



Speeds & Feeds

Product Table: Diamond End Mills for Non-Ferrous Materials - CVD Diamond - Finishers - Tight Tolerance - Corner Radius

Characteristics: 2 Flutes, Reached, Finishers

Series or Item	Material Group 14	Chip Load (MMPT) by Operation														
		Roughing					Milling					Finishing				
		RPM	Feed Rate (mm/min)	Feed (mm/tooth)	Axial DOC (mm)	Radial DOC (mm)	RPM	Feed Rate (mm/min)	Feed (mm/tooth)	Axial DOC (mm)	Radial DOC (mm)	RPM	Feed Rate (mm/min)	Feed (mm/tooth)	Axial DOC (mm)	Radial DOC (mm)
684422	Carbon Fiber, Silicon, Graphene, Graphite, Tin Alloys	30,000	600	.010	0.5xD	1.0xD	30,000	720	.012	0.5xD	0.5xD	30,000	900	.015	0.2xD	0.2xD
684022		30,000	600	.010	0.5xD	1.0xD	30,000	720	.012	0.5xD	0.5xD	30,000	900	.015	0.2xD	0.2xD
684333		30,000	850	.014	0.5xD	1.0xD	30,000	1,050	.018	0.5xD	0.5xD	30,000	1,200	.020	0.2xD	0.2xD
685245		30,000	950	.016	0.5xD	1.0xD	30,000	1,200	.020	0.5xD	0.5xD	30,000	1,500	.025	0.2xD	0.2xD
684845		30,000	950	.016	0.5xD	1.0xD	30,000	1,200	.020	0.5xD	0.5xD	30,000	1,500	.025	0.2xD	0.2xD
684245		30,000	950	.016	0.5xD	1.0xD	30,000	1,200	.020	0.5xD	0.5xD	30,000	1,500	.025	0.2xD	0.2xD
684745		30,000	950	.016	0.5xD	1.0xD	30,000	1,200	.020	0.5xD	0.5xD	30,000	1,500	.025	0.2xD	0.2xD
685157		30,000	1,450	.024	0.5xD	1.0xD	30,000	1,550	.026	0.5xD	0.5xD	30,000	2,100	.035	0.2xD	0.2xD
684657		30,000	1,450	.024	0.5xD	1.0xD	30,000	1,550	.026	0.5xD	0.5xD	30,000	2,100	.035	0.2xD	0.2xD
684957		30,000	1,450	.024	0.5xD	1.0xD	30,000	1,550	.026	0.5xD	0.5xD	30,000	2,100	.035	0.2xD	0.2xD
684157		30,000	1,450	.024	0.5xD	1.0xD	30,000	1,550	.026	0.5xD	0.5xD	30,000	2,100	.035	0.2xD	0.2xD
685061		30,000	1,900	.032	0.5xD	1.0xD	30,000	2,400	.040	0.5xD	0.5xD	30,000	3,000	.050	0.2xD	0.2xD
684761		30,000	1,900	.032	0.5xD	1.0xD	30,000	2,400	.040	0.5xD	0.5xD	30,000	3,000	.050	0.2xD	0.2xD
684161		30,000	1,900	.032	0.5xD	1.0xD	30,000	2,400	.040	0.5xD	0.5xD	30,000	3,000	.050	0.2xD	0.2xD
685066		30,000	2,900	.048	0.5xD	1.0xD	30,000	3,900	.065	0.5xD	0.5xD	30,000	4,200	.070	0.2xD	0.2xD
684966		30,000	2,900	.048	0.5xD	1.0xD	30,000	3,900	.065	0.5xD	0.5xD	30,000	4,200	.070	0.2xD	0.2xD
684566		30,000	2,900	.048	0.5xD	1.0xD	30,000	3,900	.065	0.5xD	0.5xD	30,000	4,200	.070	0.2xD	0.2xD

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.