



Speeds & Feeds

**Product Table:** Miniature End Mills - Corner Radius - Long Reach, Stub Flute  
**Characteristics:** 6x Reach Multiple  
**Series:** 7284xx, 7292xx, 7658xx, 7664xx, 7665xx, 7684xx, 7685xx

**Please note:**

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](mailto: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: ≤ 28 Rc (≤ 271 HBn)																
		SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia						Depth of Cut				
			0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial	
<b>ALUMINUM ALLOYS</b>																		
Casting (2xx, 5xx, 7xx, 8xx)		750	Slotting	.00016	.00032	.00049	1 x Dia	.08 x Dia	.00056	.00071	.00085	.00114	.00170	.00228	.00342	.00455	1 x Dia	.19 x Dia
			Roughing	.00020	.00041	.00062	.29 x Dia	.33 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	.58 x Dia	.33 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)		1000	Finishing	.00030	.00063	.00096	.08 x Dia	1.5 x Dia	.00110	.00138	.00164	.00221	.00331	.00442	.00663	.00884	.15 x Dia	1.5 x Dia
750		Slotting	.00014	.00029	.00044	1 x Dia	.08 x Dia	.00051	.00064	.00076	.00102	.00153	.00205	.00307	.00410	1 x Dia	.19 x Dia	
700		Roughing	.00018	.00037	.00055	.29 x Dia	.33 x Dia	.00064	.00080	.00095	.00128	.00192	.00256	.00384	.00512	.58 x Dia	.33 x Dia	
650		Finishing	.00027	.00057	.00086	.08 x Dia	1.5 x Dia	.00099	.00124	.00148	.00199	.00297	.00398	.00597	.00795	.15 x Dia	1.5 x Dia	
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)																		
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)																		
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)																		
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)																		
Wrought - 5%-8% Si (4xxx)																		
Wrought - 8%-12% Si (4xxx)																		
<b>MAGNESIUM ALLOYS</b>																		
1500		Slotting	.00016	.00032	.00049	1 x Dia	.08 x Dia	.00056	.00071	.00085	.00114	.00170	.00228	.00342	.00455	1 x Dia	.19 x Dia	
			Roughing	.00020	.00041	.00062	.29 x Dia	.33 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	.58 x Dia	.33 x Dia
			Finishing	.00030	.00063	.00096	.08 x Dia	1.5 x Dia	.00110	.00138	.00164	.00221	.00331	.00442	.00663	.00884	.15 x Dia	1.5 x Dia
<b>ZINC ALLOYS</b>																		
800		Slotting	.00013	.00026	.00039	1 x Dia	.08 x Dia	.00045	.00057	.00068	.00091	.00136	.00182	.00273	.00364	1 x Dia	.19 x Dia	
			Roughing	.00016	.00032	.00049	.29 x Dia	.33 x Dia	.00056	.00071	.00085	.00114	.00170	.00228	.00342	.00455	.58 x Dia	.33 x Dia
			Finishing	.00024	.00050	.00076	.08 x Dia	1.5 x Dia	.00088	.00110	.00132	.00177	.00264	.00354	.00530	.00707	.15 x Dia	1.5 x Dia
<b>COPPER ALLOYS</b>																		
High Coppers - 90%+ (C1xxx)		225	Slotting	.00013	.00026	.00039	1 x Dia	.08 x Dia	.00045	.00057	.00068	.00091	.00136	.00182	.00273	.00364	1 x Dia	.19 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C69800)		500	Roughing	.00016	.00032	.00049	.29 x Dia	.33 x Dia	.00056	.00071	.00085	.00114	.00170	.00228	.00342	.00455	.58 x Dia	.33 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)		225	Finishing	.00024	.00050	.00076	.08 x Dia	1.5 x Dia	.00088	.00110	.00132	.00177	.00264	.00354	.00530	.00707	.15 x Dia	1.5 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)		500	Roughing	.00016	.00032	.00049	.29 x Dia	.33 x Dia	.00056	.00071	.00085	.00114	.00170	.00228	.00342	.00455	.58 x Dia	.33 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)		500	Finishing	.00024	.00050	.00076	.08 x Dia	1.5 x Dia	.00088	.00110	.00132	.00177	.00264	.00354	.00530	.00707	.15 x Dia	1.5 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)		225	Slotting	.00013	.00026	.00039	1 x Dia	.08 x Dia	.00045	.00057	.00068	.00091	.00136	.00182	.00273	.00364	1 x Dia	.19 x Dia
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)		550	Finishing	.00024	.00050	.00076	.08 x Dia	1.5 x Dia	.00088	.00110	.00132	.00177	.00264	.00354	.00530	.00707	.15 x Dia	1.5 x Dia

