



Speeds & Feeds

**Product Table:** High Helix End Mills for Aluminum Alloys - 60° Helix - Square

**Characteristics:** 3x Length of Cut, 3 Flutes

**Series:** 7452xx, 7453xx, 7452xx-C8, 7453xx-C8

Cutter Series	MATERIAL	SFM	Chip Load Per Tooth (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	Radial	Axial	
Uncoated	<b>ALUMINUM ALLOYS</b>													
	Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00012	.00026	.00039	.00051	.00065	.00077	.00104	.00155	.00208	1x Dia	.5x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000												
	<b>MAGNESIUM ALLOYS</b>	1500	Roughing	.00015	.00031	.00047	.00062	.00078	.00093	.00125	.00187	.00250	.5x Dia	.5x-1x Dia
	<b>ZINC ALLOYS</b>	800												
	<b>COPPER ALLOYS</b>													
	High Coppers - 90%+ (C1xxxx)	225												
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500												
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225												
	Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500												
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500													
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225													
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550													
TiB2	<b>ALUMINUM ALLOYS</b>													
	Casting (2xx, 5xx, 7xx, 8xx)	1000	Slotting	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	1x Dia	.5x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1400												
	<b>MAGNESIUM ALLOYS</b>	2000	Roughing	.00020	.00040	.00061	.00081	.00101	.00121	.00163	.00243	.00325	.5x Dia	.5x-1x Dia
<b>ZINC ALLOYS</b>	1100													
			Finishing	.00011	.00022	.00033	.00043	.00055	.00065	.00088	.00131	.00175	.1x Dia	1x-3x Dia

**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](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.