3125" - .3749"	.0007" - .0012"	.0005" - .0010"	.0008" - .0015"	.0012" - .0020"
.3750" - .4999"	.0008" - .0015"	.0007" - .0012"	.0010" - .0018"	.0013" - .0022"
.5000" - .6249"	.0010" - .0018"	.0008" - .0015"	.0012" - .0020"	.0015" - .0025"
.6250" - .7499"	.0012" - .0020"	.0010" - .0018"	.0015" - .0022"	.0018" - .0030"
.7500" - .8749"	.0015" - .0022"	.0012" - .0020"	.0018" - .0025"	.0022" - .0035"
.8750" - 1.000"	.0018" - .0025"	.0015" - .0022"	.0022" - .0030"	.0025" - .0040"

	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)	Carbon Steels
	SFM = 150 - 250	SFM = 60 - 125	SFM = 150 - 300	SFM = 300 - 450
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
.1575" - .2755"	.0008" - .0011"	.0004" - .0008"	.0008" - .0012"	.0010" - .0015"
.2756" - .3124"	.0010" - .0015"	.0005" - .0010"	.0010" - .0018"	.0012" - .0020"
.3125" - .3749"	.0012" - .0018"	.0007" - .0012"	.0012" - .0020"	.0015" - .0023"
.3750" - .4999"	.0012" - .0021"	.0008" - .0015"	.0015" - .0022"	.0018" - .0027"
.5000" - .6249"	.0015" - .0025"	.0010" - .0018"	.0018" - .0030"	.0020" - .0032"
.6250" - .7499"	.0018" - .0030"	.0012" - .0020"	.0020" - .0033"	.0025" - .0035"
.7500" - .8749"	.0020" - .0032"	.0015" - .0022"	.0023" - .0037"	.0030" - .0042"
.8750" - 1.000"	.0025" - .0035"	.0018" - .0025"	.0027" - .0040"	.0032" - .0050"

	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.

† *Metric equivalents are for reference only*