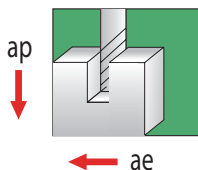


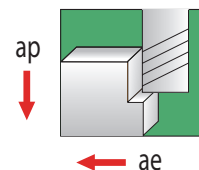
GARR TOOL Milling Guide for H-45 High Feed End Mills

	UP TO 40 HRC			40 - 45 HRC			45 - 55 HRC			55 - 60 HRC		
DIAMETER	SPEED RPM	FEED IN/MIN	FEED MM/MIN	SPEED RPM	FEED IN/MIN	FEED MM/MIN	SPEED RPM	FEED IN/MIN	FEED MM/MIN	SPEED RPM	FEED IN/MIN	FEED MM/MIN
3.0mm	16000	-	3100	13000	-	2032	11300	-	1778	9700	-	889
1/8"	15200	120	-	12000	80	-	10700	70	-	9200	35	-
4.0mm	12100	-	3700	9700	-	2540	8500	-	2159	7300	-	1016
3/16"	10200	160	-	8200	110	-	7100	90	-	6100	45	-
5.0mm	9700	-	4000	7700	-	2667	6800	-	2286	5800	-	1143
6.0mm	8100	-	4600	6500	-	3048	5700	-	2540	4900	-	1270
1/4"	7650	180	-	6100	120	-	5400	100	-	4600	50	-
5/16"	6100	195	-	4900	130	-	4300	110	-	3700	55	-
8.0mm	6050	-	4950	4850	-	3302	4300	-	2794	3650	-	1397
3/8"	5100	200	-	4100	135	-	3600	115	-	3100	60	-
10.0mm	4850	-	5100	3900	-	3429	3400	-	2921	2900	-	1524
12.0mm	4050	-	6400	3200	-	4064	2800	-	3429	2400	-	1651
1/2"	3800	240	-	3100	160	-	2700	135	-	2300	65	-

	Slotting Pocket Milling
Axial (ap)	0.3 x Radius
Radial (ae)	1 x D



	Profiling Side Milling
Axial (ap)	1 x D
Radial (ae)	0.3 x Radius



D = Tool Diameter

Example: Axial = 0.3 x radius, when D = 1/2" with .060" corner radius (.3 x .060") = .018" per pass

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