



**Product Table:** Miniature End Mills - Corner Chamfer - Standard  
**Characteristics:** 1.5x, Length of Cut, 4 Flutes  
**Series:** 7271xx, 7272xx, 7274xx

**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](mailto: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: ≤ 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	750	Slotting	.00017	.00035	.00052	1 x Dia	.20 x Dia	.00060	.00076	.00090	.00121	.00181	.00242	.00363	.00484	1 x Dia	.50 x Dia
		Roughing	.00022	.00045	.00068	.30 x Dia	1 x Dia	.00078	.00099	.00118	.00158	.00237	.00316	.00474	.00633	60 x Dia	1 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00024	.00050	.00075	.13 x Dia	1 x Dia	.00086	.00108	.00129	.00174	.00260	.00348	.00521	.00695	.25 x Dia	1 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia
		Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	60 x Dia	1 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia
		Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	60 x Dia	1 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia
		Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	60 x Dia	1 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia
		Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	60 x Dia	1 x Dia
Wrought - 5%-8% Si (4xxx)	1000	Slotting	.00017	.00035	.00052	1 x Dia	.20 x Dia	.00060	.00076	.00090	.00121	.00181	.00242	.00363	.00484	1 x Dia	.50 x Dia
		Roughing	.00022	.00045	.00068	.30 x Dia	1 x Dia	.00078	.00099	.00118	.00158	.00237	.00316	.00474	.00633	60 x Dia	1 x Dia
Wrought - 8%-12% Si (4xxx)	800	Slotting	.00017	.00035	.00052	1 x Dia	.20 x Dia	.00060	.00076	.00090	.00121	.00181	.00242	.00363	.00484	1 x Dia	.50 x Dia
		Roughing	.00022	.00045	.00068	.30 x Dia	1 x Dia	.00078	.00099	.00118	.00158	.00237	.00316	.00474	.00633	60 x Dia	1 x Dia
MAGNESIUM ALLOYS	1500	Finishing	.00024	.00050	.00075	.13 x Dia	1 x Dia	.00086	.00108	.00129	.00174	.00260	.00348	.00521	.00695	.25 x Dia	1 x Dia
ZINC ALLOYS	800	Finishing	.00024	.00050	.00075	.13 x Dia	1 x Dia	.00086	.00108	.00129	.00174	.00260	.00348	.00521	.00695	.25 x Dia	1 x Dia
COPPER ALLOYS	225	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
High Coppers - 90%+ (C1xxx)	500	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C69800)	225	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)	500	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225	Slotting	.00013	.00028	.00042	1 x Dia	.20 x Dia	.00048	.00060	.00072	.00097	.00145	.00194	.00290	.00387	1 x Dia	.50 x Dia
		Roughing	.00017	.00036	.00055	.30 x Dia	1 x Dia	.00063	.00079	.00094	.00127	.00189	.00253	.00380	.00506	60 x Dia	1 x Dia
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Slotting	.00017	.00035	.00052	1 x Dia	.20 x Dia	.00060	.00076	.00090	.00121	.00181	.00242	.00363	.00484	1 x Dia	.50 x Dia
		Roughing	.00022	.00045	.00068	.30 x Dia	1 x Dia	.00078	.00099	.00118	.00158	.00237	.00316	.00474	.00633	60 x Dia	1 x Dia

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	600	Slotting	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	.00125	.00166	1 x Dia	.50 x Dia
		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	60 x Dia	1 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.00163	.00217	.25 x Dia	1 x Dia
		Slotting	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	1 x Dia	.50 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4xLxx, 50xx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx	200	Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.00149	.00199	.25 x Dia	1 x Dia
STAINLESS STEELS	450	Slotting	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	.00125	.00166	1 x Dia	.50 x Dia
		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	60 x Dia	1 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.00163	.00217	.25 x Dia	1 x Dia
		Slotting	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	1 x Dia	.50 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	Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.00149	.00199	.25 x Dia	1 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	.20 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00071	.00095	1 x Dia	.50 x Dia
		Roughing	.00004	.00008	.00012	.30 x Dia	1 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	60 x Dia	1 x Dia
TOOL STEELS	200	Finishing	.00004	.00009	.00013	.13 x Dia	1 x Dia	.00015	.00019	.00023	.00031	.00046	.00062	.00093	.00124	.25 x Dia	1 x Dia
		Slotting	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	1 x Dia	.50 x Dia
A, L, O, P, W series	200	Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.00149	.00199	.25 x Dia	1 x Dia
D, H, M, T, S series	150	Slotting	.00003	.00007	.00010	1 x Dia	.20 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00071	.00095	1 x Dia	.50 x Dia
		Roughing	.00004	.00008	.00012	.30 x Dia	1 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	60 x Dia	1 x Dia
TITANIUM ALLOYS	150	Finishing	.00004	.00009	.00013	.13 x Dia	1 x Dia	.00015	.00019	.00023	.00031	.00046	.00062	.00093	.00124	.25 x Dia	1 x Dia
		Slotting	.00003	.00007	.00010	1 x Dia	.20 x Dia	.00012	.00015	.00018	.00024	.00036	.00048	.00071	.00095	1 x Dia	.50 x Dia
HIGH TEMP ALLOYS	70	Roughing	.00004	.00008	.00012	.30 x Dia	1 x Dia	.00014	.00017	.00021	.00028	.00042	.00056				