



Product Table: Miniature End Mills - Ball - Long Reach, Standard Flute
Characteristics: 15x Reach Multiple, 4 Flutes
Series: 8612xx, 8613xx

Table for Hardness: ≤ 28 Rc (≤ 271 HBn) with columns for Material, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Cutter Dia parameters.

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.

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 Harveych@harveymach.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 for Hardness: 29-37 Rc (279-344 HBn) with columns for Material, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Cutter Dia parameters.

Table for Hardness: 38-45 Rc (353-421 HBn) with columns for Material, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Cutter Dia parameters.