



Speeds & Feeds

Product Table: Miniature End Mills - Tapered - Square
Characteristics: 5°-6° Angle per Side, 5x Length of Cut, 4 Flutes
Series: 7239xx

Product Notes: Use the end diameter of the tool to select the correct Chip Load (IPT)

General Notes: All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. Chip loads reflect uncoated cutters and may be increased 10%-20% if coated. For ferrous materials with hardness ≤ 28 Rc, chip loads can be increased 10%-20%.

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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Dia (0.15, .031, .047), Depth of Cut (Radial, Axial), Chip Load (IPT) By Cutter Dia (.062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial). Includes sections for ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, and COPPER ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Dia (.015, .031, .047), Depth of Cut (Radial, Axial), Chip Load (IPT) By Cutter Dia (.062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial). Includes sections for CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, and HIGH TEMP ALLOYS.

Table with columns: SFM, Chip Load (IPT) By Cutter Dia (.015, .031, .047), Depth of Cut (Radial, Axial), Chip Load (IPT) By Cutter Dia (.062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial). This table provides numerical data for a hardness range of 38-45 Rc.