

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)								
		Chip Load (IPR - Inches Per Revolution) By Reamer Diameter								
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
ALUMINUM ALLOYS										
Casting (2xx, 5xx, 7xx, 8xx)	450	.00041	.00084	.00127	.00167	.00211	.00251	.00338	.00505	.00675
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	600									
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	450									
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	420									
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	390	.00036	.00075	.00114	.00151	.00190	.00226	.00304	.00454	.00608
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	350									
Wrought - 5%-8% Si (4xxx)	600									
Wrought - 8%-12% Si (4xxx)	480									
MAGNESIUM ALLOYS	900									
ZINC ALLOYS	480	.00041	.00084	.00127	.00167	.00211	.00251	.00338	.00505	.00675
COPPER ALLOYS										
High Coppers - 90%+ (C1xxx)	170									
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C66400-C69800)	375									
Phosphor Bronzes (Copper Tin alloys, C5xxx)	170	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	375									
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	375									
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	170									
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800)	400									



Speeds & Feeds

Product Table: Miniature Reamers - Right Hand Spiral
Series: RRHxxxx

Product Notes:

In order to maintain appropriate stock removal amounts based on the reamer size, a hole should be pre-drilled at a diameter that is 90-94% of the finished reamed hole diameter. For example, for a finished reamed hole diameter of .0625", the pre-drilled hole diameter should be in the range of .056"-.058". The pre-drilled hole should not be smaller than 85% of the finished reamed hole diameter.

MATERIAL	SFM	Hardness: 29-37 Rc (279-344 HBn)								
		Chip Load (IPR - Inches Per Revolution) By Reamer Diameter								
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
CARBON STEELS										
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	240	.00035	.00073	.00111	.00146	.00184	.00220	.00295	.00442	.00591
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4Lxx, 5xxx & 5Lxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx	150	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540
STAINLESS STEELS										
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	180	.00035	.00073	.00111	.00146	.00184	.00220	.00295	.00442	.00591
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	150	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	125	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338
TOOL STEELS										
A, L, O, P, W series	125	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540
D, H, M, T, S series	90	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338
TITANIUM ALLOYS	100	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338
HIGH TEMP ALLOYS										
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338

SFM	Hardness: 38-45 Rc (353-421 HBn)								
	Chip Load (IPR - Inches Per Revolution) By Reamer Diameter								
	0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-
100	.00026	.00054	.00081	.00107	.00135	.00161	.00216	.00323	.00432
90	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270
100	.00026	.00054	.00081	.00107	.00135	.00161	.00216	.00323	.00432
75	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270
75	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270
50	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270

Please note:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

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.