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

Workpiece Material Group	ISO	Coolant			Application	Type of cut		Vc-SFM	Tool Diameter (inch)					
									1/32	3/64	1/16	5/64	3/32	1/8
		Emulsion	Air	MQL		Radial (Ae)	Axial (Ap)		fz - in/tooth					
Austentic & PH Stainless Steels	**M**	●	X	X	Slotting	1 x D	0.5 x D	245	.00015	.00023	.00030	.00038	.00045	.00060
					Profiling	0.1 x D	3 x D	490	.00030	.00045	.00060	.00075	.00090	.00120
High Temp Alloys	**S**	●	X	X	Slotting	1 x D	0.3 x D	100	.00006	.00009	.00012	.00015	.00018	.00024
					Profiling	0.05 x D	3 x D	150	.00018	.00026	.00035	.00044	.00053	.00070
Titanium Alloys		●	X	X	Slotting	1 x D	0.5 x D	245	.00013	.00019	.00025	.00031	.00038	.00050
					Profiling	0.1 x D	3 x D	350	.00025	.00038	.00050	.00063	.00075	.00100
Aluminum Alloys	**N**	●	X	X	Slotting	1 x D	1 x D	525	.00035	.00053	.00070	.00088	.00105	.00140
					Profiling	0.2 x D	3 x D	655	.00056	.00084	.00113	.00141	.00169	.00225

● 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