4MVL Series Recommended Cutting Data - **Inch**

Workpiece Material Group	ISO	Coolant			Application	Type of cut		Vc-SFM	Tool Diameter (inch)					
		Emulsion	Air	MQL		Radial (Ae)	Axial (Ap)		1/32	3/64	1/16	5/64	3/32	1/8
									fz - in/tooth					
Austentic & PH Stainless Steels	**M**	●	X	X	Slotting	1 x D	0.3 x D	245	.00015	.00023	.00030	.00038	.00045	.00060
					Profiling	0.05 x D	5 x D	490	.00030	.00045	.00060	.00075	.00090	.00120
High Temp Alloys	**S**	●	X	X	Slotting	1 x D	0.2 x D	100	.00006	.00009	.00012	.00015	.00018	.00024
					Profiling	0.03 x D	5 x D	150	.00018	.00026	.00035	.00044	.00053	.00070
Titanium Alloys		●	X	X	Slotting	1 x D	0.3 x D	245	.00013	.00019	.00025	.00031	.00038	.00050
					Profiling	0.05 x D	5 x D	350	.00025	.00038	.00050	.00063	.00075	.00100
Aluminum Alloys	**N**	●	X	X	Slotting	1 x D	0.5 x D	525	.00031	.00047	.00063	.00078	.00094	.00125
					Profiling	0.1 x D	5 x D	655	.00050	.00075	.00100	.00125	.00150	.00200

● Preferred O Possible X Not Possible

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.
Max. ramp angle = 3° @ 30-50% feed reduction

Safety Note
Always wear the appropriate personal protective equipment such as safety glasses and protective clothing when using solid carbide or HSS cutting tools. Machines should be fully guarded.

⚠ **WARNING:** This product can expose you to chemicals including cobalt, which is known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov.