



Speeds & Feeds

Product Table: Variable Helix End Mills for High Temp Alloys - Corner Radius - Chipbreaker

Characteristics: 1.5x Length of Cut, 4 Flutes

Series: 7013xx-C10, 7015xx-C10, 7017xx-C10

Material	Hardness (HBn)	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
Stainless Steels: 40x, 41x, 42x, 43x, 44x, 13-8, 15-5, 15-7, 17-4, 17-7 Tool Steels: D, H, M, T, S series	275 - 300	160	Slotting	.00005	.00011	.00017	.00022	.00028	.00033	.00045	.00067	.00089	.00117	.00140	.00187	1x Dia	.4x Dia
	300 - 350	140															
	350 - 400	100															
	400 - 425	80															
Titanium: All alloys	275 - 300	200	Roughing	.00007	.00014	.00021	.00028	.00035	.00042	.00057	.00085	.00113	.00149	.00179	.00238	.4x Dia	.5x - .7x Dia
	300 - 350	125															
	350 - 400	75															
	400 - 425	75															
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	275 - 300	80	Max	.00011	.00022	.00034	.00044	.00056	.00066	.00089	.00133	.00178	.00234	.00281	.00374	-	-
	300 - 350	60															
	350 - 400	50															
	400 - 425	40															

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.