



# Speeds & Feeds

**Product Table:** Multi-Axis Finishers for High Temp Alloys - Lens Form  
**Characteristics:** 4 Flutes  
**Series:** 6984xx-C10, 6985xx-C10

Material	Hardness (HBn)	SFM										Depth of Cut	
				0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial
Stainless Steels: 40x, 41x, 42x, 43x, 44x, 13-8, 15-5, 15-7, 17-4, 17-7	275 - 300	400	Finishing	.00096	.00100	.00103	.00110	.00130	.00150	.00170	.00200	.025 x Dia x Benefit Multiple	.005"-.010"
	300 - 350	350	Finishing	.00085	.00089	.00092	.00110	.00120	.00140	.00160	.00180		
Tool Steels: D , H, M, T, S series	300 - 350	500	Finishing	.00096	.00100	.00104	.00120	.00130	.00150	.00170	.00200	.025 x Dia x Benefit Multiple	.005"-.010"
	350 - 400	450	Finishing	.00094	.00098	.00101	.00110	.00120	.00140	.00150	.00180		
	400 - 540	400	Finishing	.00083	.00086	.00089	.00100	.00110	.00120	.00140	.00160		
Titanium: All alloys	275 - 300	300	Finishing	.00108	.00113	.00117	.00130	.00150	.00170	.00190	.00220	.025 x Dia x Benefit Multiple	.005"-.010"
	300 - 350	250											
	350 - 400	200	Finishing	.00098	.00102	.00106	.00120	.00140	.00160	.00180	.00210	.025 x Dia x Benefit Multiple	.005"-.010"
	400 - 425	150											
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	275 - 300	200	Finishing	.00086	.00090	.00094	.00110	.00130	.00140	.00160	.00190	.025 x Dia x Benefit Multiple	.005"-.010"
	300 - 350	180											
	350 - 400	150	Finishing	.00084	.00088	.00091	.00100	.00110	.00130	.00150	.00170	.025 x Dia x Benefit Multiple	.005"-.010"
	400 - 425	120											

**Please note:**  
 All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. If less than minimum Axial or Radial DOC values are used, increased feed rates are possible. If greater than maximum Axial or Radial DOC values are used, decreased feed rates may be needed.  
 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 **tech@harveytool.com**.