



### VI-Pro Variable Index End Mills - 6 & 7 Flute

Material Guide		HRc	Reg Length	Long Length	Suggested Chip Load Per Tooth						
					1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
COBALT BASE ALLOYS	Stellite, HS - 21, Haynes 25/188, X - 40, L - 605	under 32 over 32	360 - 460 235 - 300	290 - 370 190 - 240	.0009	.0010	.0012	.0016	.0019	.0024	.0029
					-	-	-	-	-	-	-
					.0016	.0018	.0019	.0028	.0031	.0037	.0041
					-	-	-	-	-	-	-
NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	under 32 over 32	265 - 400 170 - 260	210 - 320 135 - 210	.0009	.0010	.0012	.0016	.0019	.0024	.0029
					-	-	-	-	-	-	-
					.0016	.0018	.0019	.0028	.0031	.0037	.0041
					-	-	-	-	-	-	-
IRON BASE ALLOYS	Incoloy 800 - 802, Multimet N - 155, Timkin 16 - 25 - 6, Carpeneter 22 - b3	under 32 over 32	335 - 460 215 - 300	270 - 370 170 - 240	.0009	.0010	.0012	.0016	.0019	.0024	.0029
					-	-	-	-	-	-	-
					.0016	.0018	.0019	.0028	.0031	.0037	.0041
					-	-	-	-	-	-	-
MONEL	Monel - 65% Nickel		360 - 460	290 - 370	.0014	.0015	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0017	.0019	.0028	.0031	.0037	.0041
					-	-	-	-	-	-	-
TITANIUM ALLOYS	Commercially Pure, 6AL - 4V, Astm 1/2/3, 6Al - 25N - 4Zr - 2Mo - Si		335 - 530	270 - 425	.0014	.0015	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0017	.0019	.0028	.0031	.0037	.0041
					-	-	-	-	-	-	-
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17 - 4	under 32 over 32	335 - 400 270 - 320	270 - 320 215 - 260	.0014	.0016	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0020	.0025	.0032	.0037	.0039	.0041
					-	-	-	-	-	-	-
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 304L, 316, 316L	under 32 over 32	335 - 500 270 - 400	270 - 400 215 - 320	.0014	.0016	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0020	.0025	.0032	.0037	.0039	.0041
					-	-	-	-	-	-	-
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440		335 - 400	270 - 320	.0014	.0016	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0020	.0025	.0032	.0037	.0039	.0041
					-	-	-	-	-	-	-
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	under 32 over 32	335 - 460 215 - 300	270 - 370 170 - 240	.0014	.0016	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0020	.0025	.0032	.0037	.0039	.0041
					-	-	-	-	-	-	-
MEDIUM ALLOY STEELS	200, 250, 300	under 32 over 32	275 - 400 180 - 260	220 - 320 145 - 210	.0014	.0016	.0017	.0026	.0029	.0035	.0039
					-	-	-	-	-	-	-
					.0016	.0020	.0025	.0032	.0037	.0039	.0041
					-	-	-	-	-	-	-
CARBON STEELS	1000's, 1100's, 1300's		550 - 585	440 - 470	.0018	.0024	.0030	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-
					.0020	.0026	.0032	.0037	.0041	.0043	.0056
					-	-	-	-	-	-	-
DUCTILE	Ductile Cast Irons		550 - 585	440 - 470	.0018	.0024	.0030	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-
					.0020	.0026	.0032	.0037	.0041	.0043	.0056
					-	-	-	-	-	-	-
CAST IRONS	Gray Cast Irons		550 - 585	440 - 470	.0018	.0024	.0030	.0035	.0039	.0041	.0054
					-	-	-	-	-	-	-
					.0020	.0026	.0032	.0037	.0041	.0043	.0056
					-	-	-	-	-	-	-