



## Speeds & Feeds

**Product Table:** End Mills For Steels & High Temp Alloys - Corner Radius - 4 Flute - Variable Helix - Long Reach

**Characteristics:** 5x Reach Multiple, 4 Flutes

**Series:** VLRM-XXX-X

**Note:** For tools with a 6x Reach Multiple, reduce SFM & IPT by 5%

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	
Tool Steels: D, H, M, T, S series	350 - 400	100	Slotting	.00005	.00010	.00016	.00020	.00026	.00031	.00041	.00062	.00083	.00108	.00130	.00173	1x Dia	.28x Dia
	400 - 425	80															
Stainless Steels: 40x, 41x, 42x, 43x, 44x, 13-8, 15-5, 15-7, 17-4, 17-7	275 - 300	160	Roughing	.00006	.00013	.00020	.00026	.00033	.00039	.00053	.00079	.00105	.00138	.00165	.00221	.28x Dia	.5x - .7x Dia
	300 - 350	140															
Titanium: All alloys	275 - 300	200	Finishing	.00008	.00017	.00026	.00034	.00043	.00051	.00069	.00103	.00138	.00180	.00217	.00289	.1x Dia	.5x - 1x Dia
	300 - 350	125															
	350 - 400	75															
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	400 - 425	75	Max	.00010	.00020	.00031	.00041	.00051	.00061	.00083	.00123	.00165	.00216	.00260	.00347	-	-
	275 - 300	80															
	300 - 350	60															
	350 - 400	50															
	400 - 425	40															

**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, Micro100 has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **800-421-8065** or **micro100tech@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.