

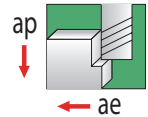
GARR TOOL Milling Guide for VRX-6 Series End Mills

Metric

	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, Ductile Iron	Invar, 400, 316, pH Series	6Al4V	1000 Series	
	SMM = 45 - 70	SMM = 75 - 120	SMM = 75 - 140	SMM = 120 - 180	SMM = 120 - 150
DIA	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
6.0	.015 - .030	.025 - .035	.025 - .035	.035 - .050	.035 - .050
8.0	.020 - .040	.030 - .050	.030 - .050	.040 - .060	.040 - .060
10.0	.025 - .055	.035 - .065	.035 - .065	.050 - .075	.050 - .075
12.0	.030 - .060	.050 - .075	.050 - .075	.060 - .090	.060 - .090
16.0	.035 - .065	.065 - .090	.065 - .090	.075 - .100	.075 - .100
20.0	.045 - .065	.075 - .100	.075 - .100	.090 - .115	.090 - .115
25.0	.050 - .075	.085 - .125	.090 - .125	.100 - .140	.100 - .140

Profile/Trochoidal Milling

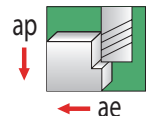
Axial (ap)	up to 2xD
Radial (ae)	11%-16% x D



	Nickel or Cobalt-based	Stainless	Titanium Alloys	Carbon Steels	Grey Cast Iron
	Inconel, Cobalt Chrome, Ductile Iron	Invar, 400, 316, pH Series	6Al4V	1000 Series	
	SMM = 60 - 75	SMM = 90 - 150	SMM = 90 - 180	SMM = 140 - 200	SMM = 140 - 160
DIA	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
6.0	.025 - .035	.035 - .050	.035 - .050	.050 - .065	.050 - .065
8.0	.025 - .045	.040 - .060	.040 - .060	.060 - .080	.060 - .080
10.0	.030 - .050	.050 - .075	.050 - .075	.065 - .090	.065 - .090
12.0	.035 - .060	.060 - .085	.060 - .090	.075 - .100	.075 - .100
16.0	.040 - .065	.075 - .100	.075 - .100	.090 - .115	.090 - .115
20.0	.050 - .075	.085 - .110	.085 - .115	.100 - .125	.100 - .125
25.0	.060 - .085	.100 - .140	.100 - .140	.125 - .165	.125 - .165

Profile/Trochoidal Milling

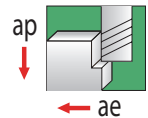
Axial (ap)	up to 3xD
Radial (ae)	6%-10% x D



	Nickel or Cobalt-based	Stainless	Titanium Alloys	Carbon Steels	Grey Cast Iron
	Inconel, Cobalt Chrome, Ductile Iron	Invar, 400, 316, pH Series	6Al4V	1000 Series	
	SMM = 70 - 90	SMM = 120 - 180	SMM = 120 - 210	SMM = 150 - 210	SMM = 140 - 180
DIA	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)	CPT (Fz)
6.0	.035 - .060	.050 - .075	.050 - .075	.065 - .085	.065 - .085
8.0	.035 - .065	.055 - .085	.055 - .085	.070 - .095	.070 - .095
10.0	.040 - .070	.065 - .100	.065 - .100	.075 - .110	.075 - .110
12.0	.050 - .085	.075 - .110	.075 - .110	.090 - .125	.090 - .125
16.0	.060 - .100	.090 - .120	.090 - .120	.100 - .135	.100 - .135
20.0	.075 - .110	.100 - .130	.100 - .130	.115 - .150	.115 - .150
25.0	.090 - .125	.120 - .170	.120 - .170	.140 - .185	.140 - .185

Profile/Trochoidal Milling

Axial (ap)	up to 4xD
Radial (ae)	3%-5% x D



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