



Speeds & Feeds

Product Table: Multi-Axis Finishers for Aluminum Alloys - Lens Form

Characteristics: 3 Flutes

Series: 6998xx-C8, 6999xx-C8

Cutter Series	MATERIAL	SFM										Depth of Cut	
				0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial
TiB2	ALUMINUM ALLOYS	1400	Finishing	.00181	.00186	.00191	.00200	.00220	.00250	.00290	.00340	.025 x Dia x Benefit Multiple	.005"-.010"
	Casting (2xx, 5xx, 7xx, 8xx)												
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	2100		.00146	.00150	.00154	.00160	.00180	.00200	.00230	.00270		
	COPPER ALLOYS	770		.00157	.00161	.00165	.00160	.00180	.00210	.00240	.00280		

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.