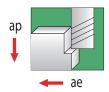
## **GARR TOOL Milling Guide for Diamond Coated End Mills in Graphite**

DIAMETER	RPM	CHIPLOAD PER TOOTH (Fz)
1/32" - 1/16"	15,000 - 35,000	.0005"0010"
1/16" - 1/8"	8,000 - 31,000	.0008"0015"
1/8" - 3/16"	8,000 - 31,000	.0010"0020"
3/16" - 1/4"	8,000 - 25,000	.0010"0020"
1/4" - 5/16"	6,000 - 23,000	.0020"0040"
5/16" - 3/8"	6,000 - 20,000	.0020"0040"
3/8" - 1/2"	6,000 - 20,000	.0030"0050"
1/2" - 5/8"	4,500 - 15,000	.0050"0060"
5/8" - 3/4"	4,500 - 12,000	.0060"0070"
3/4" - 1"	4,500 - 12,000	.0070"0080"

DIAMETER	RPM	CHIPLOAD PER TOOTH (Fz)
1.0 - 3.0mm	15,000 - 35,000	.015030
3.0 - 6.0mm	8,000 - 31,000	.030050
6.0 - 10.0mm	6,000 - 31,000	.050100
10.0 - 12.0mm	6,000 - 25,000	.080130
16.0 - 20.0mm	4,500 - 15,000	.130150
20.0 - 25.0mm	4,500 - 12,000	.150200

## Generally, tools will run at maximum RPM in relation to the corresponding parameters below:

	Slotting	Profiling
Axial (ap)	5% of Dia.	1xD
Radial (ae)	1xD	10% of Dia.



These recommendations are suggested for use primarily in graphite cutting applications.

Rigid work holding, machine stability and part integrity are critical!

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