HARVEY TOOL

Speeds & Feeds

Product Table: Miniature End Mills - Square - Long Reach, Stub Flute
Characteristics: 13x Reach Multiple
Series: 8393xx, 8394xx

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)															
			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
ALUMINUM ALLOYS		Slotting	.00009	.00019	.00029	1 x Dia	.06 x Dia	.00034	.00042	.00051	.00068	.00102	.00136	.00204	.00272	1 x Dia	.15 x Dia
Casting (2xx, 5xx, 7xx, 8xx)	750	Roughing	.00012	.00024	.00037	.19 x Dia	.25 x Dia	.00042	.00053	.00063	.00085	.00127	.00170	.00255	.00340	.37 x Dia	.25 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00023	.00047	.00072	.05 x Dia	1.5 x Dia	.00082	.00104	.00124	.00166	.00249	.00332	.00499	.00665	.09 x Dia	1.5 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00008	.00017	.00026	1 x Dia	.06 x Dia	.00030	.00038	.00046	.00061	.00092	.00123	.00184	.00245	1 x Dia	.15 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700																
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Roughing	.00011	.00022	.00033	.19 x Dia	.25 x Dia	.00038	.00048	.00057	.00077	.00115	.00153	.00230	.00306	.37 x Dia	.25 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475																
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00021	.00043	.00065	.05 x Dia	1.5 x Dia	.00074	.00093	.00111	.00150	.00224	.00299	.00449	.00598	.09 x Dia	1.5 x Dia
Wrought - 8%-12% Si (4xxx)	800																
MAGNESIUM ALLOYS	1500	Slotting	.00009	.00019	.00029	1 x Dia	.06 x Dia	.00034	.00042	.00051	.00068	.00102	.00136	.00204	.00272	1 x Dia	.15 x Dia
		Roughing	.00012	.00024	.00037	.19 x Dia	.25 x Dia	.00042	.00053	.00063	.00085	.00127	.00170	.00255	.00340	.37 x Dia	.25 x Dia
ZINC ALLOYS	800	Finishing	.00023	.00047	.00072	.05 x Dia	1.5 x Dia	.00082	.00104	.00124	.00166	.00249	.00332	.00499	.00665	.09 x Dia	1.5 x Dia
COPPER ALLOYS																	
High Coppers - 90%+ (C1xxxx)	225	Slotting	.00008	.00016	.00024	1 x Dia	.06 x Dia	.00027	.00034	.00041	.00054	.00081	.00109	.00163	.00218	1 x Dia	.15 x Dia
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500																
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225																
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Roughing	.00009	.00019	.00029	.19 x Dia	.25 x Dia	.00034	.00042	.00051	.00068	.00102	.00136	.00204	.00272	.37 x Dia	.25 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500																
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225																
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Finishing	.00018	.00038	.00057	.05 x Dia	1.5 x Dia	.00066	.00083	.00099	.00133	.00199	.00266	.00399	.00532	.09 x Dia	1.5 x Dia

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**.

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	SFM	Hardness: 29-37 Rc (279-344 HBn)															
			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
CARBON STEELS		Slotting	.00003	.00007	.00010	1 x Dia	.06 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00094	1 x Dia	.15 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Roughing	.00004	.00008	.00011	.19 x Dia	.25 x Dia	.00013	.00016	.00020	.00026	.00039	.00053	.00079	.00105	.37 x Dia	.25 x Dia
		Finishing	.00007	.00015	.00022	.05 x Dia	1.5 x Dia	.00026	.00032	.00039	.00052	.00078	.00104	.00156	.00208	.09 x Dia	1.5 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx		Slotting	.00003	.00006	.00009	1 x Dia	.06 x Dia	.00011	.00013	.00016	.00021	.00032	.00043	.00064	.00086	1 x Dia	.15 x Dia
	200	Roughing	.00003	.00007	.00010	.19 x Dia	.25 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00072	.00096	.37 x Dia	.25 x Dia
		Finishing	.00007	.00014	.00021	.05 x Dia	1.5 x Dia	.00024	.00030	.00035	.00048	.00071	.00095	.00143	.00190	.09 x Dia	1.5 x Dia
STAINLESS STEELS		Slotting	.00003	.00007	.00010	1 x Dia	.06 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00094	1 x Dia	.15 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Roughing	.00004	.00008	.00011	.19 x Dia	.25 x Dia	.00013	.00016	.00020	.00026	.00039	.00053	.00079	.00105	.37 x Dia	.25 x Dia
		Finishing	.00007	.00015	.00022	.05 x Dia	1.5 x Dia	.00026	.00032	.00039	.00052	.00078	.00104	.00156	.00208	.09 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		Slotting	.00003	.00006	.00009	1 x Dia	.06 x Dia	.00011	.00013	.00016	.00021	.00032	.00043	.00064	.00086	1 x Dia	.15 x Dia
	200	Roughing	.00003	.00007	.00010	.19 x Dia	.25 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00072	.00096	.37 x Dia	.25 x Dia
		Finishing	.00007	.00014	.00021	.05 x Dia	1.5 x Dia	.00024	.00030	.00035	.00048	.00071	.00095	.00143	.00190	.09 x Dia	1.5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7		Slotting	.00002	.00004	.00006	1 x Dia	.06 x Dia	.00007	.00008	.00010	.00013	.00020	.00027	.00040	.00053	1 x Dia	.15 x Dia
	150	Roughing	.00002	.00004	.00007	.19 x Dia	.25 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.37 x Dia	.25 x Dia
		Finishing	.00004	.00008	.00013	.05 x Dia	1.5 x Dia	.00015	.00019	.00022	.00030	.00044	.00059	.00089	.00119	.09 x Dia	1.5 x Dia
TOOL STEELS		Slotting	.00003	.00006	.00009	1 x Dia	.06 x Dia	.00011	.00013	.00016	.00021	.00032	.00043	.00064	.00086	1 x Dia	.15 x Dia
A, L, O, P, W series	200	Roughing	.00003	.00007	.00010	.19 x Dia	.25 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00072	.00096	.37 x Dia	.25 x Dia
		Finishing	.00007	.00014	.00021	.05 x Dia	1.5 x Dia	.00024	.00030	.00035	.00048	.00071	.00095	.00143	.00190	.09 x Dia	1.5 x Dia
D, H, M, T, S series		Slotting	.00002	.00004	.00006	1 x Dia	.06 x Dia	.00007	.00008	.00010	.00013	.00020	.00027	.00040	.00053	1 x Dia	.15 x Dia
	150	Roughing	.00002	.00004	.00007	.19 x Dia	.25 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.37 x Dia	.25 x Dia
		Finishing	.00004	.00008	.00013	.05 x Dia	1.5 x Dia	.00015	.00019	.00022	.00030	.00044	.00059	.00089	.00119	.09 x Dia	1.5 x Dia
TITANIUM ALLOYS		Slotting	.00002	.00004	.00006	1 x Dia	.06 x Dia	.00007	.00008	.00010	.00013	.00020	.00027	.00040	.00053	1 x Dia	.15 x Dia
	150	Roughing	.00002	.00004	.00007	.19 x Dia	.25 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.37 x Dia	.25 x Dia
		Finishing	.00004	.00008	.00013	.05 x Dia	1.5 x Dia	.00015	.00019	.00022	.00030	.00044	.00059	.00089	.00119	.09 x Dia	1.5 x Dia
HIGH TEMP ALLOYS		Slotting	.00002	.00004	.00006	1 x Dia	.06 x Dia	.00007	.00008	.00010	.00013	.00020	.00027	.00040	.00053	1 x Dia	.15 x Dia
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Roughing	.00002	.00004	.00007	.19 x Dia	.25 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.37 x Dia	.25 x Dia
		Finishing	.00004	.00008	.00013	.05 x Dia	1.5 x Dia	.00015	.00019	.00022	.00030	.00044	.00059	.00089	.00119	.09 x Dia	1.5 x Dia

