



Product Table: Miniature Diamond Coated End Mills - Square

Characteristics: 5x Length of Cut, 4 Flutes

| Material | Type | SFM | | IPT by Cutter Diameter | | | | Depth of Cut | | IPT by Cutter Diameter | | | | | | Depth of Cut | |
|--------------------------------|------------------------------------|----------|-----------|------------------------|--------|--------|--------|--------------|-----------|------------------------|--------|--------|--------|--------|--------|--------------|-----------|
| | | | | .015 | .020 | .031 | .047 | Radial | Axial | .062 | .078 | .093 | .125 | .187 | .250 | Radial | Axial |
| Composites | Laminates | 400-750 | Roughing | .00012 | .00016 | .00025 | .00037 | .25 x Dia | 1 x Dia | .00043 | .00054 | .00064 | .00086 | .00129 | .00173 | .50 x Dia | 1 x Dia |
| | | | Finishing | .00009 | .00012 | .00018 | .00028 | .05 x Dia | 5 x Dia | .00032 | .00040 | .00048 | .00065 | .00097 | .00130 | .10 x Dia | 5 x Dia |
| Plastics | 21%-40% Filled or Fiber Reinforced | 400-750 | Roughing | .00012 | .00016 | .00025 | .00037 | .25 x Dia | 1 x Dia | .00043 | .00054 | .00064 | .00086 | .00129 | .00173 | .50 x Dia | 1 x Dia |
| | | | Finishing | .00009 | .00012 | .00018 | .00028 | .05 x Dia | 5 x Dia | .00032 | .00040 | .00048 | .00065 | .00097 | .00130 | .10 x Dia | 5 x Dia |
| Graphite | POCO 3 | 600-1200 | Roughing | .00016 | .00021 | .00033 | .00051 | .30 x Dia | 1.3 x Dia | .00058 | .00073 | .00087 | .00117 | .00175 | .00234 | .65 x Dia | 1.3 x Dia |
| | | | Finishing | .00012 | .00016 | .00025 | .00038 | .06 x Dia | 5 x Dia | .00043 | .00055 | .00065 | .00088 | .00131 | .00175 | .13 x Dia | 5 x Dia |
| Green Carbide & Green Ceramics | | 100-750 | Roughing | .00015 | .00020 | .00030 | .00046 | .30 x Dia | 1.3 x Dia | .00053 | .00067 | .00079 | .00107 | .00160 | .00213 | .65 x Dia | 1.3 x Dia |
| | | | Finishing | .00011 | .00015 | .00023 | .00035 | .06 x Dia | 5 x Dia | .00040 | .00050 | .00060 | .00080 | .00120 | .00160 | .13 x Dia | 5 x Dia |

Product Notes:

Due to Edge Rounding and Surface Texture inherent in CVD diamond, plastic materials and non-ferrous alloys should be closely supervised for galling and/or flute packing.

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **833-584-3448** or **corehogtech@harveyperformance.com**.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.