



Speeds & Feeds

**Product Table:** Variable Helix End Mills for Free Machining Steels - Square - Long Reach, Stub Flute  
**Characteristics:** 5x Reach Multiple  
**Series:** 9150xx-C3, 9151xx-C3

Material	Hardness (HBn)	SFM		Chip Load (IPT) By Cutter Diameter											Depth of Cut			
				0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.500	Radial	Axial	
CARBON STEELS  10xx - 1030, 10Lxx, 11xx - 1140, 11Lxx, 12xx - 1215, 12Lxx	100-125	500	Slotting	.00012	.00026	.00039	.00051	.00065	.00077	.00099	.00148	.00198	.00259	.00311	.00415	1x Dia	.35x Dia	
	125-150	425	Roughing	.00015	.00031	.00047	.00062	.00079	.00094	.00120	.00180	.00240	.00314	.00378	.00504	.35x Dia	.5x - 1x Dia	
	150-175	400		Finishing	.00018	.00037	.00057	.00075	.00094	.00112	.00144	.00215	.00288	.00377	.00453	.00604	.1x Dia	.5x - 1x Dia
STAINLESS STEELS  203 EZ, 303 (all types), 416, 416 Se, 416 Plus X, 420 F, 420 F Se	175-200	375	Max		.00023	.00048	.00073	.00096	.00121	.00145	.00185	.00277	.00370	.00485	.00583	.00777	-	-
	200-225	350																

**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 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.