

MATERIAL	Hardness: ≤ 28 Rc (≤ 271 HBn)														
	SFM	Chip Load (IPT) By Cutter Dia			Depth of Cut		Chip Load (IPT) By Cutter Dia					Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial	
ALUMINUM ALLOYS	750														
Casting (2xx, 5xx, 7xx, 8xx)	1000	Finishing	.00005	.00011	.00016	.03 x Dia	10 x Dia	.00019	.00024	.00028	.00038	.00056	.00075	.06 x Dia	10 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	750														
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700														
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Finishing	.00005	.00010	.00015	.03 x Dia	10 x Dia	.00017	.00021	.00025	.00034	.00051	.00068	.06 x Dia	10 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475														
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1000														
Wrought - 5%-8% Si (4xxx)	800														
Wrought - 8%-12% Si (4xxx)	1500	Finishing	.00005	.00011	.00016	.03 x Dia	10 x Dia	.00019	.00024	.00028	.00038	.00056	.00075	.06 x Dia	10 x Dia
MAGNESIUM ALLOYS	800														
ZINC ALLOYS	225														
High Coppers - 90%+ (C1xxxx)	500														
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	225														
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	500	Finishing	.00004	.00009	.00013	.03 x Dia	10 x Dia	.00015	.00019	.00022	.00030	.00045	.00060	.06 x Dia	10 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500														
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	225														
Copper Nicksels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	550														
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)															



Speeds & Feeds

Product Table: Miniature End Mills - Tapered - Ball
Characteristics: 5°-6° Angle per Side, 10x Length of Cut
Series: 326xx, 8356xx

Product Notes:
 Use the end diameter of the tool to select the correct Chip Load (IPT)

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 appropriate safety equipment in the vicinity of use.

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)														
	SFM	Chip Load (IPT) By Cutter Dia			Depth of Cut		Chip Load (IPT) By Cutter Dia					Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial	
CARBON STEELS	600	Finishing	.00002	.00003	.00005	.03 x Dia	10 x Dia	.00006	.00007	.00009	.00012	.00018	.00024	.06 x Dia	10 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	200	Finishing	.00001	.00003	.00005	.03 x Dia	10 x Dia	.00005	.00007	.00008	.00011	.00016	.00022	.06 x Dia	10 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4Lxx, 50xx & 5Lxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx	450	Finishing	.00002	.00003	.00005	.03 x Dia	10 x Dia	.00006	.00007	.00009	.00012	.00018	.00024	.06 x Dia	10 x Dia
STAINLESS STEELS	200	Finishing	.00001	.00003	.00005	.03 x Dia	10 x Dia	.00005	.00007	.00008	.00011	.00016	.00022	.06 x Dia	10 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	150	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	200	Finishing	.00001	.00003	.00005	.03 x Dia	10 x Dia	.00005	.00007	.00008	.00011	.00016	.00022	.06 x Dia	10 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	150	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
TOOL STEELS	200	Finishing	.00001	.00003	.00005	.03 x Dia	10 x Dia	.00005	.00007	.00008	.00011	.00016	.00022	.06 x Dia	10 x Dia
A, L, O, P, W series	150	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
D, H, M, T, S series	150	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
TITANIUM ALLOYS	70	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
HIGH TEMP ALLOYS	50	Finishing	.00001	.00002	.00003	.03 x Dia	10 x Dia	.00003	.00004	.00005	.00007	.00010	.00013	.06 x Dia	10 x Dia
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discolloy, Incoloy															

MATERIAL	Hardness: 38-45 Rc (353-421 HBn)														
	SFM	Chip Load (IPT) By Cutter Dia			Depth of Cut		Chip Load (IPT) By Cutter Dia					Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	Radial	Axial	
	100	Finishing	.00001	.00002	.00002	.03 x Dia	10 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.06 x Dia	10 x Dia
	90	Finishing	.00000	.00001	.00001	.03 x Dia	10 x Dia	.00002	.00002	.00003	.00003	.00005	.00007	.06 x Dia	10 x Dia
	100	Finishing	.00001	.00002	.00002	.03 x Dia	10 x Dia	.00003	.00003	.00004	.00005	.00008	.00011	.06 x Dia	10 x Dia
	90	Finishing	.00000	.00001	.00001	.03 x Dia	10 x Dia	.00002	.00002	.00003	.00003	.00005	.00007	.06 x Dia	10 x Dia
	75	Finishing	.00000	.00001	.00001	.03 x Dia	10 x Dia	.00002	.00002	.00003	.00003	.00005	.00007	.06 x Dia	10 x Dia
	50	Finishing	.00000	.00001	.00001	.03 x Dia	10 x Dia	.00002	.00002	.00003	.00003	.00005	.00007	.06 x Dia	10 x Dia