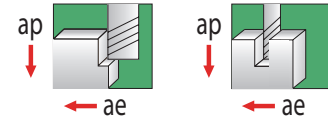


GARR TOOL Milling Guide for V4 Series End Mills

Fractional

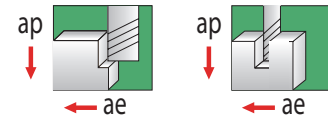
	Material Group S	Material Group M	Material Group S	Material Group P	Material Group K
	Nickel or Cobalt-based	Stainless	Titanium Alloys	Carbon Steels	Grey Cast Iron
	Inconel, Cobalt Chrome	Invar, 400, 316, pH Series	6Al4V	1000 Series	
	-	SFM = 100 - 225	SFM = 100 - 200	SFM = 250 - 400	SFM = 200 - 400
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
.1575" - .2755"	-	.0005" - .0010"	.0004" - .0008"	.0008" - .0020"	.0008" - .0020"
.2756" - .3124"	-	.0007" - .0012"	.0005" - .0010"	.0010" - .0020"	.0010" - .0020"
.3125" - .3749"	-	.0008" - .0015"	.0007" - .0012"	.0015" - .0025"	.0015" - .0025"
.3750" - .4999"	-	.0010" - .0018"	.0008" - .0015"	.0020" - .0030"	.0020" - .0030"
.5000" - .6249"	-	.0012" - .0020"	.0010" - .0018"	.0020" - .0030"	.0020" - .0030"
.6250" - .7499"	-	.0015" - .0022"	.0012" - .0020"	.0025" - .0030"	.0025" - .0030"
.7500" - .8749"	-	.0018" - .0025"	.0015" - .0022"	.0030" - .0035"	.0030" - .0035"
.8750" - 1.000"	-	.0022" - .0030"	.0018" - .0025"	.0035" - .0040"	.0035" - .0040"

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



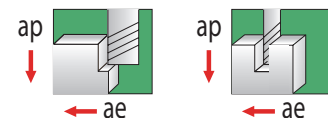
	Nickel or Cobalt-based	Stainless	Titanium Alloys	Carbon Steels	Grey Cast Iron
	SFM = 60 - 125	SFM = 150 - 300	SFM = 150 - 250	SFM = 300 - 500	SFM = 250 - 450
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
.1575" - .2755"	.0004" - .0008"	.0008" - .0012"	.0008" - .0011"	.0010" - .0025"	.0010" - .0025"
.2756" - .3124"	.0005" - .0010"	.0010" - .0018"	.0010" - .0015"	.0015" - .0030"	.0015" - .0030"
.3125" - .3749"	.0007" - .0012"	.0012" - .0020"	.0012" - .0018"	.0020" - .0035"	.0020" - .0035"
.3750" - .4999"	.0008" - .0015"	.0015" - .0022"	.0012" - .0021"	.0025" - .0040"	.0025" - .0040"
.5000" - .6249"	.0010" - .0018"	.0018" - .0030"	.0015" - .0025"	.0030" - .0040"	.0030" - .0040"
.6250" - .7499"	.0012" - .0020"	.0020" - .0033"	.0018" - .0030"	.0035" - .0040"	.0035" - .0040"
.7500" - .8749"	.0015" - .0022"	.0023" - .0037"	.0020" - .0032"	.0040" - .0045"	.0040" - .0045"
.8750" - 1.000"	.0018" - .0025"	.0027" - .0040"	.0025" - .0035"	.0045" - .0050"	.0045" - .0050"

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



	Nickel or Cobalt-based	Stainless	Titanium Alloys	Carbon Steels	Grey Cast Iron
	SFM = 100 - 200	SFM = 300 - 500	SFM = 200 - 400	SFM = 425 - 600	SFM = 325 - 500
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
.1575" - .2755"	.0008" - .0012"	.0010" - .0014"	.0010" - .0014"	.0016" - .0026"	.0016" - .0026"
.2756" - .3124"	.0008" - .0016"	.0012" - .0020"	.0012" - .0020"	.0018" - .0028"	.0018" - .0028"
.3125" - .3749"	.0010" - .0022"	.0014" - .0026"	.0014" - .0026"	.0020" - .0035"	.0020" - .0035"
.3750" - .4999"	.0012" - .0024"	.0020" - .0030"	.0020" - .0030"	.0030" - .0041"	.0030" - .0041"
.5000" - .6249"	.0014" - .0026"	.0026" - .0035"	.0026" - .0035"	.0033" - .0043"	.0033" - .0043"
.6250" - .7499"	.0016" - .0026"	.0028" - .0037"	.0028" - .0037"	.0037" - .0045"	.0037" - .0045"
.7500" - .8749"	.0018" - .0028"	.0030" - .0039"	.0030" - .0039"	.0041" - .0049"	.0041" - .0049"
.8750" - 1.000"	.0020" - .0030"	.0033" - .0049"	.0033" - .0049"	.0047" - .0059"	.0047" - .0059"

	Profiling Side Cutting	Slotting Pocket Milling
Axial (ap)	1xD	20% of Dia.
Radial (ae)	20% of Dia.	1xD



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