



Speeds & Feeds

**Product Table:** High Helix End Mills for Medium Alloy Steels - Ball - Tapered Reach (Mold Cutters)

**Characteristics:** 15° Neck Angle

**Series:** 7739xx-C6

**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	Profiling			Finishing		
	IPT	Radial DOC*	Axial DOC	IPT	Radial DOC*	Axial DOC
5x	100%	100%	100%	100%	100%	100%
8x	83%	100%	100%	83%	100%	100%
10x	79%	100%	100%	79%	100%	100%
15x	66%	77%	77%	66%	80%	100%
20x	59%	77%	77%	59%	80%	100%
25x	52%	77%	62%	52%	80%	80%
30x	45%	62%	62%	45%	60%	60%
40x	45%	62%	38%	45%	60%	50%
50x	45%	46%	31%	45%	50%	40%
60x	45%	46%	23%	45%	50%	30%

\* Radial DOC values represent typical starting parameters. For other finish options, consult a Cusp Height & Finish chart.

**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	Hardness: 29-37 Rc (279-344 HBn)													Hardness: 38-45 Rc (353-421 HBn)															
	SFM	Chip Load (IPT) by Cutter Diameter											Depth of Cut		SFM	Chip Load (IPT) by Cutter Diameter											Depth of Cut		
		.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	Radial	Axial		.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	Radial	Axial	
<b>CARBON STEELS</b> Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Profiling	.00017	.00036	.00054	.00071	.00089	.00107	.00143	.00214	.00286	.00357	.00430	.13 x Dia	.13 x Dia	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Finishing		.00016	.00032	.00049	.00065	.00081	.00097	.00130	.00195	.00260	.00325	.00391	.10 x Dia	.10 x Dia	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	Profiling	.00016	.00032	.00049	.00065	.00082	.00097	.00131	.00196	.00262	.00327	.00393	.13 x Dia	.13 x Dia	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Finishing		.00014	.00030	.00045	.00059	.00074	.00089	.00119	.00178	.00238	.00297	.00357	.10 x Dia	.10 x Dia	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>STAINLESS STEELS</b> 203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Profiling	.00017	.00036	.00054	.00071	.00089	.00107	.00143	.00214	.00286	.00357	.00430	.13 x Dia	.13 x Dia	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Finishing		.00016	.00032	.00049	.00065	.00081	.00097	.00130	.00195	.00260	.00325	.00391	.10 x Dia	.10 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	Profiling	.00016	.00032	.00049	.00065	.00082	.00097	.00131	.00196	.00262	.00327	.00393	.13 x Dia	.13 x Dia	Profiling	.00008	.00016	.00025	.00032	.00041	.00049	.00065	.00098	.00131	.00163	.00196	.13 x Dia	.13 x Dia
Finishing		.00014	.00030	.00045	.00059	.00074	.00089	.00119	.00178	.00238	.00297	.00357	.10 x Dia	.10 x Dia	Finishing	.00007	.00015	.00022	.00030	.00037	.00044	.00060	.00089	.00119	.00149	.00179	.10 x Dia	.10 x Dia	
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Profiling	.00010	.00020	.00031	.00041	.00051	.00061	.00082	.00122	.00164	.00204	.00246	.13 x Dia	.13 x Dia	Profiling	.00005	.00010	.00015	.00020	.00026	.00030	.00041	.00061	.00082	.00102	.00123	.13 x Dia	.13 x Dia
Finishing		.00009	.00018	.00028	.00037	.00046	.00055	.00074	.00111	.00149	.00186	.00223	.10 x Dia	.10 x Dia	Finishing	.00004	.00009	.00014	.00018	.00023	.00028	.00037	.00056	.00074	.00093	.00112	.10 x Dia	.10 x Dia	
<b>TOOL STEELS</b> A, L, O, P, W series	200	Profiling	.00016	.00032	.00049	.00065	.00082	.00097	.00131	.00196	.00262	.00327	.00393	.13 x Dia	.13 x Dia	Profiling	.00008	.00016	.00025	.00032	.00041	.00049	.00065	.00098	.00131	.00163	.00196	.13 x Dia	.13 x Dia
Finishing		.00014	.00030	.00045	.00059	.00074	.00089	.00119	.00178	.00238	.00297	.00357	.10 x Dia	.10 x Dia	Finishing	.00007	.00015	.00022	.00030	.00037	.00044	.00060	.00089	.00119	.00149	.00179	.10 x Dia	.10 x Dia	
D, H, M, T, S series	150	Profiling	.00010	.00020	.00031	.00041	.00051	.00061	.00082	.00122	.00164	.00204	.00246	.13 x Dia	.13 x Dia	Profiling	.00005	.00010	.00015	.00020	.00026	.00030	.00041	.00061	.00082	.00102	.00123	.13 x Dia	.13 x Dia
Finishing		.00009	.00018	.00028	.00037	.00046	.00055	.00074	.00111	.00149	.00186	.00223	.10 x Dia	.10 x Dia	Finishing	.00004	.00009	.00014	.00018	.00023	.00028	.00037	.00056	.00074	.00093	.00112	.10 x Dia	.10 x Dia	
<b>TITANIUM ALLOYS</b>	150	Profiling	.00010	.00020	.00031	.00041	.00051	.00061	.00082	.00122	.00164	.00204	.00246	.13 x Dia	.13 x Dia	Profiling	.00005	.00010	.00015	.00020	.00026	.00030	.00041	.00061	.00082	.00102	.00123	.13 x Dia	.13 x Dia
Finishing		.00009	.00018	.00028	.00037	.00046	.00055	.00074	.00111	.00149	.00186	.00223	.10 x Dia	.10 x Dia	Finishing	.00004	.00009	.00014	.00018	.00023	.00028	.00037	.00056	.00074	.00093	.00112	.10 x Dia	.10 x Dia	
<b>HIGH TEMP ALLOYS</b> Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Profiling	.00010	.00020	.00031	.00041	.00051	.00061	.00082	.00122	.00164	.00204	.00246	.13 x Dia	.13 x Dia	Profiling	.00005	.00010	.00015	.00020	.00026	.00030	.00041	.00061	.00082	.00102	.00123	.13 x Dia	.13 x Dia
Finishing		.00009	.00018	.00028	.00037	.00046	.00055	.00074	.00111	.00149	.00186	.00223	.10 x Dia	.10 x Dia	Finishing	.00004	.00009	.00014	.00018	.00023	.00028	.00037	.00056	.00074	.00093	.00112	.10 x Dia	.10 x Dia	