



Speeds & Feeds

Product Table: Miniature End Mills - Square - Long Reach, Stub Flute
Characteristics: 3x Reach Multiple, 3 Flutes
Series: 478xx, 9784xx

Please note:

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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), Depth of Cut (Radial, Axial). Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, HIGH TEMP ALLOYS.

Table with columns: SFM, Chip Load (IPT) by Dia (0.015, 0.031, 0.047), Depth of Cut (Radial, Axial), Chip Load (IPT) by Cutter Dia (0.062, 0.078, 0.093, 0.125, 0.187, 0.250, 0.375, 0.500), Depth of Cut (Radial, Axial). Rows include various material groups with specific SFM values.