



Speeds & Feeds

Product Table: Variable Helix End Mills for Aluminum Alloys - Square - Long Reach, Stub Flute
Characteristics: 7x Reach Multiple
Series: 8139xx, 8139xx, 8139xx-C8, 8140xx-C8

Cutter Series	MATERIAL	SFM	Chip Load (IPT) By Cutter Diameter											Depth of Cut			
			0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.500	Radial	Axial	
Uncoated	ALUMINUM ALLOYS																
	Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00017	.00036	.00054	.00071	.00090	.00107	.00144	.00215	.00287	.00376	.00452	.00603	1x Dia	.4x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Roughing	.00020	.00042	.00063	.00083	.00105	.00125	.00167	.00251	.00335	.00439	.00528	.00703	.4x Dia	.5x - 1x Dia
	MAGNESIUM ALLOYS	1500	Finishing	.00022	.00045	.00067	.00089	.00112	.00134	.00179	.00268	.00359	.00470	.00565	.00754	.1x Dia	.5x - 1x Dia
	ZINC ALLOYS	800	Max	.00023	.00047	.00072	.00095	.00119	.00142	.00191	.00286	.00383	.00502	.00603	.00804	-	-
	COPPER ALLOYS																
	High Coppers - 90%+ (C1xxxx)	225	Slotting	.00014	.00028	.00043	.00057	.00072	.00085	.00115	.00172	.00230	.00301	.00362	.00482	1x Dia	.4x Dia
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500	Roughing	.00016	.00033	.00050	.00066	.00084	.00100	.00134	.00200	.00268	.00351	.00422	.00563	.4x Dia	.5x - 1x Dia
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225		.00017	.00036	.00054	.00071	.00090	.00107	.00144	.00215	.00287	.00376	.00452	.00603	.1x Dia	.5x - 1x Dia
	Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Finishing	.00017	.00036	.00054	.00071	.00090	.00107	.00144	.00215	.00287	.00376	.00452	.00603	.1x Dia	.5x - 1x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500	.00018		.00038	.00058	.00076	.00096	.00114	.00153	.00229	.00306	.00401	.00482	.00643	-	-	
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225	Max	.00018	.00038	.00058	.00076	.00096	.00114	.00153	.00229	.00306	.00401	.00482	.00643	-	-	
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550		.00022	.00046	.00070	.00093	.00116	.00139	.00187	.00279	.00373	.00489	.00588	.00784	1x Dia	.4x Dia	
TiB2	ALUMINUM ALLOYS																
	Casting (2xx, 5xx, 7xx, 8xx)	1000	Slotting	.00022	.00046	.00070	.00093	.00116	.00139	.00187	.00279	.00373	.00489	.00588	.00784	1x Dia	.4x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1400	Roughing	.00026	.00054	.00082	.00108	.00136	.00162	.00218	.00326	.00435	.00571	.00686	.00914	.4x Dia	.5x - 1x Dia
	MAGNESIUM ALLOYS	2000	Finishing	.00028	.00058	.00088	.00116	.00146	.00174	.00233	.00349	.00467	.00611	.00735	.00980	.1x Dia	.5x - 1x Dia
ZINC ALLOYS	1100	Max	.00030	.00062	.00094	.00123	.00155	.00185	.00249	.00372	.00498	.00652	.00784	.01045			
Amorphous Diamond	ALUMINUM (High Silicon)																
	Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	2500	Slotting	.00019	.00039	.00059	.00078	.00099	.00117	.00158	.00236	.00316	.00414	.00497	.00663	1x Dia	.3x Dia
	Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	2000	Roughing	.00022	.00046	.00069	.00091	.00115	.00137	.00184	.00276	.00368	.00483	.00580	.00774	.3x Dia	.3x - .8x Dia
	Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1500		.00024	.00049	.00074	.00098	.00123	.00147	.00197	.00295	.00395	.00517	.00622	.00829	.1x Dia	.5x - 1x Dia
	Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1000	Finishing	.00024	.00049	.00074	.00098	.00123	.00147	.00197	.00295	.00395	.00517	.00622	.00829	.1x Dia	.5x - 1x Dia
	Wrought - 5%-8% Si (4xxx)	2200		Max	.00025	.00052	.00079	.00104	.00131	.00157	.00211	.00315	.00421	.00552	.00663	.00884	-
	Wrought - 8%-12% Si (4xxx)	1700	.00015		.00031	.00047	.00063	.00079	.00094	.00126	.00189	.00253	.00331	.00398	.00531	1x Dia	.3x Dia
	COPPER ALLOYS																
	High Coppers - 90%+ (C1xxxx)	800	Slotting	.00015	.00031	.00047	.00063	.00079	.00094	.00126	.00189	.00253	.00331	.00398	.00531	1x Dia	.3x Dia
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	1500		Roughing	.00018	.00037	.00055	.00073	.00092	.00110	.00147	.00220	.00295	.00386	.00464	.00619	.3x Dia
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	800	Finishing		.00019	.00039	.00059	.00078	.00099	.00117	.00158	.00236	.00316	.00414	.00497	.00663	.1x Dia
	Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	1000		Max	.00020	.00042	.00063	.00084	.00105	.00125	.00168	.00252	.00337	.00441	.00531	.00707	-
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	1000	Max	.00020		.00042	.00063	.00084	.00105	.00125	.00168	.00252	.00337	.00441	.00531	.00707	-	-
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	800		Max	.00020	.00042	.00063	.00084	.00105	.00125	.00168	.00252	.00337	.00441	.00531	.00707	-	-
Cast Copper Alloys (C80100-C82800, C86300, C90200-C91700, C96200-C96600, C99300)	150	Max		.00020	.00042	.00063	.00084	.00105	.00125	.00168	.00252	.00337	.00441	.00531	.00707	-	-
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	750																

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 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.