GARR TOOL Milling Guide for Die Mold Cutters

Roughing

TECHNICAL

(Reference series: 350MX)

	RF	PM	CHIPLOAD PER TOOTH (Fz)		
DIAMETER	40 - 50 HRC	50 - 60 HRC	40 - 50 HRC	50 - 60 HRC	
1/32"	20,000 - 40,000	20,000 - 40,000	.0005"0007"	.0004"0005"	
1/16"	20,000 - 40,000	20,000 - 40,000	.0010"0015"	.0008"0010"	
3/32"	20,000 - 32,000	20,000 - 30,000	.0015"0020"	.0010"0015"	
1/8"	18,000 - 24,000	15,000 - 20,000	.0020"0025"	.0015"0020"	
3/16"	12,000 - 16,000	10,000 - 14,000	.0030"0040"	.0020"0030"	
1/4"	9,000 - 12,000	7,500 - 10,000	.0040"0050"	.0025"0040"	
5/16"	7,000 - 10,000	6,000 - 8,500	.0050"0065"	.0035"0050"	
3/8"	6,000 - 8,000	5,000 - 7,000	.0060"0075"	.0045"0060"	
1/2"	4,500 - 6,000	4,000 - 5,500	.0080"0100"	.0055"0080"	
5/8"	3,500 - 5,000	3,000 - 4,500	.0090"0110"	.0065"0090"	
3/4"	3,000 - 4,000	2,500 - 3,500	.0100"0120"	.0075"0100"	
1"	2,300 - 3,000	2,000 - 2,500	.0110"0130"	.0085"0110"	

Semi-Finishing and Finishing

	RF	PM	CHIPLOAD PER TOOTH (Fz)		
DIAMETER	40 - 50 HRC	50 - 60 HRC	40 - 50 HRC	50 - 60 HRC	
1/32"	20,000 - 40,000	20,000 - 40,000	.0004"0005"	.0003"0004"	
1/16"	20,000 - 40,000	20,000 - 40,000	.0008"0010"	.0005"0008"	
3/32"	20,000 - 40,000	20,000 - 40,000	.0010"0015"	.0008"0012"	
1/8"	20,000 - 40,000	20,000 - 36,000	.0015"0020"	.0010"0015"	
3/16"	20,000 - 32,000	20,000 - 25,000	.0020"0030"	.0015"0020"	
1/4"	18,000 - 25,000	15,000 - 18,000	.0025"0040"	.0020"0030"	
5/16"	14,000 - 19,000	12,000 - 14,000	.0035"0050"	.0025"0040"	
3/8"	12,000 - 16,000	10,000 - 12,000	.0045"0060"	.0030"0045"	
1/2"	9,000 - 12,000	7,500 - 9,000	.0055"0080"	.0040"0060"	
5/8"	6,500 - 9,000	5,000 - 7,000	.0065"0090"	.0050"0070"	
3/4"	5,500 - 7,500	4,000 - 6,000	.0075"0100"	.0060"0080"	
1"	4,000 - 6,000	3,500 - 5,500	.0085"0110"	.0070"0090"	





Roughing		Semi-Finishing		Finishing	
Axial (ap)	15% - 25% of Dia.	Axial (ap)	5% - 8% of Dia.	Axial (ap)	1% - 3% of Dia.
Radial (ae)	20% - 30% of Dia.	Radial (ae)	2% - 5% of Dia.	Radial (ae)	.5% - 1% of Dia.

High pressure air is recommended for clearing chips away from the cut.

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



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