



Product Table: End Mills for Aluminum Alloys - Finishers - Tight Tolerance - Corner Radius
Characteristics: 2 Flutes, Reached, Finishers

Series or Item	Materials	RPM	Chip Load (MMPT)	Axial DOC (mm)
686611-C4	Aluminum, Copper, Brass	48,000	.0300	.020
686822-C4		44,000	.0400	.065
686422-C4		38,000	.0380	.040
685822-C4		38,000	.0380	.040
685422-C4		38,000	.0400	.030
685622-C4		38,000	.0360	.025
685322-C4		38,000	.0360	.025
686133-C4		31,000	.0360	.055
685533-C4		30,000	.0360	.050
686345-C4		24,000	.0600	.100
686045-C4		22,000	.0600	.080
685745-C4		22,000	.0600	.080
685345-C4		22,000	.0600	.050
686257-C4		20,000	.0660	.120
685957-C4		17,000	.0600	.120
686261-C4		13,000	.0900	.200
686564-C4		11,000	.1200	.380
686766-C4		10,000	.1500	.300

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.