



**Product Table:** Miniature End Mills - Square - Tapered Reach (Clearance Cutters)  
**Characteristics:** 2 Flutes  
**Series:** 174xx, 175xx, 266xx, 267xx, 283xx, 284xx

**Product Notes:**  
 Posted values represent a 5x Reach. Use the table below to adjust Chip Load (IPT) and Depths of Cut for tools with longer reach.

Reach Multiple	SLOTTING				ROUGHING				FINISHING			
	Chip Load	DOC (Dia < .062)	DOC (Dia > .062)	DOC (Dia > .062)	Chip Load	DOC (Dia < .062)	DOC (Dia > .062)	DOC (Dia > .062)	Chip Load	DOC (Dia < .062)	DOC (Dia > .062)	DOC (Dia > .062)
5x	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%
8x	75%	100%	88%	100%	75%	93%	86%	92%	86%	83%	100%	100%
10x	67%	100%	88%	100%	67%	83%	86%	83%	86%	79%	75%	100%
12x	60%	100%	75%	100%	60%	77%	71%	75%	71%	75%	63%	100%
15x	50%	100%	75%	100%	50%	50%	71%	50%	71%	67%	50%	100%
18x	45%	100%	63%	100%	45%	47%	63%	50%	57%	63%	38%	100%
20x	40%	100%	50%	100%	40%	43%	57%	42%	57%	58%	25%	100%
25x	30%	100%	50%	100%	30%	43%	57%	42%	57%	50%	25%	100%
30x	25%	100%	38%	100%	25%	37%	43%	33%	43%	42%	25%	100%
40x	25%	100%	38%	100%	25%	33%	43%	30%	43%	42%	13%	100%
50x	20%	100%	25%	100%	20%	27%	29%	25%	29%	33%	13%	100%
60x	20%	100%	25%	100%	20%	20%	29%	20%	29%	33%	13%	100%

**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 **Harveytech@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.

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)													
		Chip Load (IPT) By Cutter Dia			Depth of Cut		Chip Load (IPT) By Cutter Dia					Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial	
<b>ALUMINUM ALLOYS</b>															
Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00020	.00042	.00064	1 x Dia	.08 x Dia	.00073	.00092	.00110	.00147	.00221	.00295	1 x Dia	.20 x Dia
		Roughing	.00025	.00053	.00080	.30 x Dia	.35 x Dia	.00091	.00115	.00137	.00184	.00276	.00369	.60 x Dia	.35 x Dia
		Finishing	.00039	.00080	.00121	.08 x Dia	1.5 x Dia	.00139	.00174	.00208	.00280	.00418	.00559	.15 x Dia	1.5 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Slotting	.00018	.00038	.00057	1 x Dia	.08 x Dia	.00066	.00083	.00099	.00133	.00199	.00265	1 x Dia	.20 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00018	.00038	.00057	1 x Dia	.08 x Dia	.00066	.00083	.00099	.00133	.00199	.00265	1 x Dia	.20 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Slotting	.00018	.00038	.00057	1 x Dia	.08 x Dia	.00066	.00083	.00099	.00133	.00199	.00265	1 x Dia	.20 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Roughing	.00023	.00047	.00072	.30 x Dia	.35 x Dia	.00082	.00104	.00123	.00166	.00248	.00332	.60 x Dia	.35 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475	Roughing	.00023	.00047	.00072	.30 x Dia	.35 x Dia	.00082	.00104	.00123	.00166	.00248	.00332	.60 x Dia	.35 x Dia
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00035	.00072	.00109	.08 x Dia	1.5 x Dia	.00125	.00157	.00187	.00252	.00376	.00503	.15 x Dia	1.5 x Dia
Wrought - 8%-12% Si (4xxx)	800	Finishing	.00035	.00072	.00109	.08 x Dia	1.5 x Dia	.00125	.00157	.00187	.00252	.00376	.00503	.15 x Dia	1.5 x Dia
<b>MAGNESIUM ALLOYS</b>															
	1500	Slotting	.00020	.00042	.00064	1 x Dia	.08 x Dia	.00073	.00092	.00110	.00147	.00221	.00295	1 x Dia	.20 x Dia
		Roughing	.00025	.00053	.00080	.30 x Dia	.35 x Dia	.00091	.00115	.00137	.00184	.00276	.00369	.60 x Dia	.35 x Dia
		Finishing	.00039	.00080	.00121	.08 x Dia	1.5 x Dia	.00139	.00174	.00208	.00280	.00418	.00559	.15 x Dia	1.5 x Dia
<b>ZINC ALLOYS</b>															
	800	Slotting	.00020	.00042	.00064	1 x Dia	.08 x Dia	.00073	.00092	.00110	.00147	.00221	.00295	1 x Dia	.20 x Dia
		Roughing	.00025	.00053	.00080	.30 x Dia	.35 x Dia	.00091	.00115	.00137	.00184	.00276	.00369	.60 x Dia	.35 x Dia
		Finishing	.00039	.00080	.00121	.08 x Dia	1.5 x Dia	.00139	.00174	.00208	.00280	.00418	.00559	.15 x Dia	1.5 x Dia
<b>COPPER ALLOYS</b>															
High Coppers - 90%+ (C1xxx)	225	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00088	.00118	.00177	.00236	1 x Dia	.20 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C6980)	500	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00088	.00118	.00177	.00236	1 x Dia	.20 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)	225	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00088	.00118	.00177	.00236	1 x Dia	.20 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C6500-C6420)	500	Roughing	.00020	.00042	.00064	.30 x Dia	.35 x Dia	.00073	.00092	.00110	.00147	.00221	.00295	.60 x Dia	.35 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500	Roughing	.00020	.00042	.00064	.30 x Dia	.35 x Dia	.00073	.00092	.00110	.00147	.00221	.00295	.60 x Dia	.35 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00088	.00118	.00177	.00236	1 x Dia	.20 x Dia
Cast Copper Alloys (C8300-C8620, C86400-C8790, C92200-C9580, C97300-C9780, C99400-C99700)	550	Finishing	.00031	.00064	.00097	.08 x Dia	1.5 x Dia	.00111	.00140	.00166	.00224	.00335	.00447	.15 x Dia	1.5 x Dia

