



Speeds & Feeds

Product Table: Miniature End Mills - Square - Long Flute
Characteristics: 4x Length of Cut, 4 Flutes
Items: 8369xx, 8370xx, 8885xx

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.

MATERIAL		Hardness: ≤ 28 Rc (≤ 271 HBn)															
		SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia						Depth of Cut			
			0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial
ALUMINUM ALLOYS																	
Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00014	.00028	.00043	1 x Dia	.11 x Dia	.00049	.00062	.00074	.00099	.00148	.00198	.00297	.00396	1 x Dia	.27 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Roughing	.00011	.00024	.00036	.13 x Dia	4 x Dia	.00041	.00051	.00061	.00083	.00123	.00165	.00248	.00330	.25 x Dia	4 x Dia
		Finishing	.00017	.00035	.00053	.06 x Dia	4 x Dia	.00060	.00076	.00091	.00122	.00182	.00243	.00365	.00487	.12 x Dia	4 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00012	.00025	.00039	1 x Dia	.11 x Dia	.00044	.00056	.00066	.00089	.00133	.00178	.00267	.00356	1 x Dia	.27 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Slotting	.00012	.00025	.00039	1 x Dia	.11 x Dia	.00044	.00056	.00066	.00089	.00133	.00178	.00267	.00356	1 x Dia	.27 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Roughing	.00010	.00021	.00032	.13 x Dia	4 x Dia	.00037	.00046	.00055	.00074	.00111	.00149	.00223	.00297	.25 x Dia	4 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475	Roughing	.00010	.00021	.00032	.13 x Dia	4 x Dia	.00037	.00046	.00055	.00074	.00111	.00149	.00223	.00297	.25 x Dia	4 x Dia
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00015	.00031	.00047	.06 x Dia	4 x Dia	.00054	.00068	.00081	.00109	.00164	.00219	.00328	.00438	.12 x Dia	4 x Dia
Wrought - 8%-12% Si (4xxx)	800	Finishing	.00015	.00031	.00047	.06 x Dia	4 x Dia	.00054	.00068	.00081	.00109	.00164	.00219	.00328	.00438	.12 x Dia	4 x Dia
MAGNESIUM ALLOYS																	
	1500	Slotting	.00014	.00028	.00043	1 x Dia	.11 x Dia	.00049	.00062	.00074	.00099	.00148	.00198	.00297	.00396	1 x Dia	.27 x Dia
		Roughing	.00011	.00024	.00036	.13 x Dia	4 x Dia	.00041	.00051	.00061	.00083	.00123	.00165	.00248	.00330	.25 x Dia	4 x Dia
		Finishing	.00017	.00035	.00053	.06 x Dia	4 x Dia	.00060	.00076	.00091	.00122	.00182	.00243	.00365	.00487	.12 x Dia	4 x Dia
ZINC ALLOYS																	
	800	Slotting	.00014	.00028	.00043	1 x Dia	.11 x Dia	.00049	.00062	.00074	.00099	.00148	.00198	.00297	.00396	1 x Dia	.27 x Dia
		Roughing	.00011	.00024	.00036	.13 x Dia	4 x Dia	.00041	.00051	.00061	.00083	.00123	.00165	.00248	.00330	.25 x Dia	4 x Dia
		Finishing	.00017	.00035	.00053	.06 x Dia	4 x Dia	.00060	.00076	.00091	.00122	.00182	.00243	.00365	.00487	.12 x Dia	4 x Dia
COPPER ALLOYS																	
High Coppers - 90%+ (C1xxx)	225	Slotting	.00011	.00023	.00034	1 x Dia	.11 x Dia	.00039	.00049	.00059	.00079	.00118	.00158	.00238	.00317	1 x Dia	.27 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C69800)	500	Slotting	.00011	.00023	.00034	1 x Dia	.11 x Dia	.00039	.00049	.00059	.00079	.00118	.00158	.00238	.00317	1 x Dia	.27 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)	225	Slotting	.00011	.00023	.00034	1 x Dia	.11 x Dia	.00039	.00049	.00059	.00079	.00118	.00158	.00238	.00317	1 x Dia	.27 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Slotting	.00011	.00023	.00034	1 x Dia	.11 x Dia	.00039	.00049	.00059	.00079	.00118	.00158	.00238	.00317	1 x Dia	.27 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C68100)	500	Roughing	.00009	.00019	.00029	.13 x Dia	4 x Dia	.00033	.00041	.00049	.00066	.00099	.00132	.00198	.00264	.25 x Dia	4 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225	Roughing	.00009	.00019	.00029	.13 x Dia	4 x Dia	.00033	.00041	.00049	.00066	.00099	.00132	.00198	.00264	.25 x Dia	4 x Dia
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Finishing	.00013	.00028	.00042	.06 x Dia	4 x Dia	.00048	.00061	.00072	.00097	.00146	.00195	.00292	.00389	.12 x Dia	4 x Dia

