

VFSS STUB & TECHNICAL DATA



STUB

5 FL Part #	Cut Dia	Shank	LOC	Corner Rad	OAL	Price
18MTMX5S	1/8	1/8	7/32	.010-.015	1.5	\$17.68
532MTMX5S	5/32	3/16	9/32	.010-.015	2	\$20.56
316MTMX5S	3/16	3/16	5/16	.010-.015	2	\$19.69
732MTMX5S	7/32	1/4	5/16	.015-.020	2	\$26.43
14MTMX5S	1/4	1/4	3/8	.015-.020	2	\$25.31
932MTMX5S	9/32	5/16	3/8	.015-.020	2	\$33.69
516MTMX5S	5/16	5/16	3/8	.015-.020	2	\$32.51
38MTMX5S	3/8	3/8	1/2	.015-.020	2	\$38.40
716MTMX5S	7/16	7/16	5/8	.015-.020	2 1/2	\$57.71
12MTMX5S	1/2	1/2	5/8	.025-.030	3	\$68.96

STARTING RECOMMENDED SPEEDS AND FEEDS

Profile

Radial Depth = .5 x Diameter
Axial Depth = 1 x Diameter

Slotting

Axial Depth = .5 x Diameter

Materials	Stainless	Stainless	Stainless	Stainless	Stainless	Stainless
	300 Series 304, 310, 316	400 Series 409, 430, 436	15-5 17-4PH	300 Series 304, 310, 316	400 Series 409, 430, 436	15-5 17-4PH
Diameter	300 SFM	250 SFM	250 SFM	240 SFM	200 SFM	200 SFM
1/4	.001	.001	.001	.0008	.0008	.0008
5/16	.0015	.0015	.0014	.0012	.0012	.0011
3/8	.002	.002	.0019	.0016	.0016	.0015
1/2	.0025	.0025	.0022	.002	.002	.0018
5/8	.003	.003	.0027	.0025	.0025	.0022
3/4	.0035	.0035	.003	.0028	.0028	.0024
1	.0042	.0042	.004	.0034	.0034	.0032

NOTE:

- These are approximate numbers, a good starting point.
- Coolant application is important.
- Tools perform best when balanced.