HARVEY TOOL

Speeds & Feeds

Product Table: End Mills for Hardened Steels - Corner Radius - For Steels 45-68 Rc
Characteristics: 1.5x Length of Cut, 7 Flutes
Series: 8679xx-C6, 8680xx-C6, 8791xx-C6, 9031xx-C6, 9032xx-C6

Material	Hardness	SFM	Chip Load (IPT) By Cutter Diameter												Depth of Cut	
				.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	.500	Radial	Axial
Hardened Steels Titanium Alloys Nickel Alloys	45 - 55 Rc	60	Semi-Roughing	.00004	.00009	.00013	.00017	.00021	.00026	.00034	.00051	.00069	.00086	.00103	.00137	.15 x Dia	.25 x Dia
			Finishing	.00005	.00010	.00016	.00021	.00026	.00031	.00042	.00062	.00083	.00104	.00125	.00166	.08 x Dia	.5 x Dia
	56 - 68 Rc	50	Semi-Roughing	.00003	.00007	.00010	.00014	.00017	.00020	.00027	.00041	.00055	.00069	.00082	.00110	.12 x Dia	.20 x Dia
			Finishing	.00004	.00007	.00011	.00015	.00019	.00022	.00030	.00045	.00060	.00075	.00091	.00121	.08 x Dia	.5 x Dia

Please note:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. If less than minimum Axial or Radial DOC values are used, increased feed rates are possible. If greater than maximum Axial or Radial DOC values are used, decreased feed rates may be needed.

If you require additional information, Harvey Tool has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **800-645-5609** or **Harveytech@harveyperformance.com**.