MATERIAL		Hardness: 29-37 Rc (279-344 HBn)																
		SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia						Depth of Cut				
			0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	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	.00005	.00011	.00017	1 x Dia	.08 x Dia	.00019	.00024	.00029	.00039	.00059	.00078	.00117	.00156	1 x Dia	.19 x Dia
			Roughing	.00006	.00013	.00019	.29 x Dia	.33 x Dia	.00022	.00027	.00033	.00044	.00066	.00088	.00132	.00176	.58 x Dia	.33 x Dia
			Finishing	.00010	.00020	.00030	.08 x Dia	1.5 x Dia	.00034	.00043	.00051	.00069	.00103	.00138	.00207	.00276	.15 x Dia	1.5 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx		200	Slotting	.00005	.00010	.00015	1 x Dia	.08 x Dia	.00018	.00022	.00027	.00036	.00054	.00072	.00107	.00143	1 x Dia	.19 x Dia
			Roughing	.00006	.00011	.00017	.29 x Dia	.33 x Dia	.00020	.00025	.00030	.00040	.00060	.00080	.00121	.00161	.58 x Dia	.33 x Dia
			Finishing	.00009	.00018	.00027	.08 x Dia	1.5 x Dia	.00031	.00039	.00047	.00063	.00094	.00126	.00189	.00253	.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	.00005	.00011	.00017	1 x Dia	.08 x Dia	.00019	.00024	.00029	.00039	.00059	.00078	.00117	.00156	1 x Dia	.19 x Dia
			Roughing	.00006	.00013	.00019	.29 x Dia	.33 x Dia	.00022	.00027	.00033	.00044	.00066	.00088	.00132	.00176	.58 x Dia	.33 x Dia
			Finishing	.00010	.00020	.00030	.08 x Dia	1.5 x Dia	.00034	.00043	.00051	.00069	.00103	.00138	.00207	.00276	.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	.00005	.00010	.00015	1 x Dia	.08 x Dia	.00018	.00022	.00027	.00036	.00054	.00072	.00107	.00143	1 x Dia	.19 x Dia
			Roughing	.00006	.00011	.00017	.29 x Dia	.33 x Dia	.00020	.00025	.00030	.00040	.00060	.00080	.00121	.00161	.58 x Dia	.33 x Dia
			Finishing	.00009	.00018	.00027	.08 x Dia	1.5 x Dia	.00031	.00039	.00047	.00063	.00094	.00126	.00189	.00253	.15 x Dia	1.5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7		150	Slotting	.00003	.00006	.00010	1 x Dia	.08 x Dia	.00011	.00014	.00017	.00022	.00033	.00045	.00067	.00089	1 x Dia	.19 x Dia
			Roughing	.00003	.00007	.00011	.29 x Dia	.33 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.00075	.00101	.58 x Dia	.33 x Dia
			Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia
<b>TOOL STEELS</b>																		
A, L, O, P, W series		200	Slotting	.00005	.00010	.00015	1 x Dia	.08 x Dia	.00018	.00022	.00027	.00036	.00054	.00072	.00107	.00143	1 x Dia	.19 x Dia
			Roughing	.00006	.00011	.00017	.29 x Dia	.33 x Dia	.00020	.00025	.00030	.00040	.00060	.00080	.00121	.00161	.58 x Dia	.33 x Dia
			Finishing	.00009	.00018	.00027	.08 x Dia	1.5 x Dia	.00031	.00039	.00047	.00063	.00094	.00126	.00189	.00253	.15 x Dia	1.5 x Dia
D, H, M, T, S series		150	Slotting	.00003	.00006	.00010	1 x Dia	.08 x Dia	.00011	.00014	.00017	.00022	.00033	.00045	.00067	.00089	1 x Dia	.19 x Dia
			Roughing	.00003	.00007	.00011	.29 x Dia	.33 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.00075	.00101	.58 x Dia	.33 x Dia
			Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia
<b>TITANIUM ALLOYS</b>																		
150		Slotting	.00003	.00006	.00010	1 x Dia	.08 x Dia	.00011	.00014	.00017	.00022	.00033	.00045	.00067	.00089	1 x Dia	.19 x Dia	
			Roughing	.00003	.00007	.00011	.29 x Dia	.33 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.00075	.00101	.58 x Dia	.33 x Dia
			Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia
<b>HIGH TEMP ALLOYS</b>																		
70		Slotting	.00003	.00006	.00010	1 x Dia	.08 x Dia	.00011	.00014	.00017	.00022	.00033	.00045	.00067	.00089	1 x Dia	.19 x Dia	
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy			Roughing	.00003	.00007	.00011	.29 x Dia	.33 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.00075	.00101	.58 x Dia	.33 x Dia
			Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia

MATERIAL		Hardness: 38-45 Rc (353-421 HBn)													