



Speeds & Feeds

Product Table: End Mills for Aluminum Alloys - Finishers - Tight Tolerance - Ball **Characteristics:**
2 Flutes, Reached, Finishers

Series or Item	Materials	RPM	Chip Load (MMPT)	Radial DOC (mm)	Axial DOC (mm)
690206-C4	Aluminum, Copper, Brass	60,000	.0230	.020	.060
690006-C4		60,000	.0200	.015	.040
689906-C4		60,000	.0200	.012	.035
690009-C4		48,000	.0300	.025	.080
689609-C4		38,000	.0240	.010	.030
690111-C4		45,000	.0300	.035	.100
689911-C4		43,000	.0270	.030	.090
689711-C4		43,000	.0270	.020	.050
690213-C4		48,000	.0380	.040	.120
689913-C4		43,000	.0380	.022	.065
689613-C4		38,000	.0300	.015	.040
690018-C4		48,000	.0380	.050	.160
689818-C4		43,000	.0340	.030	.090
690022-C4		38,000	.0400	.040	.100
689922-C4		38,000	.0400	.040	.100
689722-C4		38,000	.0400	.025	.075
689622-C4		38,000	.0400	.025	.075
690033-C4		30,000	.0400	.060	.160
689933-C4		30,000	.0400	.060	.150
689733-C4		30,000	.0400	.060	.140
690245-C4		25,000	.0700	.200	.600
690045-C4		25,000	.0700	.140	.400
689945-C4		22,000	.0600	.080	.200
689845-C4		22,000	.0600	.080	.200
689645-C4		22,000	.0600	.050	.150
690257-C4		19,000	.0700	.200	.600
690057-C4		18,000	.0700	.200	.600
689957-C4		18,000	.0700	.120	.250
690061-C4		14,000	.0900	.200	.600
690066-C4		9,500	.1200	.300	.700

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.