GARR TOOL Milling Guide for Drill Mills

* Chamfering *

	ISO Material	HRC	SFM (Vc)	CHIPLOAD PER TOOTH (Fz)							
			154M, 154MA 152M, 152MA	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"
S	**COBALT BASE ALLOYS**										
	Powdered Metal, Stellite, Hs-21, Haynes 25/188, X-40, L-605	< 40 > 40	60 - 90 50 - 80	.0004" - .0008" .0003" - .0006"	.0004" - .0008" .0003" - .0006"	.0005" - .0010" .0003" - .0008"	.0008" - .0015" .0005" - .0010"	.0010" - .0018" .0008" - .0015"	.0015" - .0030" .0010" - .0015"	.0020" - .0030" .0015" - .0025"	.0025" - .0035" .0015" - .0020"
	NICKEL BASE ALLOYS										
	Invar, Kovar, Inconel-625/718, Waspaloy, Rene, Hastelloy, A286	< 40 > 40	55 - 90 45 - 80	.0004" - .0008" .0003" - .0006"	.0004" - .0008" .0003" - .0006"	.0005" - .0010" .0003" - .0008"	.0008" - .0015" .0005" - .0010"	.0010" - .0018" .0008" - .0015"	.0015" - .0030" .0010" - .0015"	.0020" - .0030" .0015" - .0025"	.0025" - .0035" .0015" - .0020"
	IRON BASE ALLOYS										
	Incoloy 800-802, Multimet N-155, Timkin 16-25-6, Carpenter 22-b3	< 40 > 40	55 - 90 50 - 80	.0004" - .0008" .0003" - .0006"	.0004" - .0008" .0003" - .0006"	.0005" - .0010" .0003" - .0008"	.0008" - .0015" .0005" - .0010"	.0010" - .0018" .0008" - .0015"	.0015" - .0030" .0010" - .0015"	.0020" - .0030" .0015" - .0025"	.0025" - .0035" .0015" - .0020"
	MONEL										
	Monel - 65% Nickel		50 - 80	.0003" - .0008"	.0005" - .0012"	.0005" - .0012"	.0008" - .0015"	.0010" - .0015"	.0013" - .0020"	.0018" - .0025"	.0025" - .0035"
	TITANIUM ALLOYS										
	Commercially Pure, 6Al-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si		100 - 150	.0003" - .0008"	.0005" - .0012"	.0005" - .0012"	.0008" - .0015"	.0010" - .0015"	.0013" - .0020"	.0018" - .0025"	.0025" - .0035"
	5553 / Beta Titanium		90 - 120	.0003" - .0008"	.0004" - .0010"	.0004" - .0010"	.0005" - .0012"	.0008" - .0014"	.0010" - .0016"	.0010" - .0020"	.0015" - .0025"
M	**STAINLESS STEELS**										
	13/8, 15/5, 17-4, pH Types	< 40 > 40	100 - 150 80 - 100	.0003" - .0006" .0002" - .0004"	.0003" - .0007" .0002" - .0006"	.0006" - .0009" .0003" - .0007"	.0008" - .0012" .0004" - .0008"	.0013" - .0018" .0007" - .0012"	.0010" - .0020" .0008" - .0015"	.0012" - .0025" .0010" - .0016"	.0012" - .0020" .0013" - .0017"
	200 Series, 300 Series	< 40 > 40	150 - 225 125 - 220	.0002" - .0006" .0003" - .0005"	.0005" - .0008" .0003" - .0007"	.0008" - .0015" .0005" - .0010"	.0010" - .0018" .0008" - .0012"	.0010" - .0018" .0009" - .0015"	.0015" - .0025" .0013" - .0018"	.0018" - .0028" .0013" - .0018"	.0022" - .0032" .0017" - .0025"
	304L, 316L, Nitronic 50	< 40 > 40	100 - 150 80 - 100	.0003" - .0007" .0002" - .0005"	.0005" - .0010" .0004" - .0007"	.0008" - .0015" .0005" - .0010"	.0009" - .0013" .0005" - .0010"	.0010" - .0018" .0007" - .0010"	.0015" - .0020" .0009" - .0015"	.0018" - .0022" .0012" - .0018"	.0018" - .0035" .0015" - .0025"
