



Speeds & Feeds

Product Table: End Mills for Hardened Steels - Tight Tolerance - Square - For Steels 70 Rc
Characteristics: 4 Flutes, Reached

Series or Item		Chip Load (IPT) by Material							
		Hardened Steels 45-55 HRC				Hardened Steels 55-70 HRC			
		RPM	Chip Load (IPT)	Axial DOC	Radial DOC	RPM	Chip Load (IPT)	Axial DOC	Radial DOC
675631-C12	Roughing	29,000	.00055	.00044	.00165-.01654	26,000	.00055	.00041	.00138-.01654
	Finishing	23,000	.00039	.00012	.00031	22,000	.00035	.00012	.00028
675431-C12	Roughing	28,000	.00055	.00044	.00165-.01654	26,000	.00055	.00041	.00138-.01654
	Finishing	22,000	.00039	.00012	.00031	20,000	.00035	.00012	.00028
675647-C12	Roughing	23,000	.00089	.00084	.00299-.02591	21,000	.00079	.00077	.00265-.02591
	Finishing	19,000	.00047	.00012	.00031	18,000	.00047	.00012	.00028
675447-C12	Roughing	23,000	.00087	.00044	.00165-.02665	21,000	.00076	.00041	.00138-.02665
	Finishing	18,000	.00051	.00012	.00031	16,000	.00051	.00012	.00028
675662-C12	Roughing	20,000	.00118	.00196	.00646-.03759	18,000	.00105	.00178	.00577-.03759
	Finishing	16,000	.00079	.00059	.00157	15,000	.00075	.00055	.00146
675462-C12	Roughing	19,000	.00116	.00074	.00283-.03845	18,000	.00102	.00069	.00212-.03845
	Finishing	15,000	.00083	.00043	.00098	14,000	.00079	.00039	.00098
675678-C12	Roughing	17,000	.00140	.00259	.00842-.04676	16,000	.00125	.00235	.00746-.04676
	Finishing	14,000	.00102	.00094	.00244	13,000	.00098	.00087	.00228
675478-C12	Roughing	16,000	.00139	.00147	.0051-.04754	15,000	.00122	.00135	.00411-.04754
	Finishing	13,000	.00106	.00075	.00193	12,000	.00098	.00071	.00185
675693-C12	Roughing	14,000	.00159	.00312	.01007-.05423	13,000	.00141	.00283	.00889-.05423
	Finishing	12,000	.00126	.00122	.00319	12,000	.00114	.00110	.00295
675493-C12	Roughing	14,000	.00157	.00206	.00695-.05497	13,000	.00138	.00189	.00575-.05497
	Finishing	11,000	.00126	.00106	.00272	10,000	.00118	.00098	.00256
675708-C12	Roughing	11,000	.00188	.00423	.0135-.06588	10,000	.00167	.00383	.01198-.06588
	Finishing	9,800	.00154	.00169	.00449	9,300	.00142	.00157	.00413
675508-C12	Roughing	10,000	.00186	.00301	.00989-.06673	9,500	.00164	.00275	.00834-.06673
	Finishing	8,400	.00157	.00150	.00394	7,800	.00146	.00138	.00366
675712-C12	Roughing	5,300	.00228	.00539	.01714-.08254	5,400	.00203	.00489	.01512-.08254
	Finishing	5,700	.00201	.00232	.00614	5,500	.00181	.00213	.00563
675512-C12	Roughing	4,900	.00227	.00434	.01402-.08327	4,800	.00200	.00395	.01198-.08327
	Finishing	4,900	.00201	.00213	.00563	4,900	.00185	.00197	.00524
675716-C12	Roughing	4,200	.00258	.00650	.02056-.09415	4,200	.00229	.00589	.0182-.09415
	Finishing	4,900	.00232	.00280	.0074	4,900	.00209	.00256	.00681
675516-C12	Roughing	4,200	.00256	.00528	.01695-.09501	4,200	.00226	.00480	.01456-.09501
	Finishing	4,900	.00232	.00260	.00685	4,900	.00213	.00236	.00634

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.