



Speeds & Feeds

Product Table: Miniature End Mills - Tapered - Square
Characteristics: 9°-10° Angle per Side, 5x Length of Cut
Series: 9882xx

Product Notes:

Use the end diameter of the tool to select the correct Chip Load (IPT)

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 harveymach@harveymach.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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Dia (.015, .031, .047, .062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial), and Hardness: ≤ 28 Rc (≤ 271 HBn). Includes materials like ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS, and HIGH TEMP ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Dia (.015, .031, .047, .062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial), and Hardness: 29-37 Rc (279-344 HBn). Includes materials like CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, and HIGH TEMP ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Dia (.015, .031, .047, .062, .078, .093, .125, .187, .250), Depth of Cut (Radial, Axial), and Hardness: 38-45 Rc (353-421 HBn). This table shows mostly blank data for the specified hardness range.