HARVEY TOOL

Speeds & Feeds

Product Table: Miniature End Mills - Tapered - Ball
Characteristics: 16°-20° Angle per Side, 5x Length of Cut
Series: 8021xx

Hardness: ≤ 28 Rc (≤ 271 HBn)

MATERIAL	SFM		Chip Load (IPT) By Cutter Dia .015	.031	.047	Depth of Cut Radial	Axial	Chip Load (IPT) By Cutter Dia .062	.078	.093	.125	.187	.250	Depth of Cut Radial	Axial
ALUMINUM ALLOYS															
Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00089	.00119	.00178	.00238	1 x Dia	.20 x Dia
		Roughing	.00010	.00021	.00032	.13 x Dia	5 x Dia	.00037	.00046	.00055	.00074	.00111	.00149	.25 x Dia	5 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00019	.00040	.00061	.05 x Dia	5 x Dia	.00070	.00088	.00105	.00141	.00211	.00282	.10 x Dia	5 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00015	.00031	.00046	1 x Dia	.08 x Dia	.00053	.00067	.00080	.00107	.00160	.00214	1 x Dia	.20 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	.00009	.00019	.00029	.13 x Dia	5 x Dia	.00033	.00042	.00050	.00067	.00100	.00134	.25 x Dia	5 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475														
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00018	.00036	.00055	.05 x Dia	5 x Dia	.00063	.00079	.00094	.00127	.00190	.00254	.10 x Dia	5 x Dia
Wrought - 8%-12% Si (4xxx)	800														
MAGNESIUM ALLOYS	1500	Slotting	.00016	.00034	.00051	1 x Dia	.08 x Dia	.00059	.00074	.00089	.00119	.00178	.00238	1 x Dia	.20 x Dia
		Roughing	.00010	.00021	.00032	.13 x Dia	5 x Dia	.00037	.00046	.00055	.00074	.00111	.00149	.25 x Dia	5 x Dia
ZINC ALLOYS	800	Finishing	.00019	.00040	.00061	.05 x Dia	5 x Dia	.00070	.00088	.00105	.00141	.00211	.00282	.10 x Dia	5 x Dia
COPPER ALLOYS															
High Coppers - 90%+ (C1xxxx)	225	Slotting	.00013	.00027	.00041	1 x Dia	.08 x Dia	.00047	.00059	.00071	.00095	.00142	.00190	1 x Dia	.20 x Dia
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500														
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225	Roughing	.00008	.00017	.00026	.13 x Dia	5 x Dia	.00030	.00037	.00044	.00060	.00089	.00119	.25 x Dia	5 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500														
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	.00016	.00032	.00049	.05 x Dia	5 x Dia	.00056	.00070	.00084	.00113	.00169	.00226	.10 x Dia	5 x Dia

Product Notes:
Use the end diameter of the tool to select the correct Chip Load (IPT)

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.

Hardness: 29-37 Rc (279-344 HBn)

MATERIAL	SFM		Chip Load (IPT) By Cutter Dia .015	.031	.047	Depth of Cut Radial	Axial	Chip Load (IPT) By Cutter Dia .062	.078	.093	.125	.187	.250	Depth of Cut Radial	Axial
CARBON STEELS															
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00020	.00026	.00030	.00041	.00061	.00082	1 x Dia	.20 x Dia
		Roughing	.00003	.00007	.00010	.13 x Dia	5 x Dia	.00011	.00014	.00017	.00023	.00034	.00046	.25 x Dia	5 x Dia
		Finishing	.00006	.00013	.00019	.05 x Dia	5 x Dia	.00022	.00028	.00033	.00044	.00066	.00088	.10 x Dia	5 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	Slotting	.00005	.00011	.00016	1 x Dia	.08 x Dia	.00019	.00023	.00028	.00037	.00056	.00075	1 x Dia	.20 x Dia
		Roughing	.00003	.00006	.00009	.13 x Dia	5 x Dia	.00010	.00013	.00016	.00021	.00031	.00042	.25 x Dia	5 x Dia
		Finishing	.00006	.00011	.00017	.05 x Dia	5 x Dia	.00020	.00025	.00030	.00040	.00060	.00081	.10 x Dia	5 x Dia
STAINLESS STEELS															
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00020	.00026	.00030	.00041	.00061	.00082	1 x Dia	.20 x Dia
		Roughing	.00003	.00007	.00010	.13 x Dia	5 x Dia	.00011	.00014	.00017	.00023	.00034	.00046	.25 x Dia	5 x Dia
		Finishing	.00006	.00013	.00019	.05 x Dia	5 x Dia	.00022	.00028	.00033	.00044	.00066	.00088	.10 x Dia	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	.00011	.00016	1 x Dia	.08 x Dia	.00019	.00023	.00028	.00037	.00056	.00075	1 x Dia	.20 x Dia
		Roughing	.00003	.00006	.00009	.13 x Dia	5 x Dia	.00010	.00013	.00016	.00021	.00031	.00042	.25 x Dia	5 x Dia
		Finishing	.00006	.00011	.00017	.05 x Dia	5 x Dia	.00020	.00025	.00030	.00040	.00060	.00081	.10 x Dia	5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00003	.00007	.00010	1 x Dia	.08 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	1 x Dia	.20 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	5 x Dia	.00007	.00008	.00010	.00013	.00020	.00026	.25 x Dia	5 x Dia
		Finishing	.00003	.00007	.00011	.05 x Dia	5 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.10 x Dia	5 x Dia
TOOL STEELS															
A, L, O, P, W series	200	Slotting	.00005	.00011	.00016	1 x Dia	.08 x Dia	.00019	.00023	.00028	.00037	.00056	.00075	1 x Dia	.20 x Dia
		Roughing	.00003	.00006	.00009	.13 x Dia	5 x Dia	.00010	.00013	.00016	.00021	.00031	.00042	.25 x Dia	5 x Dia
		Finishing	.00006	.00011	.00017	.05 x Dia	5 x Dia	.00020	.00025	.00030	.00040	.00060	.00081	.10 x Dia	5 x Dia
D, H, M, T, S series	150	Slotting	.00003	.00007	.00010	1 x Dia	.08 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	1 x Dia	.20 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	5 x Dia	.00007	.00008	.00010	.00013	.00020	.00026	.25 x Dia	5 x Dia
		Finishing	.00003	.00007	.00011	.05 x Dia	5 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.10 x Dia	5 x Dia
TITANIUM ALLOYS	150	Slotting	.00003	.00007	.00010	1 x Dia	.08 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	1 x Dia	.20 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	5 x Dia	.00007	.00008	.00010	.00013	.00020	.00026	.25 x Dia	5 x Dia
		Finishing	.00003	.00007	.00011	.05 x Dia	5 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.10 x Dia	5 x Dia
HIGH TEMP ALLOYS															
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Slotting	.00003	.00007	.00010	1 x Dia	.08 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	1 x Dia	.20 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	5 x Dia	.00007	.00008	.00010	.00013	.00020	.00026	.25 x Dia	5 x Dia
		Finishing	.00003	.00007	.00011	.05 x Dia	5 x Dia	.00012	.00016	.00019	.00025	.00038	.00050	.10 x Dia	5 x Dia

