

Product Table: End Mills for Hardened Steels - Corner Radius - For Steels Up to 55 Rc **Characteristics:** 1.5x Length of Cut, 5 Flutes **Series:** 7320xx-C6, 7613xx-C6, 7980xx-C6, 8727xx-C6, 9204xx-C6, 9205xx-C6

Material	Hardness	SFM	Chip Load (IPT) By Cutter Diameter														Depth of Cut	
				.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	.500	Radial	Axial	
Hardened Steels	38 - 44 Rc	100	Slotting	.00004	.00007	.00011	.00015	.00019	.00022	.00030	.00045	.00060	.00075	.00090	.00120	1 x Dia	.30 x Dia	
Titanium Allovs			Profiling	.00004	.00009	.00014	.00018	.00023	.00027	.00036	.00054	.00073	.00091	.00109	.00145	.3 x Dia	.5 x Dia	
,	45 - 55 Rc	60	Slotting	.00002	.00005	.00007	.00010	.00012	.00014	.00019	.00029	.00038	.00048	.00058	.00077	1 x Dia	.15 x Dia	
Nickel Alloys			Profiling	.00003	.00005	.00008	.00010	.00013	.00016	.00021	.00032	.00042	.00053	.00063	.00084	.15 x Dia	.5 x 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**.

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.