

VI-PRO VARIABLE INDEX END MILLS

5 Flute - Technical Information

VI-Pro Variable Index End Mills - 5 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 over 32	315 - 400 200 - 290	250 - 320 160 - 230	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
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NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	under 32 over 32	230 - 345 145 - 230	185 - 275 115 - 185	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
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IRON BASE ALLOYS	Incoloy 800 - 802, Multimet N - 155, Timkin 16 - 25 - 6, Carpeneter 22 - b3	under 32 over 32	290 - 400 230 - 290	230 - 320 185 - 230	.0004	.0005	.0009	.0010	.0012	.0014	.0016	.0019	.0024	.0029
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MONEL	Monel - 65% Nickel		315 - 400	250 - 320	.0004	.0009	.0014	.0015	.0017	.0019	.0026	.0029	.0035	.0039
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TITANIUM ALLOYS	Commercially Pure, 6AL - 4V, Astm 1/2/3, 6Al - 25N - 4Zr - 2Mo - Si		290 - 460	230 - 370	.0004	.0009	.0014	.0015	.0017	.0019	.0026	.0029	.0035	.0039
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STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17 - 4	under 32 over 32	290 - 345 230 - 290	230 - 275 185 - 230	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
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STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 304L, 316, 316L	under 32 over 32	290 - 430 230 - 290	230 - 345 185 - 230	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
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STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440		290 - 345	230 - 275	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
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HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	under 32 over 32	290 - 400 170 - 230	230 - 420 135 - 185	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
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MEDIUM ALLOY STEELS	200, 250, 300	under 32 over 32	240 - 345 150 - 200	190 - 275 120 - 160	.0004	.0009	.0014	.0016	.0017	.0019	.0026	.0029	.0035	.0039
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CARBON STEELS	1000's, 1100's, 1300's		480 - 510	385 - 405	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
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DUCTILE	Ductile Cast Irons		480 - 510	385 - 405	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
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CAST IRONS	Gray Cast Irons		480 - 510	385 - 405	.0004	.0011	.0018	.0024	.0030	.0033	.0035	.0039	.0041	.0054
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