

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)									
		Chip Load (IPR - Inches Per Revolution) By Reamer Diameter									
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.375
ALUMINUM ALLOYS											
Casting (2xx, 5xx, 7xx, 8xx)	450	.00041	.00084	.00127	.00167	.00211	.00251	.00338	.00505	.00675	.01013
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	600										
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	450										
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	420										
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	390	.00036	.00075	.00114	.00151	.00190	.00226	.00304	.00454	.00608	.00911
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	350										
Wrought - 5%-8% Si (4xxx)	600										
Wrought - 8%-12% Si (4xxx)	480										
MAGNESIUM ALLOYS	900	.00041	.00084	.00127	.00167	.00211	.00251	.00338	.00505	.00675	.01013
ZINC ALLOYS	480										
COPPER ALLOYS											
High Coppers - 90%+ (C1xxxx)	170										
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C66400-C69800)	375										
Phosphor Bronzes (Copper Tin alloys, C5xxx)	170	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540	.00810
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	375										
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	375										
Copper Nicksels, Nickel Silvers (Copper Nickel alloys, C7xxx)	170										
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800)	400										



Speeds & Feeds

Product Table: Miniature Reamers
Series: RSBxxxx, RSCxxxx

Product Notes:

In order to maintain appropriate stock removal amounts based on the reamer size, a hole should be pre-drilled at a diameter that is 90-94% of the finished reamed hole diameter. For example, for a finished reamed hole diameter of .0625", the pre-drilled hole diameter should be in the range of .056"-.058". The pre-drilled hole should not be smaller than 85% of the finished reamed hole diameter.

MATERIAL	SFM	Hardness: 29-37 Rc (279-344 HBn)									
		Chip Load (IPR - Inches Per Revolution) By Reamer Diameter									
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.375
CARBON STEELS											
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	240	.00035	.00073	.00111	.00146	.00184	.00220	.00295	.00442	.00591	.00886
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4Lxx, 50xx & 5Lxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx	150	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540	.00810
STAINLESS STEELS											
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	180	.00035	.00073	.00111	.00146	.00184	.00220	.00295	.00442	.00591	.00886
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	150	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540	.00810
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	125	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00506
TOOL STEELS											
A, L, O, P, W series	125	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540	.00810
D, H, M, T, S series	90	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00506
TITANIUM ALLOYS	100	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00506
HIGH TEMP ALLOYS											
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00506

SFM	Hardness: 38-45 Rc (353-421 HBn)									
	Chip Load (IPR - Inches Per Revolution) By Reamer Diameter									
	0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.375
-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-
100	.00026	.00054	.00081	.00107	.00135	.00161	.00216	.00323	.00432	.00648
90	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00405
100	.00026	.00054	.00081	.00107	.00135	.00161	.00216	.00323	.00432	.00648
75	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00405
75	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00405
50	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00405

Please note:
All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

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.