



Product Table: Miniature Diamond Coated End Mills - Ball
Characteristics: 3x Length of Cut, 4 Flutes

Material	Type	SFM	IPT by Cutter Diameter						Depth of Cut		
				.062	.078	.093	.125	.187	.250	Radial	Axial
Composites	Laminates	400-750	Roughing	.00054	.00067	.00080	.00108	.00161	.00216	.50 x Dia	1 x Dia
			Finishing	.00043	.00054	.00064	.00086	.00129	.00173	.15 x Dia	3 x Dia
Plastics	21%-40% Filled or Fiber Reinforced	400-750	Roughing	.00054	.00067	.00080	.00108	.00161	.00216	.50 x Dia	1 x Dia
			Finishing	.00043	.00054	.00064	.00086	.00129	.00173	.15 x Dia	3 x Dia
Graphite	POCO 3	600-1200	Roughing	.00072	.00091	.00109	.00146	.00218	.00292	.65 x Dia	1.3 x Dia
			Finishing	.00058	.00073	.00087	.00117	.00175	.00234	.20 x Dia	3 x Dia
Green Carbide & Green Ceramics		100-750	Roughing	.00066	.00083	.00099	.00133	.00199	.00267	.65 x Dia	1.3 x Dia
			Finishing	.00053	.00067	.00079	.00107	.00160	.00213	.20 x Dia	3 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.