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

SFM		Chip Load (IPT) By Cutter Dia .015	.031	.047	Depth of Cut Radial	Axial	Chip Load (IPT) By Cutter Dia .062	.078	.093	.125	.187	.250	Depth of Cut Radial	Axial
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-
100	Slotting	.00003	.00005	.00008	1 x Dia	.08 x Dia	.00009	.00012	.00014	.00019	.00028	.00037	1 x Dia	.20 x Dia
	Roughing	.00001	.00003	.00005	.13 x Dia	5 x Dia	.00005	.00007	.00008	.00011	.00016	.00021	.25 x Dia	5 x Dia
	Finishing	.00003	.00006	.00009	.05 x Dia	5 x Dia	.00010	.00013	.00015	.00020	.00030	.00041	.10 x Dia	5 x Dia
90	Slotting	.00002	.00003	.00005	1 x Dia	.08 x Dia	.00006	.00007	.00009	.00012	.00017	.00023	1 x Dia	.20 x Dia
	Roughing	.00001	.00002	.00003	.13 x Dia	5 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.25 x Dia	5 x Dia
	Finishing	.00002	.00004	.00005	.05 x Dia	5 x Dia	.00006	.00008	.00009	.00013	.00019	.00025	.10 x Dia	5 x Dia
100	Slotting	.00003	.00005	.00008	1 x Dia	.08 x Dia	.00009	.00012	.00014	.00019	.00028	.00037	1 x Dia	.20 x Dia
	Roughing	.00001	.00003	.00005	.13 x Dia	5 x Dia	.00005	.00007	.00008	.00011	.00016	.00021	.25 x Dia	5 x Dia
	Finishing	.00003	.00006	.00009	.05 x Dia	5 x Dia	.00010	.00013	.00015	.00020	.00030	.00041	.10 x Dia	5 x Dia
90	Slotting	.00002	.00003	.00005	1 x Dia	.08 x Dia	.00006	.00007	.00009	.00012	.00017	.00023	1 x Dia	.20 x Dia
	Roughing	.00001	.00002	.00003	.13 x Dia	5 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.25 x Dia	5 x Dia
	Finishing	.00002	.00004	.00005	.05 x Dia	5 x Dia	.00006	.00008	.00009	.00013	.00019	.00025	.10 x Dia	5 x Dia
75	Slotting	.00002	.00003	.00005	1 x Dia	.08 x Dia	.00006	.00007	.00009	.00012	.00017	.00023	1 x Dia	.20 x Dia
	Roughing	.00001	.00002	.00003	.13 x Dia	5 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.25 x Dia	5 x Dia
	Finishing	.00002	.00004	.00005	.05 x Dia	5 x Dia	.00006	.00008	.00009	.00013	.00019	.00025	.10 x Dia	5 x Dia
50	Slotting	.00002	.00003	.00005	1 x Dia	.08 x Dia	.00006	.00007	.00009	.00012	.00017	.00023	1 x Dia	.20 x Dia
	Roughing	.00001	.00002	.00003	.13 x Dia	5 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.25 x Dia	5 x Dia
	Finishing	.00002	.00004	.00005	.05 x Dia	5 x Dia	.00006	.00008	.00009	.00013	.00019	.00025	.10 x Dia	5 x Dia