



Speeds & Feeds

Product Table: Miniature End Mills - Square - Extra Long Length
Characteristics: 4 Flutes
Series: 9605xx, 9919xx

Product Notes:

Posted values reflect tools with a reach equal to 5x Diameter. For tools with a greater reach multiple, use the table below to adjust Chip Load and Depths of Cut.

Table with columns for Reach Multiple, Slotting (Chip Load, Depth of Cut Radial, Axial), Roughing (Chip Load, Depth of Cut Radial, Axial), and Finishing (Chip Load, Depth of Cut Radial, Axial). Rows include 5x, 8x, 12x, 15x, 20x, and 25x reach multiples.

General Notes:

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.

Main product table for Hardness: ≤ 28 Rc (≤ 271 HBn). Columns include Material, SFM, Chip Load (IPT) by Cutter Diameter (.125, .187, .250, .312, .375, .500, .625, .750, 1.000), and Depth of Cut (Radial, Axial). Rows cover Aluminum Alloys, Magnesium Alloys, Zinc Alloys, and Copper Alloys.

Main product table for Hardness: 29-37 Rc (279-344 HBn). Columns include Material, SFM, Chip Load (IPT) by Cutter Diameter (.125, .187, .250, .312, .375, .500, .625, .750, 1.000), and Depth of Cut (Radial, Axial). Rows cover Carbon Steels, Stainless Steels, Tool Steels, Titanium Alloys, and High Temp Alloys.

Main product table for Hardness: 38-45 Rc (353-421 HBn). Columns include SFM, Chip Load (IPT) by Cutter Diameter (.125, .187, .250, .312, .375, .500, .625, .750, 1.000), and Depth of Cut (Radial, Axial). Rows include a blank header row and multiple rows of data for various materials and SFM values.