

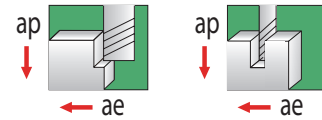
# GARR TOOL Milling Guide for V5 End Mills in Titanium, Inconel, and Stainless

(CHIP THINNING CALCULATION ALREADY APPLIED)

## Fractional

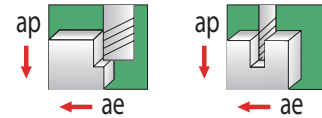
	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)
	SFM = 150 - 250	SFM = 60 - 125	SFM = 150 - 300
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)
.2362" - .2755"	.0008" - .0011"	.0004" - .0008"	.0008" - .0012"
.2756" - .3124"	.0010" - .0015"	.0005" - .0010"	.0010" - .0018"
.3125" - .3749"	.0012" - .0018"	.0007" - .0012"	.0012" - .0020"
.3750" - .4999"	.0012" - .0021"	.0008" - .0015"	.0015" - .0022"
.5000" - .6249"	.0015" - .0025"	.0010" - .0018"	.0018" - .0030"
.6250" - .7499"	.0018" - .0030"	.0012" - .0020"	.0020" - .0033"
.7500" - .8749"	.0020" - .0032"	.0015" - .0022"	.0025" - .0037"
.8750" - 1.000"	.0025" - .0035"	.0018" - .0025"	.0030" - .0042"

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



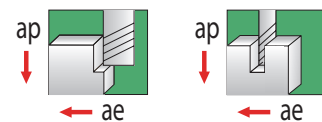
	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)
	SFM = 300 - 500	SFM = 100 - 200	SFM = 250 - 400
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)
.2362" - .2755"	.0011" - .0015"	.0007" - .0011"	.0011" - .0015"
.2756" - .3124"	.0013" - .0021"	.0008" - .0013"	.0015" - .0021"
.3125" - .3749"	.0015" - .0023"	.0010" - .0015"	.0018" - .0025"
.3750" - .4999"	.0018" - .0025"	.0011" - .0018"	.0021" - .0028"
.5000" - .6249"	.0021" - .0033"	.0013" - .0021"	.0023" - .0033"
.6250" - .7499"	.0023" - .0036"	.0015" - .0023"	.0028" - .0038"
.7500" - .8749"	.0028" - .0040"	.0018" - .0025"	.0033" - .0043"
.8750" - 1.000"	.0033" - .0045"	.0021" - .0028"	.0038" - .0048"

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



	Titanium Alloys	Nickel or Cobalt-based Material	Stainless (400 Series, pH Series)
	SFM = 400 - 700	SFM = 150 - 250	SFM = 300 - 500
DIAMETER	CPT (Fz)	CPT (Fz)	CPT (Fz)
.2362" - .2755"	.0018" - .0022"	.0015" - .0020"	.0020" - .0025"
.2756" - .3124"	.0022" - .0028"	.0017" - .0022"	.0022" - .0030"
.3125" - .3749"	.0025" - .0032"	.0018" - .0025"	.0025" - .0035"
.3750" - .4999"	.0028" - .0035"	.0020" - .0028"	.0028" - .0040"
.5000" - .6249"	.0030" - .0040"	.0022" - .0030"	.0030" - .0045"
.6250" - .7499"	.0035" - .0045"	.0025" - .0032"	.0032" - .0050"
.7500" - .8749"	.0040" - .0050"	.0028" - .0035"	.0035" - .0055"
.8750" - 1.000"	.0045" - .0055"	.0032" - .0040"	.0040" - .0060"

	Profiling Side Cutting	Slotting Pocket Milling
Axial (ap)	1xD	5% of Dia.
Radial (ae)	5% of Dia.	1xD



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