MATERIAL		Hardness: 29-37 Rc (279-344 HBn)															
		SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia						Depth of Cut			
			0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial
CARBON STEELS																	
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Slotting	.00005	.00010	.00015	1 x Dia	.11 x Dia	.00017	.00021	.00025	.00034	.00051	.00068	.00102	.00136	1 x Dia	.27 x Dia
		Roughing	.00004	.00007	.00011	.13 x Dia	4 x Dia	.00013	.00016	.00019	.00026	.00038	.00051	.00077	.00102	.25 x Dia	4 x Dia
		Finishing	.00005	.00011	.00016	.06 x Dia	4 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	.12 x Dia	4 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 44Lxx, 50xx & 54Lxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx	200	Slotting	.00004	.00009	.00013	1 x Dia	.11 x Dia	.00015	.00019	.00023	.00031	.00047	.00062	.00093	.00124	1 x Dia	.27 x Dia
		Roughing	.00003	.00007	.00010	.13 x Dia	4 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00093	.25 x Dia	4 x Dia
		Finishing	.00005	.00010	.00015	.06 x Dia	4 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00104	.00139	.12 x Dia	4 x Dia
STAINLESS STEELS																	
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Slotting	.00005	.00010	.00015	1 x Dia	.11 x Dia	.00017	.00021	.00025	.00034	.00051	.00068	.00102	.00136	1 x Dia	.27 x Dia
		Roughing	.00004	.00007	.00011	.13 x Dia	4 x Dia	.00013	.00016	.00019	.00026	.00038	.00051	.00077	.00102	.25 x Dia	4 x Dia
		Finishing	.00005	.00011	.00016	.06 x Dia	4 x Dia	.00019	.00024	.00028	.00038	.00057	.00076	.00114	.00152	.12 x Dia	4 x Dia
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Slotting	.00004	.00009	.00013	1 x Dia	.11 x Dia	.00015	.00019	.00023	.00031	.00047	.00062	.00093	.00124	1 x Dia	.27 x Dia
		Roughing	.00003	.00007	.00010	.13 x Dia	4 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00093	.25 x Dia	4 x Dia
		Finishing	.00005	.00010	.00015	.06 x Dia	4 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00104	.00139	.12 x Dia	4 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00003	.00006	.00008	1 x Dia	.11 x Dia	.00010	.00012	.00014	.00019	.00029	.00039	.00058	.00078	1 x Dia	.27 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	4 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	.25 x Dia	4 x Dia
		Finishing	.00003	.00006	.00009	.06 x Dia	4 x Dia	.00011	.00014	.00016	.00022	.00033	.00043	.00065	.00087	.12 x Dia	4 x Dia
TOOL STEELS																	
A, L, O, P, W series	200	Slotting	.00004	.00009	.00013	1 x Dia	.11 x Dia	.00015	.00019	.00023	.00031	.00047	.00062	.00093	.00124	1 x Dia	.27 x Dia
		Roughing	.00003	.00007	.00010	.13 x Dia	4 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00093	.25 x Dia	4 x Dia
		Finishing	.00005	.00010	.00015	.06 x Dia	4 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00104	.00139	.12 x Dia	4 x Dia
D, H, M, T, S series	150	Slotting	.00003	.00006	.00008	1 x Dia	.11 x Dia	.00010	.00012	.00014	.00019	.00029	.00039	.00058	.00078	1 x Dia	.27 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	4 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	.25 x Dia	4 x Dia
		Finishing	.00003	.00006	.00009	.06 x Dia	4 x Dia	.00011	.00014	.00016	.00022	.00033	.00043	.00065	.00087	.12 x Dia	4 x Dia
TITANIUM ALLOYS																	
	150	Slotting	.00003	.00006	.00008	1 x Dia	.11 x Dia	.00010	.00012	.00014	.00019	.00029	.00039	.00058	.00078	1 x Dia	.27 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	4 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	.25 x Dia	4 x Dia
		Finishing	.00003	.00006	.00009	.06 x Dia	4 x Dia	.00011	.00014	.00016	.00022	.00033	.00043	.00065	.00087	.12 x Dia	4 x Dia
HIGH TEMP ALLOYS																	
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Slotting	.00003	.00006	.00008	1 x Dia	.11 x Dia	.00010	.00012	.00014	.00019	.00029	.00039	.00058	.00078	1 x Dia	.27 x Dia
		Roughing	.00002	.00004	.00006	.13 x Dia	4 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	.25 x Dia	4 x Dia
		Finishing	.00003	.00006	.00009	.06 x Dia	4 x Dia	.00011	.00014	.00016	.00022	.00033	.00043	.00065	.00087	.12 x Dia	4 x Dia

MATERIAL		Hardness: 38-45 Rc (353-421 HBn)													
		SFM	Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia						Depth of Cut	