



Speeds & Feeds

Product Table: Variable Helix End Mills for Medium Alloy Steels - Corner Radius

Characteristics: 3x Length of Cut

Series: 456xx-C3, 457xx-C3, 8168xx-c3, 8169xx-C3, 9034xx-C3, 9072xx-C3, 9073xx-C3, 9138xx-C3, 9139xx-C3, 9278xx-C3, 9279xx-C3, 9313xx-C3, 9314xx-C3, 9768xx-C3

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	
CARBON STEELS	225 - 250	250	Slotting	.00008	.00017	.00026	.00035	.00043	.00052	.00066	.00099	.00133	.00174	.00209	.00278	1x Dia	.5x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx			Roughing	.00010	.00021	.00032	.00042	.00052	.00062	.00080	.00120	.00160	.00210	.00252	.00336	.5x Dia	.5x - 1x Dia
STAINLESS STEELS	250 - 275	220	Finishing	.00012	.00025	.00038	.00050	.00063	.00075	.00096	.00144	.00193	.00252	.00303	.00404	.1x Dia	.5x - 1x 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, 414, 42x, 43x, 44x, 501, 502			Max	.00016	.00032	.00049	.00064	.00081	.00097	.00124	.00185	.00248	.00324	.00390	.00520	-	-
TOOL STEELS	275 - 300	180															
A, L, O, P, W series																	

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 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.