

546 SERIES V² 5 FLUTE CHIPLOADS

MATERIALS		Carbon Steels	Alloy Steels	Stainless Steels 300 Series	Stainless Steels 400 Series	Cast Irons	High Temp Alloys	Titanium Alloys
Description		10XX, 11XX, 13XX, 15XX	40XX, 41XX, 42XX, 43XX, 46XX, 86XX Series	304, 304L, 316, 316L, 312, Invar Kovar	420, 430F, 416, 420F, 440L		Inconel 625/718, A286, Haynes	Wrought 6AL-4V, ASTM 1,2,3, 6A1-25N-4ZR-2MO-51
SFM < 32 RC		360- 420	180 – 260	250 – 300	360 – 420	140 -300	100 – 160	200 – 250
SFM > 32 RC		220 -280	140 – 220	200 – 260	220 – 280	80 – 140	60 – 120	160 – 200
1/4	M R	.0014	.0014	.0014	.0014	.0014	.0014	.0014
	FMR	.0014	.0014	.0014	.0014	.0014	.0014	.0014
	F	.0023	.0020	.0020	.0020	.0020	.0020	.0023
5/16	M R	.0017	.0017	.0017	.0017	.0017	.0017	.0017
	FMR	.0017	.0017	.0017	.0017	.0017	.0017	.0017
	F	.0027	.0025	.0025	.0025	.0025	.0025	.0027
3/8	M R	.0021	.0021	.0021	.0021	.0021	.0021	.0021
	FMR	.0021	.0021	.0021	.0021	.0021	.0021	.0021
	F	.1136	.0032	.0032	.0032	.0032	.0032	.0036
1/2	M R	.0030	.0030	.0030	.0030	.0030	.0030	.0030
	FMR	.0030	.0030	.0030	.0030	.0030	.0030	.0030
	F	.0045	.0045	.0045	.0045	.0045	.0045	.0050
5/8	F R	.0037	.0037	.0031	.0037	.0037	.0037	.0037
	FMR	.0037	.0037	.0037	.0037	.0037	.0037	.0037
	F	.0061	.0055	.0055	.0055	.0055	.0055	.0061
3/4	M R	.0045	.0045	.0045	.0045	.0045	.0045	.0045
	FMR	.0045	.0045	.0045	.0045	.0045	.0045	.0045
	F	.0074	.0067	.0060	.0060	.0067	.0067	.0074
1"	M R	.0060	.0060	.0060	.0060	.0060	.0060	.0060
	FMR	.0060	.0060	.0060	.0060	.0060	.0060	.0060
	F	.0100	.0090	.0090	.0090	.0090	.0090	.0010

Medium Radial = 1.0 x Dia Depth
<20% x Dia Radial

Finishing Medium Radial <10% of Dia
Finishing - <.010 Radial Depth