



Speeds & Feeds

Product Table: Variable Helix End Mills for Aluminum Alloys - Finishers - Square
Characteristics: 1.5x Length of Cut
Series: 8569xx-C8

Cutter Series	MATERIAL	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															
Uncoated	ALUMINUM ALLOYS																														
	Casting (2xx, 5xx, 7xx, 8xx)	750																													
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000																													
	MAGNESIUM ALLOYS	1500																													
	ZINC ALLOYS	800																													
	COPPER ALLOYS																														
	High Coppers - 90%+ (C1xxxx)	225	Finishing	.00031	.00064	.00097	.00128	.00161	.00193	.00259	.00387	.00518	.00678	.00815	.01087	.12x Dia	.5x - 3x Dia														
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500																													
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225																													
	Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500																													
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500																														
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225																														
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550																														
ALUMINUM ALLOYS																															
Casting (2xx, 5xx, 7xx, 8xx)	1000																														
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1400	Finishing																.00040	.00083	.00126	.00167	.00210	.00250	.00336	.00503	.00673	.00882	.01060	.01413	.12x Dia	.5x - 3x Dia
MAGNESIUM ALLOYS	2000																														
ZINC ALLOYS	1100																														

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.