	400 Series	< 40 > 40	150 - 200 100 - 150	.0007" - .0010" .0004" - .0008"	.0009" - .0015" .0006" - .0010"	.0009" - .0014" .0007" - .0011"	.0011" - .0015" .0008" - .0012"	.0013" - .0018" .0009" - .0015"	.0015" - .0025" .0012" - .0020"	.0020" - .0035" .0018" - .0030"	.0030" - .0046" .0024" - .0042"
P	**HIGH STRENGTH TOOL STEELS**										
	4140, 4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	< 40 > 40	150 - 200 100 - 150	.0003" - .0008" .0003" - .0005"	.0005" - .0010" .0003" - .0008"	.0010" - .0015" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0014" - .0024" .0010" - .0015"	.0018" - .0026" .0012" - .0018"	.0020" - .0028" .0015" - .0022"
	MEDIUM ALLOY TOOL STEELS										
	200, 250, 300, 8620	< 40 > 40	150 - 200 100 - 150	.0003" - .0008" .0003" - .0005"	.0005" - .0010" .0003" - .0008"	.0010" - .0015" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0014" - .0024" .0010" - .0015"	.0018" - .0026" .0012" - .0018"	.0020" - .0028" .0015" - .0022"
	LOW CARBON STEELS										
	Platinum, A36, 12L14, 1000's, 1100's, 1300's	< 40 > 40	150 - 200 100 - 150	.0003" - .0008" .0003" - .0005"	.0005" - .0010" .0003" - .0008"	.0010" - .0015" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0012" - .0020" .0005" - .0010"	.0014" - .0024" .0010" - .0015"	.0018" - .0026" .0012" - .0018"	.0020" - .0028" .0015" - .0022"
	CAST STEELS										
	Steel		125 - 175	.0003" - .0008"	.0005" - .0010"	.0010" - .0018"	.0010" - .0018"	.0012" - .0020"	.0015" - .0025"	.0024" - .0032"	.0026" - .0034"
K	**CAST MATERIAL**										
	Ductile Iron		175 - 225	.0008" - .0012"	.0010" - .0015"	.0015" - .0025"	.0015" - .0025"	.0020" - .0030"	.0025" - .0035"	.0035" - .0045"	.0035" - .0045"
	Gray Iron		175 - 225	.0008" - .0012"	.0010" - .0015"	.0015" - .0025"	.0015" - .0025"	.0020" - .0030"	.0025" - .0035"	.0035" - .0045"	.0035" - .0045"
N	**NON-FERROUS**										
	Aluminum (6061, 7075)		300 - 500	.0006" - .0010"	.0008" - .0014"	.0012" - .0020"	.0014" - .0028"	.0020" - .0030"	.0035" - .0048"	.0050" - .0060"	.0058" - .0070"
	Magnesium		300 - 500	.0006" - .0010"	.0008" - .0014"	.0012" - .0020"	.0014" - .0028"	.0020" - .0030"	.0035" - .0048"	.0050" - .0060"	.0058" - .0070"
	Copper		250 - 450	.0006" - .0010"	.0008" - .0014"	.0012" - .0020"	.0014" - .0028"	.0020" - .0030"	.0035" - .0048"	.0050" - .0060"	.0058" - .0070"
	Brass, Bronze		200 - 400	.0006" - .0010"	.0008" - .0014"	.0012" - .0020"	.0014" - .0028"	.0020" - .0030"	.0035" - .0048"	.0050" - .0060"	.0058" - .0070"
O	**COMPOSITE (non-ISO)**										
	Glass Epoxy, Fiberglass, Plastics		200 - 400	.0006" - .0010"	.0008" - .0014"	.0012" - .0020"	.0014" - .0028"	.0020" - .0030"	.0035" - .0048"	.0050" - .0060"	.0058" - .0070"

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