MATERIAL	SFM	Hardness: 29-37 Rc (279-344 HBn)													
		Chip Load (IPT) By Cutter Dia			Depth of Cut		Chip Load (IPT) By Cutter Dia					Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial	
<b>CARBON STEELS</b>															
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Slotting	.00007	.00014	.00022	1 x Dia	.08 x Dia	.00025	.00032	.00038	.00051	.00076	.00101	1 x Dia	.20 x Dia
		Roughing	.00008	.00016	.00025	.30 x Dia	.35 x Dia	.00028	.00036	.00042	.00057	.00085	.00114	.60 x Dia	.35 x Dia
		Finishing	.00012	.00025	.00038	.08 x Dia	1.5 x Dia	.00043	.00055	.00065	.00087	.00131	.00175	.15 x Dia	1.5 x Dia
1030 - 1095, 1140 - 1151, 113x, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx	200	Slotting	.00006	.00013	.00020	1 x Dia	.08 x Dia	.00023	.00029	.00034	.00046	.00069	.00093	1 x Dia	.20 x Dia
		Roughing	.00007	.00015	.00023	.30 x Dia	.35 x Dia	.00026	.00033	.00039	.00052	.00078	.00104	.60 x Dia	.35 x Dia
		Finishing	.00011	.00023	.00035	.08 x Dia	1.5 x Dia	.00040	.00050	.00059	.00080	.00120	.00160	.15 x Dia	1.5 x Dia
<b>STAINLESS STEELS</b>															
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Slotting	.00007	.00014	.00022	1 x Dia	.08 x Dia	.00025	.00032	.00038	.00051	.00076	.00101	1 x Dia	.20 x Dia
		Roughing	.00008	.00016	.00025	.30 x Dia	.35 x Dia	.00028	.00036	.00042	.00057	.00085	.00114	.60 x Dia	.35 x Dia
		Finishing	.00012	.00025	.00038	.08 x Dia	1.5 x Dia	.00043	.00055	.00065	.00087	.00131	.00175	.15 x Dia	1.5 x Dia
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Slotting	.00006	.00013	.00020	1 x Dia	.08 x Dia	.00023	.00029	.00034	.00046	.00069	.00093	1 x Dia	.20 x Dia
		Roughing	.00007	.00015	.00023	.30 x Dia	.35 x Dia	.00026	.00033	.00039	.00052	.00078	.00104	.60 x Dia	.35 x Dia
		Finishing	.00011	.00023	.00035	.08 x Dia	1.5 x Dia	.00040	.00050	.00059	.00080	.00120	.00160	.15 x Dia	1.5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00004	.00008	.00013	1 x Dia	.08 x Dia	.00014	.00018	.00022	.00029	.00043	.00058	1 x Dia	.20 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	.35 x Dia	.00016	.00020	.00024	.00033	.00049	.00065	.60 x Dia	.35 x Dia
		Finishing	.00007	.00014	.00022	.08 x Dia	1.5 x Dia	.00025	.00031	.00037	.00050	.00075	.00100	.15 x Dia	1.5 x Dia
<b>TOOL STEELS</b>															
A, L, O, P, W series	200	Slotting	.00006	.00013	.00020	1 x Dia	.08 x Dia	.00023	.00029	.00034	.00046	.00069	.00093	1 x Dia	.20 x Dia
		Roughing	.00007	.00015	.00023	.30 x Dia	.35 x Dia	.00026	.00033	.00039	.00052	.00078	.00104	.60 x Dia	.35 x Dia
		Finishing	.00011	.00023	.00035	.08 x Dia	1.5 x Dia	.00040	.00050	.00059	.00080	.00120	.00160	.15 x Dia	1.5 x Dia
D, H, M, T, S series	150	Slotting	.00004	.00008	.00013	1 x Dia	.08 x Dia	.00014	.00018	.00022	.00029	.00043	.00058	1 x Dia	.20 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	.35 x Dia	.00016	.00020	.00024	.00033	.00049	.00065	.60 x Dia	.35 x Dia
		Finishing	.00007	.00014	.00022	.08 x Dia	1.5 x Dia	.00025	.00031	.00037	.00050	.00075	.00100	.15 x Dia	1.5 x Dia
<b>TITANIUM ALLOYS</b>															
	150	Slotting	.00004	.00008	.00013	1 x Dia	.08 x Dia	.00014	.00018	.00022	.00029	.00043	.00058	1 x Dia	.20 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	.35 x Dia	.00016	.00020	.00024	.00033	.00049	.00065	.60 x Dia	.35 x Dia
		Finishing	.00007	.00014	.00022	.08 x Dia	1.5 x Dia	.00025	.00031	.00037	.00050	.00075	.00100	.15 x Dia	1.5 x Dia
<b>HIGH TEMP ALLOYS</b>															
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discology, Incoloy	70	Slotting	.00004	.00008											