



Product Table: Miniature Diamond Coated End Mills - Square

Characteristics: 3x Length of Cut, 4 Flutes

Material	Type	SFM		IPT by Cutter Diameter				Depth of Cut		IPT by Cutter Diameter						Depth of Cut	
				.015	.020	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial
Composites	Laminates	400-750	Roughing	.00015	.00020	.00031	.00047	.25 x Dia	1 x Dia	.00054	.00067	.00080	.00108	.00161	.00216	.50 x Dia	1 x Dia
			Finishing	.00012	.00016	.00025	.00037	.08 x Dia	3 x Dia	.00043	.00054	.00064	.00086	.00129	.00173	.15 x Dia	3 x Dia
Plastics	21%-40% Filled or Fiber Reinforced	400-750	Roughing	.00015	.00020	.00031	.00047	.25 x Dia	1 x Dia	.00054	.00067	.00080	.00108	.00161	.00216	.50 x Dia	1 x Dia
			Finishing	.00012	.00016	.00025	.00037	.08 x Dia	3 x Dia	.00043	.00054	.00064	.00086	.00129	.00173	.15 x Dia	3 x Dia
Graphite	POCO 3	600-1200	Roughing	.00020	.00027	.00042	.00063	.30 x Dia	1.3 x Dia	.00072	.00091	.00109	.00146	.00218	.00292	.65 x Dia	1.3 x Dia
			Finishing	.00016	.00021	.00033	.00051	.10 x Dia	3 x Dia	.00058	.00073	.00087	.00117	.00175	.00234	.20 x Dia	3 x Dia
Green Carbide & Green Ceramics		100-750	Roughing	.00018	.00025	.00038	.00058	.30 x Dia	1.3x Dia	.00066	.00083	.00099	.00133	.00199	.00267	.65 x Dia	1.3 x Dia
			Finishing	.00015	.00020	.00030	.00046	.10 x Dia	3 x Dia	.00053	.00067	.00079	.00107	.00160	.00213	.20 x Dia	3 x Dia

Product Notes:

Due to Edge Rounding and Surface Texture inherent in CVD diamond, plastic materials and non-ferrous alloys should be closely supervised for galling and/or flute packing.

General Notes:

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

If you require additional information, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **833-584-3448** or **corehogtech@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.