HARVEY TOOL

Speeds & Feeds

Product Table: Miniature End Mills - Square - Long Reach, Stub Flute
Characteristics: 3x Reach Multiple
Series: 478xx, 9784xx

MATERIAL	SFM		Hardness: ≤ 28 Rc (≤ 271 HBn)															
			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	750	Slotting	.00020	.00042	.00064	1 x Dia	.14 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.35 x Dia
Casting (2xx, 5xx, 7xx, 8xx)		Roughing	.00026	.00053	.00080	.33 x Dia	.45 x Dia	.00092	.00116	.00138	.00186	.00278	.00371	.00557	.00743	.65 x Dia	.45 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00038	.00078	.00118	.08 x Dia	1.5 x Dia	.00136	.00171	.00204	.00274	.00410	.00547	.00821	.01095	.15 x Dia	1.5 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00018	.00038	.00058	1 x Dia	.14 x Dia	.00066	.00083	.00099	.00134	.00200	.00267	.00401	.00535	1 x Dia	.35 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700																
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Roughing	.00023	.00048	.00072	.33 x Dia	.45 x Dia	.00083	.00104	.00124	.00167	.00250	.00334	.00501	.00668	.65 x Dia	.45 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475																
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00034	.00070	.00107	.08 x Dia	1.5 x Dia	.00122	.00154	.00183	.00246	.00369	.00493	.00739	.00985	.15 x Dia	1.5 x Dia
Wrought - 8%-12% Si (4xxx)	800																
MAGNESIUM ALLOYS	1500	Slotting	.00020	.00042	.00064	1 x Dia	.14 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	1 x Dia	.35 x Dia
		Roughing	.00026	.00053	.00080	.33 x Dia	.45 x Dia	.00092	.00116	.00138	.00186	.00278	.00371	.00557	.00743	.65 x Dia	.45 x Dia
ZINC ALLOYS	800	Finishing	.00038	.00078	.00118	.08 x Dia	1.5 x Dia	.00136	.00171	.00204	.00274	.00410	.00547	.00821	.01095	.15 x Dia	1.5 x Dia
COPPER ALLOYS																	
High Coppers - 90%+ (C1xxxx)	225	Slotting	.00016	.00034	.00051	1 x Dia	.14 x Dia	.00059	.00074	.00088	.00119	.00178	.00238	.00356	.00475	1 x Dia	.35 x Dia
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500																
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225	Roughing	.00020	.00042	.00064	.33 x Dia	.45 x Dia	.00074	.00093	.00110	.00149	.00222	.00297	.00446	.00594	.65 x Dia	.45 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500																
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500																
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225																
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Finishing	.00030	.00062	.00095	.08 x Dia	1.5 x Dia	.00109	.00137	.00163	.00219	.00328	.00438	.00657	.00876	.15 x Dia	1.5 x Dia

