



## List VGM5: 5 Flute

### Side Milling

Hardness	-		Up to 30 HRC				-		-		-		-		35 HRC	
Work Material	Mild Steels Carbon Steels Cast Iron		Tool Steel Alloy Steel		Stainless Steel 304		Titanium Alloy Ti-6AL-4V		Inconel 718		Inconel 625		Cast Iron		Hardened Steel	
Cutting	350-650 SFM		350-650 SFM		200-350 SFM		200-350 SFM		100-200 SFM		150-250 SFM		350-750 SFM		200-350 SFM	
Depth of Cut	Aa = up to Max LOC, Ar = 0.3xD						Aa = up to Max LOC, Ar = 0.2xD		Aa = up to Max LOC, Ar = 0.1xD				Aa = up to Max LOC, Ar = 0.3xD		Aa = up to Max LOC, Ar = 0.15xD	
Mill Dia.	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM
Inch																
1/8	16,794	84.0	16,794	84.0	7,634	38.2	7,634	38.2	4,580	22.9	6,107	30.5	16,794	84.0	7,634	38.2
5/32	13,435	86.1	13,435	86.1	6,107	39.1	6,107	39.1	3,664	18.3	4,885	24.4	13,435	86.1	6,107	39.1
3/16	11,196	88.2	11,196	88.2	5,089	40.1	5,089	40.1	3,053	22.9	4,071	30.5	11,196	88.2	5,089	40.1
7/32	9,597	90.3	9,597	90.3	4,362	41.0	4,362	41.0	2,617	19.6	3,490	26.2	9,597	90.3	4,362	41.0
1/4	8,397	92.4	8,397	92.4	3,817	42.0	3,817	42.0	2,290	22.9	3,053	30.5	8,397	92.4	3,817	42.0
9/32	7,464	94.5	7,464	94.5	3,393	42.9	3,393	42.9	2,036	20.4	2,714	27.1	7,464	94.5	3,393	42.9
5/16	6,718	96.6	6,718	96.6	3,053	43.9	3,053	43.9	1,832	18.3	2,443	24.4	6,718	96.6	3,053	43.9
3/8	5,598	98.0	5,598	98.0	2,545	44.5	2,545	44.5	1,527	19.1	2,036	25.4	5,598	98.0	2,545	44.5
1/2	4,198	88.2	4,198	88.2	1,908	40.1	1,908	40.1	1,145	14.3	1,527	19.1	4,198	88.2	1,908	40.1
5/8	3,359	70.5	3,359	70.5	1,527	32.1	1,527	32.1	916	11.5	1,221	15.3	3,359	70.5	1,527	32.1
3/4	2,799	61.6	2,799	61.6	1,272	28.0	1,272	28.0	763	9.5	1,018	12.7	2,799	61.6	1,272	28.0
1	2,099	46.2	2,099	46.2	954	21.0	954	21.0	573	8.6	763	11.5	2,099	46.2	954	21.0

- The above milling condition is a guideline for L/D ratio 1.25 and 1.5.
- Use a rigid and precise machine and holder.
- The rotational speed is calculated by the median of the recommended cutting speed.  
Adjustments may be necessary depending on the rigidity of the workpiece, fixture, and machine.
- Please use a suitable fluid with high smoke retardant properties.
- During dry (no fluid) milling, please use air blow to remove chips from the milling area and to eliminate chip packing.
- Please use water-soluble coolant when machining stainless steel and titanium alloy.
- Reduce speed and feed as well as depth of cut when high precision is required.

### Speed & Feed Reduction Chart by L/D Ratio

Hardness	-		Up to 30 HRC				-		-		-		-		35 HRC	
Work Material	Mild Steels Carbon Steels Cast Iron		Tool Steel Alloy Steel		Stainless Steel 304		Titanium Alloy Ti-6AL-4V		Inconel 718		Inconel 625		Cast Iron		Hardened Steel	
L/D Ratio	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM	Speed RPM	Feed IPM
2	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
2.5	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
3	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%	80%
4	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%	60%
5	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%	50%
6	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%	40%

### Aa & Ar Adjustment Chart by L/D Ratio

Hardness	-		Up to 30 HRC				-		-		-		-		35 HRC			
Work Material	Mild Steels Carbon Steels Cast Iron		Tool Steel Alloy Steel		Stainless Steel 304		Titanium Alloy Ti-6AL-4V		Inconel 718		Inconel 625		Cast Iron		Hardened Steel			
L/D Ratio	Aa	Ar	Aa	Ar	Aa	Ar	Aa	Ar	Aa	Ar	Aa	Ar	Aa	Ar	Aa	Ar		
2		0.2 x D		0.2 x D		0.2 x D		0.15 x D		0.08 x D		0.08 x D		0.2 x D		0.1 x D		
2.5		0.2 x D		0.2 x D		0.2 x D		0.15 x D		0.08 x D		0.08 x D		0.2 x D		0.1 x D		
3	Up to Max. LOC	0.15 x D	Up to Max. LOC	0.15 x D	Up to Max. LOC	0.15 x D	Up to Max. LOC	0.1 x D	Up to Max. LOC	0.05 x D	Up to Max. LOC	0.05 x D	Up to Max. LOC	0.15 x D	Up to Max. LOC	0.05 x D		
4		0.1 x D		0.1 x D		0.05 x D		0.03 x D		0.1 x D		0.03 x D						
5		0.1 x D		0.1 x D		0.05 x D		0.03 x D		0.1 x D		0.03 x D						
6		0.05 x D		0.05 x D		0.05 x D		0.03 x D		0.05 x D		0.02 x D		0.05 x D		0.02 x D	0.05 x D	0.02 x D

