



Speeds & Feeds

Product Table: Miniature End Mills - Square - Stub & Standard
Characteristics: 0.8x Length of Cut, 2 Flutes
Series: 7334xx, 7335xx

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.

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	.00023	.00047	.00071	1 x Dia	.25 x Dia	.00082	.00103	.00123	.00165	.00247	.00330	.00495	.00660	1 x Dia	.50 x Dia
		Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00033	.00068	.00103	.16 x Dia	0.8 x Dia	.00119	.00149	.00178	.00239	.00358	.00478	.00717	.00956	.35 x Dia	0.08 x Dia
		Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
		Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
		Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
		Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475	Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
		Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00030	.00061	.00093	.16 x Dia	0.8 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	.35 x Dia	0.08 x Dia
		Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
Wrought - 8%-12% Si (4xxx)	800	Finishing	.00030	.00061	.00093	.16 x Dia	0.8 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	.35 x Dia	0.08 x Dia
		Slotting	.00020	.00042	.00064	1 x Dia	.25 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.50 x Dia
MAGNESIUM ALLOYS	1500	Slotting	.00023	.00047	.00071	1 x Dia	.25 x Dia	.00082	.00103	.00123	.00165	.00247	.00330	.00495	.00660	1 x Dia	.50 x Dia
ZINC ALLOYS	800	Roughing	.00030	.00061	.00093	.30 x Dia	1 x Dia	.00107	.00134	.00160	.00215	.00321	.00430	.00645	.00859	60 x Dia	1 x Dia
		Finishing	.00033	.00068	.00103	.16 x Dia	0.8 x Dia	.00119	.00149	.00178	.00239	.00358	.00478	.00717	.00956	.35 x Dia	0.08 x Dia
COPPER ALLOYS	225	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
High Coppers - 90%+ (C1xxx)	500	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C69800)	225	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)	500	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225	Slotting	.00018	.00038	.00057	1 x Dia	.25 x Dia	.00065	.00082	.00098	.00132	.00197	.00264	.00396	.00528	1 x Dia	.50 x Dia
		Roughing	.00024	.00049	.00074	.30 x Dia	1 x Dia	.00085	.00107	.00128	.00172	.00257	.00344	.00516	.00688	60 x Dia	1 x Dia
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Finishing	.00026	.00055	.00083	.16 x Dia	0.8 x Dia	.00095	.00119	.00142	.00191	.00286	.00382	.00574	.00765	.35 x Dia	0.08 x Dia
		Slotting	.00023	.00047	.00071	1 x Dia	.25 x Dia	.00082	.00103	.00123	.00165	.00247	.00330	.00495	.00660	1 x Dia	.50 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	.00008	.00016	.00025	1 x Dia	.25 x Dia	.00028	.00035	.00042	.00057	.00085	.00113	.00170	.00227	1 x Dia	.50 x Dia
		Roughing	.00009	.00019	.00029	.30 x Dia	1 x Dia	.00033	.00041	.00049	.00066	.00099	.00133	.00199	.00266	60 x Dia	1 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	200	Finishing	.00010	.00021	.00032	.16 x Dia	0.8 x Dia	.00037	.00047	.00056	.00075	.00112	.00149	.00224	.00299	.35 x Dia	0.08 x Dia
		Slotting	.00007	.00015	.00022	1 x Dia	.25 x Dia	.00026	.00032	.00039	.00052	.00078	.00104	.00156	.00207	1 x Dia	.50 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4Lxx, 5xxx & 5Lxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx	200	Roughing	.00008	.00017	.00026	.30 x Dia	1 x Dia	.00030	.00038	.00045	.00061	.00091	.00122	.00182	.00243	60 x Dia	1 x Dia
		Finishing	.00009	.00019	.00030	.16 x Dia	0.8 x Dia	.00034	.00043	.00051	.00068	.00102	.00137	.00205	.00273	.35 x Dia	0.08 x Dia
STAINLESS STEELS	450	Slotting	.00008	.00016	.00025	1 x Dia	.25 x Dia	.00028	.00035	.00042	.00057	.00085	.00113	.00170	.00227	1 x Dia	.50 x Dia
		Roughing	.00009	.00019	.00029	.30 x Dia	1 x Dia	.00033	.00041	.00049	.00066	.00099	.00133	.00199	.00266	60 x Dia	1 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	200	Finishing	.00010	.00021	.00032	.16 x Dia	0.8 x Dia	.00037	.00047	.00056	.00075	.00112	.00149	.00224	.00299	.35 x Dia	0.08 x Dia
		Slotting	.00007	.00015	.00022	1 x Dia	.25 x Dia	.00026	.00032	.00039	.00052	.00078	.00104	.00156	.00207	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	.00008	.00017	.00026	.30 x Dia	1 x Dia	.00030	.00038	.00045	.00061	.00091	.00122	.00182	.00243	60 x Dia	1 x Dia
		Finishing	.00009	.00019	.00030	.16 x Dia	0.8 x Dia	.00034	.00043	.00051	.00068	.00102	.00137	.00205	.00273	.35 x Dia	0.08 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00004	.00009	.00014	1 x Dia	.25 x Dia	.00016	.00020	.00024	.00032	.00048	.00065	.00097	.00130	1 x Dia	.50 x Dia
		Roughing	.00005	.00011	.00016	.30 x Dia	1 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	60 x Dia	1 x Dia
TOOL STEELS	200	Finishing	.00006	.00012	.00018	.16 x Dia	0.8 x Dia	.00021	.00027	.00032	.00043	.00064	.00085	.00128	.00171	.35 x Dia	0.08 x Dia
		Slotting	.00007	.00015	.00022	1 x Dia	.25 x Dia	.00026	.00032	.00039	.00052	.00078	.00104	.00156	.00207	1 x Dia	.50 x Dia
A, L, O, P, W series	150	Roughing	.00008	.00017	.00026	.30 x Dia	1 x Dia	.00030	.00038	.00045	.00061	.00091	.00122	.00182	.00243	60 x Dia	1 x Dia
		Finishing	.00009	.00019	.00030	.16 x Dia	0.8 x Dia	.00034	.00043	.00051	.00068	.00102	.00137	.00205	.00273	.35 x Dia	0.08 x Dia
D, H, M, T, S series	150	Slotting	.00004	.00009	.00014	1 x Dia	.25 x Dia	.00016	.00020	.00024	.00032	.00048	.00065	.00097	.00130	1 x Dia	.50 x Dia
		Roughing	.00005	.00011	.00016	.30 x Dia	1 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	60 x Dia	1 x Dia
TITANIUM ALLOYS	150	Finishing	.00006	.00012	.00018	.16 x Dia	0.8 x Dia	.000									