

## VI-PRO VARIABLE INDEX END MILLS

### 4 Flute - Technical Information

VI-Pro Variable Index End Mills - 4 Flute

Material Guide		Rc	SFM		Feed Per Tooth									
			Stub, Reg Length	Long, Xlong Length	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	1"
COBALT BASE ALLOYS	Stellite, HS - 21, Haynes 25/188, X - 40, L - 605	under 32	275 - 350	220 - 280	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
		over 32	175 - 250	140 - 200	-	-	-	-	-	-	-	-	-	-
NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	under 32	200 - 300	160 - 240	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
		over 32	125 - 200	100 - 160	-	-	-	-	-	-	-	-	-	-
IRON BASE ALLOYS	Incoloy 800 - 802, Multimet N - 155, Timkin 16 - 25 - 6, Carpeneter 22 - b3	under 32	250 - 350	200 - 280	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
		over 32	200 - 250	160 - 200	-	-	-	-	-	-	-	-	-	-
MONEL	Monel - 65% Nickel		275 - 350	220 - 280	.0004	.0009	.0014	.0015	.0017	.0019	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-	-	-	-
TITANIUM ALLOYS	Commercially Pure, 6AL - 4V, Astm 1/2/3, 6Al - 25N - 4Zr - 2Mo - Si		250 - 400	200 - 320	.0004	.0009	.0014	.0015	.0017	.0019	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-	-	-	-
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17 - 4, AM - 350/355	under 32	250 - 300	200 - 240	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
		over 32	200 - 250	160 - 200	-	-	-	-	-	-	-	-	-	-
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 304L, 316, 316L	under 32	250 - 375	200 - 300	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
		over 32	200 - 250	160 - 200	-	-	-	-	-	-	-	-	-	-
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440		250 - 300	200 - 240	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-	-	-	-
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	under 32	250 - 350	200 - 280	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
		over 32	150 - 200	120 - 160	-	-	-	-	-	-	-	-	-	-
MEDIUM ALLOY STEELS	200, 250, 300	under 32	210 - 300	170 - 240	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
		over 32	130 - 170	100 - 135	-	-	-	-	-	-	-	-	-	-
CARBON STEELS	1000's, 1100's, 1300's		420 - 450	335 - 360	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-	-	-	-
DUCTILE	Ductile Cast Irons		420 - 450	335 - 360	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-	-	-	-
CAST IRONS	Gray Cast Irons		420 - 450	335 - 360	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-	-	-	-