

5125 V-MAC VICOR+ - IMPERIAL

V-MAC

VICOR+



The V-Mac is a premiere edition of full radial engagement HEM style end mill. The V-Mac has unsurpassed performance in high cutting force milling in high temp alloys, stainless steel, and Inconel. Please select L.O.C. appropriately to ensure maximum performance. **Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, or Graphite.**

Examples: Inconel 625

Nickel Alloy			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	150	220	160
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
1/8"	.0006	.0007	.0007
1/4"	.0015	.0015	.0015
3/8"	.0020	.0020	.0022
1/2"	.0025	.0027	.0030
3/4"	.0035	.0038	.0040
1"	.0040	.0035	.0046

Examples: 301,303,304,304L,316,316L,321

Stainless Steel - Austenitic			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	375	575	400
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
1/8"	.0008	.0010	.0010
1/4"	.0016	.0018	.0018
3/8"	.0024	.0027	.0028
1/2"	.0037	.0045	.0045
3/4"	.0045	.0052	.0056
1"	.0058	.0066	.0068

Examples: 13XX, 41XX, 43XX, 51XX, 86XX, 93XX

Steels			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	550	950	700
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>10%
1/8"	.0008	.0010	.0010
1/4"	.0016	.0018	.0018
3/8"	.0024	.0027	.0028
1/2"	.0037	.0045	.0045
3/4"	.0045	.0052	.0056
1"	.0058	.0066	.0068

Table HEM compensated

Examples: Inconel 718

Nickel Alloy			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	170	250	180
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
1/8"	.0007	.0008	.0008
1/4"	.0016	.0017	.0018
3/8"	.0024	.0025	.0025
1/2"	.0027	.0030	.0032
3/4"	.0038	.0040	.0042
1"	.0042	.0045	.0048

Examples: 403, 410, 416, 420, 440, 430, 446

Stainless Steel - Martensitic Ferritic			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	425	625	475
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
1/8"	.0008	.0010	.0010
1/4"	.0016	.0018	.0018
3/8"	.0024	.0027	.0028
1/2"	.0037	.0045	.0045
3/4"	.0045	.0052	.0056
1"	.0058	.0066	.0068

Examples: A2, H13, P20, S7 (36-50 Rc)

Hardened Steels			
IMPERIAL IPT	Rough Profile	HEM	Finish
SFM (ft/min)	200	375	230
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
1/8"	.0007	.0008	.0008
1/4"	.0016	.0017	.0018
3/8"	.0024	.0025	.0025
1/2"	.0027	.0030	.0032
3/4"	.0038	.0040	.0042
1"	.0042	.0045	.0048

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5125 V-MAC VICOR+ - METRIC

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FULLERTON®
SPEEDS / FEEDS

Examples: Inconel 625

Nickel Alloy			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	46	91	49
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0152	.0178	.0178
6	.0381	.0381	.0381
10	.0508	.0508	.0559
12	.0635	.0686	.0762
20	.0889	.0965	.1016
25	.1016	.0889	.1168

Examples: 301,303,304,304L,316,316L,321

Stainless Steel - Austenitic			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	114	175	122
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0203	.0254	.0254
6	.0406	.0457	.0457
10	.0610	.0686	.0711
12	.0940	.1143	.1143
20	.1143	.1321	.1422
25	.1473	.1676	.1727

Examples: 13XX, 41XX, 43XX, 51XX, 86XX, 93XX

Steels			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	168	290	213
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0203	.0254	.0254
6	.0406	.0457	.0457
10	.0610	.0686	.0711
12	.0940	.1143	.1143
20	.1143	.1321	.1422
25	.1473	.1676	.1727

Table HEM compensated

Examples: Inconel 718

Nickel Alloy			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	52	101	55
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0178	.0203	.0203
6	.0406	.0432	.0457
10	.0610	.0635	.0635
12	.0686	.0762	.0813
20	.0965	.1016	.1067
25	.1067	.1143	.1219

Examples: 403, 410, 416, 420, 440, 430, 446

Stainless Steel - Martensitic Ferritic			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	130	191	145
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0203	.0254	.0254
6	.0406	.0457	.0457
10	.0610	.0686	.0711
12	.0940	.1143	.1143
20	.1143	.1321	.1422
25	.1473	.1676	.1727

Examples: A2, H13, P20, S7 (36-50 Rc)

Hardened Steels			
METRIC MMPT	Rough Profile	HEM	Finish
SMPM (m/min)	61	114	70
Axial Depth	full	full	full
Radial Width	10%	4%-8%	>6%
3	.0178	.0203	.0203
6	.0406	.0432	.0457
10	.0610	.0635	.0635
12	.0686	.0762	.0813
20	.0965	.1016	.1067
25	.1067	.1143	.1219

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