



Speeds & Feeds

Product Table: Drill/End Mills - Mill Style - 4 Flute
Characteristics: 82°-140° Included Angle
Series: 153xx, 265xx, 274xx, 8172xx, 8242xx, 8244xx, 8702xx, 9881xx

Product Notes:

- Milling - Presented data reflects slotting application using OD of cutter up to .5x Dia Axial DOC
- Use OD of cutter for Chip Load selection and RPM calculation
- If Axial DOC exceeds .5x Dia, Chip Load and/or Radial DOC must be reduced
Chamfering - Presented data reflects full chamfer engagement on one side of workpiece
- Due to a varying tip diameter, an Effective Cutter Diameter is needed for Chip Load selection and RPM calculation.

- Drilling - Presented values are Chip Load per Tooth and not Chip Load per Rev
- Use OD for Chip Load selection and RPM calculation
- Since only 2 flutes are center cutting in 2 and 4 flute drill/mills, all drilling feed calculations should be made using 2 Effective Flutes
- Depth of Cut not shown as it is not applicable

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. Chip loads reflect uncoated cutters and may be increased 10%-20% if coated. For ferrous materials with hardness <= 28 Rc, chip loads can be increased 10%-20%.
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 Harveytch@harveyperformance.com.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other

Table with columns: MATERIAL, SFM, 0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.312, 0.375, 0.500, 0.625, 0.750, 1.000, Radial, Axial. Includes sections for ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, and COPPER ALLOYS.

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