



Speeds & Feeds

Product Table: Diamond End Mills for Non-Ferrous Materials - CVD Diamond - Finishers - Tight Tolerance - Ball
Characteristics: 2 Flutes, Reached, Finishers

Series or Item	Chip Load (MMPT) by Material									
	Graphite Fine Grain					Zirconium				
	RPM	Feed Rate (mm/min)	Feed (mm/tooth)	Axial DOC (mm)	Radial DOC (mm)	RPM	Feed Rate (mm/min)	Feed (mm/tooth)	Axial DOC (mm)	Radial DOC (mm)
689004	35,000	617	.009	.014	.023	30,000	450	.007	.023	.019
688706	32,000	847	.013	.020	.035	28,000	630	.011	.034	.028
688709	35,000	1,235	.018	.027	.050	30,000	900	.015	.046	.040
688711	35,000	1,235	.018	.034	.063	30,000	900	.015	.057	.050
688411	30,000	794	.013	.027	.058	26,000	585	.011	.046	.047
688713	33,000	1,237	.019	.039	.078	28,000	892	.016	.065	.062
688513	30,000	926	.015	.037	.070	26,000	682	.013	.061	.056
688413	27,000	774	.014	.033	.064	23,000	560	.012	.055	.051
688718	34,000	1,499	.022	.055	.107	28,000	1,344	.024	.091	.085
689022	36,000	1,985	.028	.082	.133	31,000	1,860	.030	.137	.107
688722	33,000	1,746	.026	.068	.125	28,000	1,624	.029	.114	.100
688522	30,000	1,521	.025	.061	.117	26,000	1,456	.028	.102	.093
688422	27,000	1,310	.024	.055	.107	23,000	1,242	.027	.091	.085
688933	32,000	3,840	.060	.118	.194	27,000	2,754	.051	.196	.155
688733	30,000	3,480	.058	.102	.188	26,000	2,548	.049	.171	.150
689045	35,000	6,370	.091	.164	.267	30,000	4,620	.077	.273	.213
688845	34,000	6,052	.089	.150	.250	29,000	4,408	.076	.250	.200
688745	33,000	5,808	.088	.137	.240	28,000	4,200	.075	.228	.192
688645	30,000	5,280	.088	.123	.227	26,000	3,900	.075	.205	.181
689157	36,000	8,856	.123	.266	.400	30,000	6,300	.105	.444	.320
689057	35,000	8,610	.123	.246	.375	30,000	6,240	.104	.410	.300
688957	35,000	8,540	.122	.235	.350	29,000	6,032	.104	.392	.280
688757	33,000	7,920	.120	.205	.300	28,000	5,712	.102	.341	.240
689061	33,000	11,814	.179	.328	.507	28,000	8,512	.152	.546	.405
688861	32,000	11,264	.176	.300	.453	27,000	8,046	.149	.501	.363
688761	31,000	10,540	.170	.273	.400	27,000	7,830	.145	.455	.320
689066	28,000	3,951	.071	.491	.750	24,000	2,879	.060	.819	1.600

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.