## **GARR TOOL Application Guide for Aluminum Series 3-Flute Drills**

## **Fractional**

CHIPLOAD PER FLUTE (Fz)												
Material	Type	SFM	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"				
Aluminum Alloy	6061	450 - 650	.0020"0040"	.0025"0050"	.0035"0060"	.0045"0070"	.0055"0080"	.0065"0100"				
Cast Aluminum	380	300 - 500	.0015"0030"	.0020"0040"	.0030"0050"	.0030"0060"	.0035"0070"	.0040"0080"				
Magnesium		250 - 500	.0015"0030"	.0020"0040"	.0030"0050"	.0030"0060"	.0035"0070"	.0040"0080"				
Copper & Brass		250 - 400	.0010"0025"	.0020"0030"	.0020"0030"	.0020"0040"	.0030"0050"	.0030"0060"				
Titanium	6Al-4V	100 - 300	.0010"0020"	.0020"0030"	.0020"0030"	.0020"0040"	.0030"0050"	.0030"0060"				

## Metric

CHIPLOAD PER FLUTE (Fz)												
Material	Туре	M/Min.	4.0	6.0	8.0	10.0	12.0	16.0				
Aluminum Alloy	6061	140 - 200	.050100	.065125	.090150	.115175	.150200	.165250				
Cast Aluminum	380	90 - 150	.038075	.050100	.075125	.075150	.090175	.100200				
Magnesium		75 - 150	.038075	.050100	.075125	.075150	.090175	.100200				
Copper & Brass		75 - 120	.025060	.050075	.050075	.050100	.075125	.075150				
Titanium	6Al-4V	30 - 90	.025050	.050075	.050075	.050100	.075125	.075150				



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

