



Speeds & Feeds

Product Table: End Mills for Hardened Steels - Finishers - Ball - Taper Reach

Characteristics: 3° Taper, 2 Flutes

Series: 9949xx-C6

Material	Hardness	SFM	Chip Load (IPT) By Cutter Diameter												Depth of Cut		
				.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	.500	Radial	Axial
Hardened Steels	45-55 Rc	700	Finishing	.00026	.00053	.00081	.00106	.00134	.00160	.00215	.00321	.00429	.00535	.00644	.00858	.10 x Dia	.04 x Dia
	56-68 Rc	600	Finishing	.00021	.00043	.00065	.00085	.00107	.00128	.00172	.00257	.00343	.00428	.00515	.00686	.07 x Dia	.04 x Dia

Product Notes:

Posted values represent a 5x Reach. Use the table below to adjust Chip Load (IPT) and Depths of Cut for tools with longer reach.

Reach Multiple	Chip Load	Depth of Cut (45-55 Rc)		Depth of Cut (56-68 Rc)	
		Radial*	Axial	Radial*	Axial
5x	100%	100%	100%	100%	100%
8x	88%	100%	75%	100%	75%
10x	80%	100%	50%	100%	50%
12x	70%	80%	50%	86%	50%
15x	65%	80%	25%	86%	25%
18x	65%	80%	25%	86%	25%
20x	60%	80%	25%	86%	25%
25x	60%	80%	25%	86%	25%
30x	55%	60%	25%	57%	25%
40x	50%	60%	25%	57%	25%
50x	45%	50%	25%	43%	25%
60x	40%	50%	25%	43%	25%

* Radial DOC values represent typical starting parameters. For other finish options, consult a Cusp Height & Finish chart.

General Notes:

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.