

## VARIABLE FLUTE FOR STEEL

Profile Width = 1/4 x Diameter    Slotting Depth = 1 x Diameter

Materials	Steel	Cast Iron	Tool Steel	Steel	Cast Iron	Tool Steel
Diameter	600-750 SFM	500-650 SFM	425-525 SFM	475-660 SFM	400-550 SFM	325-425 SFM
1/4	.0014	.0014	.0013	.0012	.0013	.0011
5/16	.0017	.0017	.0016	.0013	.0016	.0013
3/8	.002	.0022	.002	.0016	.002	.0015
1/2	.0026	.0029	.0025	.0023	.0025	.002
5/8	.0028	.0032	.0028	.0024	.0028	.0022
3/4	.0032	.0036	.0031	.0025	.0031	.0025
1	.0038	.0043	.0038	.0032	.0038	.0032

**NOTE:**

- These are approximate numbers, a good starting point.
- Coolant application is an important part of using the variable flute geometries.
- Tools perform best when balanced.

**WARNING** – Due to the high metal removal rates of the VFS tools, it is necessary to make all work holding components as rigid as possible.

List Price Catalog - Current Pricing On Our Website

Tolerance – Diameter: +.000/-.002    Shank: -.0001/-.0003    Made from Submicrograin Carbide

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