

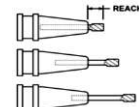


Speeds & Feeds

Product Table: End Mills - Corner Radius - Reduced Shank
Characteristics: 4 Flutes
Series: 176xx

Product Notes:
Reduced shank end mills can be chucked at a variety of reach lengths. Posted values reflect a 3x reach length (ex. a 1/8 diameter mill chucked at a 3/8 reach). When chucking at longer reach lengths, use the table below for Chip Load and Depth of Cut adjustment multipliers.

Table with columns for Reach Multiple, Slotting, Roughing, and Finishing, each with sub-columns for Chip Load, Radial, and Axial.



General Notes:

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

Main table for materials with hardness <= 28 Rc. Columns include MATERIAL, SFM, Chip Load (IPT) by Cutter Diameter, and Depth of Cut (Radial, Axial).

Main table for materials with hardness 29-37 Rc. Columns include MATERIAL, SFM, Chip Load (IPT) by Cutter Diameter, and Depth of Cut (Radial, Axial).

Main table for materials with hardness 38-45 Rc. Columns include SFM, Chip Load (IPT) by Cutter Diameter, and Depth of Cut (Radial, Axial).