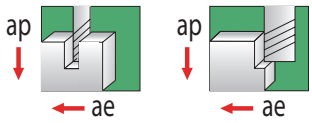
GARR TOOL Application Guide for ARC Series 3-Flute Roughers

Fractional

	Aluminum	Non-Ferrous (Copper, Brass, Bronze)	Titanium Alloys	Carbon Steels
	SFM = 700 - 1000	SFM = 300 - 500	SFM = 150 - 250	SFM = 200 - 300
Diameter	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
3/16"	.0010" - .0020"	.0008" - .0013"	.0005" - .0008"	.0008" - .0010"
1/4"	.0015" - .0025"	.0012" - .0018"	.0007" - .0010"	.0010" - .0015"
5/16"	.0020" - .0030"	.0015" - .0023"	.0008" - .0013"	.0012" - .0020"
3/8"	.0025" - .0035"	.0018" - .0028"	.0012" - .0018"	.0013" - .0022"
1/2"	.0030" - .0040"	.0020" - .0035"	.0015" - .0023"	.0015" - .0025"
5/8"	.0040" - .0050"	.0025" - .0045"	.0018" - .0028"	.0018" - .0030"
3/4"	.0050" - .0060"	.0030" - .0050"	.0020" - .0035"	.0022" - .0035"
1"	.0060" - .0070"	.0040" - .0060"	.0025" - .0045"	.0025" - .0040"

	SLOTTING	PROFILING
Axial (ap)	1xD	2xD
Radial (ae)	1xD	0.5xD



Metric

	Aluminum	Non-Ferrous (Copper, Brass, Bronze)	Titanium Alloys	Carbon Steels
	SMM = 200 - 350	SMM = 80 - 150	SMM = 40 - 80	SMM = 70 - 90
Diameter	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
4.0	.025 - .050	.020 - .035	.010 - .020	.020 - .025
6.0	.040 - .065	.025 - .050	.015 - .025	.025 - .040
8.0	.050 - .075	.035 - .055	.020 - .035	.025 - .050
10.0	.060 - .090	.045 - .075	.025 - .050	.025 - .060
12.0	.075 - .100	.050 - .090	.035 - .055	.035 - .060
16.0	.100 - .125	.060 - .115	.045 - .075	.050 - .075
20.0	.125 - .150	.075 - .125	.050 - .090	.050 - .090
25.0	.150 - .180	.100 - .150	.060 - .115	.060 - .100

ARC SERIES TOOLS ARE NOT DESIGNED FOR OVER 28Rc MATERIALS

CPT (Fz) = Chipload per flute

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