



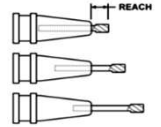
Speeds & Feeds

Product Table: End Mills - Corner Radius - Reduced Shank
Characteristics: 4 Flutes
Series: 176xx, 7662xx

Product Notes:

Reduced shank end mills can be chucked at a variety of reach lengths. Posted values reflect a 3x reach length (ex. a 1/8 diameter mill chucked at a 3/8 reach). When chucking at longer reach lengths, use the table below for Chip Load and Depth of Cut adjustment multipliers.

Table with columns: Reach Multiple, Slottting (Chip Load, Depth of Cut Radial, Axial), Roughing (Chip Load, Depth of Cut Radial, Axial), Finishing (Chip Load, Depth of Cut Radial, Axial). Rows for 3x, 5x, 8x, 12x, 15x, 18x, 20x reach multiples.



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.

Table for Hardness: <= 28 Rc (<= 271 HBn). Columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Diameter (.062 to 1.000), Depth of Cut (Radial, Axial). Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, and COPPER ALLOYS.

Table for Hardness: 29-37 Rc (279-344 HBn). Columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Diameter (.062 to 1.000), Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.

Table for Hardness: 38-45 Rc (353-421 HBn). Columns: SFM, Chip Load (IPT) By Cutter Diameter (.062 to 1.000), Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.