



## Speeds & Feeds

**Product Table:** Variable Helix End Mills for Free Machining Steels - Square  
**Characteristics:** 1.5x Length of Cut  
**Series:** 9260xx-C3, 9398xx-C3, 9399xx-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  10xx - 1030, 10Lxx, 11xx - 1140, 11Lxx, 12xx - 1215, 12Lxx	100-125	500	Slotting	.00014	.00030	.00045	.00059	.00075	.00089	.00111	.00165	.00221	.00290	.00348	.00465	1x Dia	.5x Dia
	125-150	425	Roughing	.00017	.00036	.00055	.00072	.00091	.00108	.00134	.00201	.00269	.00352	.00423	.00564	.5x Dia	.5x - 1x Dia
	150-175	400															
STAINLESS STEELS  203 EZ, 303 (all types), 416, 416 Se, 416 Plus X., 420 F, 420 F Se	175-200	375	Finishing	.00021	.00043	.00065	.00086	.00109	.00129	.00161	.00241	.00322	.00422	.00507	.00676	.1x Dia	.5x - 1x Dia
	200-225	350	Max	.00027	.00055	.00084	.00111	.00140	.00166	.00207	.00310	.00414	.00543	.00653	.00870	-	-

### 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](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.