SFM	Hardness: 38-45 Rc (353-421 HBn)															
		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
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
100	Slotting	.00001	.00003	.00005	1 x Dia	.06 x Dia	.00005	.00007	.00008	.00011	.00016	.00021	.00032	.00043	1 x Dia	.15 x Dia
	Roughing	.00002	.00003	.00005	.19 x Dia	.25 x Dia	.00006	.00008	.00009	.00012	.00018	.00024	.00036	.00048	.37 x Dia	.25 x Dia
	Finishing	.00003	.00007	.00010	.05 x Dia	1.5 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00072	.00096	.09 x Dia	1.5 x Dia
90	Slotting	.00001	.00002	.00003	1 x Dia	.06 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.00020	.00027	1 x Dia	.15 x Dia
	Roughing	.00001	.00002	.00003	.19 x Dia	.25 x Dia	.00004	.00005	.00006	.00008	.00011	.00015	.00023	.00030	.37 x Dia	.25 x Dia
	Finishing	.00002	.00004	.00006	.05 x Dia	1.5 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.09 x Dia	1.5 x Dia
100	Slotting	.00001	.00003	.00005	1 x Dia	.06 x Dia	.00005	.00007	.00008	.00011	.00016	.00021	.00032	.00043	1 x Dia	.15 x Dia
	Roughing	.00002	.00003	.00005	.19 x Dia	.25 x Dia	.00006	.00008	.00009	.00012	.00018	.00024	.00036	.00048	.37 x Dia	.25 x Dia
	Finishing	.00003	.00007	.00010	.05 x Dia	1.5 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00072	.00096	.09 x Dia	1.5 x Dia
90	Slotting	.00001	.00002	.00003	1 x Dia	.06 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.00020	.00027	1 x Dia	.15 x Dia
	Roughing	.00001	.00002	.00003	.19 x Dia	.25 x Dia	.00004	.00005	.00006	.00008	.00011	.00015	.00023	.00030	.37 x Dia	.25 x Dia
	Finishing	.00002	.00004	.00006	.05 x Dia	1.5 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.09 x Dia	1.5 x Dia
75	Slotting	.00001	.00002	.00003	1 x Dia	.06 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.00020	.00027	1 x Dia	.15 x Dia
	Roughing	.00001	.00002	.00003	.19 x Dia	.25 x Dia	.00004	.00005	.00006	.00008	.00011	.00015	.00023	.00030	.37 x Dia	.25 x Dia
	Finishing	.00002	.00004	.00006	.05 x Dia	1.5 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.09 x Dia	1.5 x Dia
50	Slotting	.00001	.00002	.00003	1 x Dia	.06 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.00020	.00027	1 x Dia	.15 x Dia
	Roughing	.00001	.00002	.00003	.19 x Dia	.25 x Dia	.00004	.00005	.00006	.00008	.00011	.00015	.00023	.00030	.37 x Dia	.25 x Dia
	Finishing	.00002	.00004	.00006	.05 x Dia	1.5 x Dia	.00007	.00009	.00011	.00015	.00022	.00030	.00045	.00060	.09 x Dia	1.5 x Dia