



Speeds & Feeds

Product Table: Miniature End Mills - Square - Stub & Standard Characteristics: 1.5x Length of Cut, 4 Flutes Series: 140xx, 503xx

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 harveytch@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 with columns for MATERIAL, SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Hardness: ≤ 28 Rc (≤ 274 HBn), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), and Depth of Cut (Radial, Axial). Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS, and CAST COPPER ALLOYS.

Table with columns for MATERIAL, SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Hardness: 29-37 Rc (279-344 HBn), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), and Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, D. H. M. T. S series, and TITANIUM ALLOYS.

Table with columns for SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Hardness: 38-45 Rc (353-421 HBn), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), and Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, D. H. M. T. S series, and TITANIUM ALLOYS.