

MATERIAL	Hardness: ≤ 28 Rc (≤ 271 HBn)												Radial	Axial	
	SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia					Depth of Cut			
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250			Radial
ALUMINUM ALLOYS															
Casting (2xx, 5xx, 7xx, 8xx)	750	Finishing	.0008	.00017	.00025	.05 x Dia	8 x Dia	.00029	.00037	.00044	.00059	.00088	.00117	.10 x Dia	8 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000														
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Finishing	.00007	.00015	.00023	.05 x Dia	8 x Dia	.00026	.00033	.00039	.00053	.00079	.00106	.10 x Dia	8 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700														
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650														
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475														
Wrought - 5%-8% Si (4xxx)	1000														
Wrought - 8%-12% Si (4xxx)	800														
MAGNESIUM ALLOYS															
	1500	Finishing	.00008	.00017	.00025	.05 x Dia	8 x Dia	.00029	.00037	.00044	.00059	.00088	.00117	.10 x Dia	8 x Dia
ZINC ALLOYS															
	800														
COPPER ALLOYS															
High Coppers - 90%+ (C1xxx)	225	Finishing	.00006	.00013	.00020	.05 x Dia	8 x Dia	.00023	.00029	.00035	.00047	.00070	.00094	.10 x Dia	8 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C66400-C69800)	500														
Phosphor Bronzes (Copper Tin alloys, C5xxx)	225														
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500														
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500														
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225														
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550														



Speeds & Feeds

Product Table: Miniature End Mills - Square - Long Flute
Characteristics: 7.5x, 8x, 9x Length of Cut, 3 Flutes
Series: 127xx, 336xx, and Items #33702, 33705, 33708,7336xx, 8378xx, 8379xx

Please note:
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.

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)												Radial	Axial	
	SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia					Depth of Cut			
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250			Radial
CARBON STEELS															
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Finishing	.00003	.00005	.00008	.05 x Dia	8 x Dia	.00009	.00011	.00014	.00018	.00027	.00037	.10 x Dia	8 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xx, 3xx, 4xx & 4xLxx, 5xx & 5xLxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xx, 8xx, 9xx	200	Finishing	.00002	.00005	.00007	.05 x Dia	8 x Dia	.00008	.00010	.00012	.00017	.00025	.00034	.10 x Dia	8 x Dia
STAINLESS STEELS															
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Finishing	.00003	.00005	.00008	.05 x Dia	8 x Dia	.00009	.00011	.00014	.00018	.00027	.00037	.10 x Dia	8 x Dia
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Finishing	.00002	.00005	.00007	.05 x Dia	8 x Dia	.00008	.00010	.00012	.00017	.00025	.00034	.10 x Dia	8 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Finishing	.00001	.00003	.00005	.05 x Dia	8 x Dia	.00005	.00007	.00008	.00010	.00016	.00021	.10 x Dia	8 x Dia
TOOL STEELS															
A, L, O, P, W series	200	Finishing	.00002	.00005	.00007	.05 x Dia	8 x Dia	.00008	.00010	.00012	.00017	.00025	.00034	.10 x Dia	8 x Dia
D, H, M, T, S series	150	Finishing	.00001	.00003	.00005	.05 x Dia	8 x Dia	.00005	.00007	.00008	.00010	.00016	.00021	.10 x Dia	8 x Dia
TITANIUM ALLOYS															
	150	Finishing	.00001	.00003	.00005	.05 x Dia	8 x Dia	.00005	.00007	.00008	.00010	.00016	.00021	.10 x Dia	8 x Dia
HIGH TEMP ALLOYS															
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Finishing	.00001	.00003	.00005	.05 x Dia	8 x Dia	.00005	.00007	.00008	.00010	.00016	.00021	.10 x Dia	8 x Dia

MATERIAL	Hardness: 38-45 Rc (353-421 HBn)												Radial	Axial	
	SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia					Depth of Cut			
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250			Radial
			-	-	-	.05 x Dia	8 x Dia	-	-	-	-	-	-	-	-
			-	-	-	.05 x Dia	8 x Dia	-	-	-	-	-	-	-	-
			-	-	-	.05 x Dia	8 x Dia	-	-	-	-	-	-	-	-
	100	Finishing	.00001	.00002	.00004	.05 x Dia	8 x Dia	.00004	.00005	.00006	.00008	.00013	.00017	.10 x Dia	8 x Dia
	90	Finishing	.00001	.00002	.00002	.05 x Dia	8 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.10 x Dia	8 x Dia
	100	Finishing	.00001	.00002	.00004	.05 x Dia	8 x Dia	.00004	.00005	.00006	.00008	.00013	.00017	.10 x Dia	8 x Dia
	90	Finishing	.00001	.00002	.00002	.05 x Dia	8 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.10 x Dia	8 x Dia
	75	Finishing	.00001	.00002	.00002	.05 x Dia	8 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.10 x Dia	8 x Dia
	50	Finishing	.00001	.00002	.00002	.05 x Dia	8 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.10 x Dia	8 x Dia