End Mills									
Z = number of teeth		Fine Finishing	Finishing	Roughing	Slot Milling	Plunging	Contour Milling	Peel Milling	Trochoidal Milling
end mill Z = 1		○	○	●	●	●	○	○	○
end mill Z = 2		○	○	◑	●	●	○	○	○
end mill Z = 3		○	◑	◑	●	◑	○	○	○
end mill Z = 4/5		◑	●	●	●*	○	○	●	●
multi-flute cutter Z = 6-8		●	●	○	○	○	○	●	●
Ball Nose and Torus End Mills									
ball nose end mill Z = 2					●		●		
ball nose end mill Z = 4					◑		●		

**VariMill™/VariMill™ GP Only*

● first choice

◑ suitable with limitations

○ not recommended

Always select a tool with the shortest possible flute length whenever possible. This will increase the stability of the tool and give the best results.

When selecting an end mill, the following machining factors will affect your selection of the correct end mill for your application:

1. Tool overhang.
2. Coolant flow.
3. Machine and setup stability.
4. Machine power and torque.
5. Material to be machined.
6. Machine adaptor size (CV40, CV50, HSK63, etc.).
7. See Tool Reference Guides on pages N6–N15.