MATERIAL	SFM		Hardness: 29-37 Rc (279-344 HBn)															
			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	600	Slotting	.00007	.00015	.00022	1 x Dia	.14 x Dia	.00025	.00032	.00038	.00051	.00076	.00102	.00153	.00204	1 x Dia	.35 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx		Roughing	.00008	.00016	.00025	.33 x Dia	.45 x Dia	.00028	.00036	.00043	.00057	.00086	.00115	.00172	.00230	.65 x Dia	.45 x Dia
		Finishing	.00012	.00024	.00037	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.00128	.00171	.00257	.00342	.15 x Dia	1.5 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	Slotting	.00006	.00013	.00020	1 x Dia	.14 x Dia	.00023	.00029	.00035	.00047	.00070	.00093	.00140	.00187	1 x Dia	.35 x Dia
		Roughing	.00007	.00015	.00023	.33 x Dia	.45 x Dia	.00026	.00033	.00039	.00052	.00079	.00105	.00157	.00210	.65 x Dia	.45 x Dia
		Finishing	.00011	.00022	.00034	.08 x Dia	1.5 x Dia	.00039	.00049	.00058	.00078	.00117	.00156	.00235	.00313	.15 x Dia	1.5 x Dia
STAINLESS STEELS	450	Slotting	.00007	.00015	.00022	1 x Dia	.14 x Dia	.00025	.00032	.00038	.00051	.00076	.00102	.00153	.00204	1 x Dia	.35 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe		Roughing	.00008	.00016	.00025	.33 x Dia	.45 x Dia	.00028	.00036	.00043	.00057	.00086	.00115	.00172	.00230	.65 x Dia	.45 x Dia
		Finishing	.00012	.00024	.00037	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.00128	.00171	.00257	.00342	.15 x Dia	1.5 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	.00006	.00013	.00020	1 x Dia	.14 x Dia	.00023	.00029	.00035	.00047	.00070	.00093	.00140	.00187	1 x Dia	.35 x Dia
		Roughing	.00007	.00015	.00023	.33 x Dia	.45 x Dia	.00026	.00033	.00039	.00052	.00079	.00105	.00157	.00210	.65 x Dia	.45 x Dia
		Finishing	.00011	.00022	.00034	.08 x Dia	1.5 x Dia	.00039	.00049	.00058	.00078	.00117	.00156	.00235	.00313	.15 x Dia	1.5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00004	.00008	.00013	1 x Dia	.14 x Dia	.00014	.00018	.00022	.00029	.00044	.00058	.00087	.00117	1 x Dia	.35 x Dia
		Roughing	.00005	.00009	.00014	.33 x Dia	.45 x Dia	.00016	.00020	.00024	.00033	.00049	.00066	.00098	.00131	.65 x Dia	.45 x Dia
		Finishing	.00007	.00014	.00021	.08 x Dia	1.5 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.15 x Dia	1.5 x Dia
TOOL STEELS	200	Slotting	.00006	.00013	.00020	1 x Dia	.14 x Dia	.00023	.00029	.00035	.00047	.00070	.00093	.00140	.00187	1 x Dia	.35 x Dia
A, L, O, P, W series		Roughing	.00007	.00015	.00023	.33 x Dia	.45 x Dia	.00026	.00033	.00039	.00052	.00079	.00105	.00157	.00210	.65 x Dia	.45 x Dia
		Finishing	.00011	.00022	.00034	.08 x Dia	1.5 x Dia	.00039	.00049	.00058	.00078	.00117	.00156	.00235	.00313	.15 x Dia	1.5 x Dia
D, H, M, T, S series	150	Slotting	.00004	.00008	.00013	1 x Dia	.14 x Dia	.00014	.00018	.00022	.00029	.00044	.00058	.00087	.00117	1 x Dia	.35 x Dia
		Roughing	.00005	.00009	.00014	.33 x Dia	.45 x Dia	.00016	.00020	.00024	.00033	.00049	.00066	.00098	.00131	.65 x Dia	.45 x Dia
		Finishing	.00007	.00014	.00021	.08 x Dia	1.5 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.15 x Dia	1.5 x Dia
TITANIUM ALLOYS	150	Slotting	.00004	.00008	.00013	1 x Dia	.14 x Dia	.00014	.00018	.00022	.00029	.00044	.00058	.00087	.00117	1 x Dia	.35 x Dia
		Roughing	.00005	.00009	.00014	.33 x Dia	.45 x Dia	.00016	.00020	.00024	.00033	.00049	.00066	.00098	.00131	.65 x Dia	.45 x Dia
		Finishing	.00007	.00014	.00021	.08 x Dia	1.5 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.15 x Dia	1.5 x Dia
HIGH TEMP ALLOYS	70	Slotting	.00004	.00008	.00013	1 x Dia	.14 x Dia	.00014	.00018	.00022	.00029	.00044	.00058	.00087	.00117	1 x Dia	.35 x Dia
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy		Roughing	.00005	.00009	.00014	.33 x Dia	.45 x Dia	.00016	.00020	.00024	.00033	.00049	.00066	.00098	.00131	.65 x Dia	.45 x Dia
		Finishing	.00007	.00014	.00021	.08 x Dia	1.5 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.15 x Dia	1.5 x Dia

SFM		Hardness: 38-45 Rc (353-421 HBn)															
		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
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
100	Slotting	.00003	.00007	.00010	1 x Dia	.14 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00093	1 x Dia	.35 x Dia
	Roughing	.00004	.00007	.00011	.33 x Dia	.45 x Dia	.00013	.00016	.00020	.00026	.00039	.00052	.00079	.00105	.65 x Dia	.45 x Dia
	Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia
90	Slotting	.00002	.00004	.00006	1 x Dia	.14 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	1 x Dia	.35 x Dia
	Roughing	.00002	.00005	.00007	.33 x Dia	.45 x Dia	.00008	.00010	.00012	.00016	.00025	.00033	.00049	.00066	.65 x Dia	.45 x Dia
	Finishing	.00003	.00007	.00011	.08 x Dia	1.5 x Dia	.00012	.00015	.00018	.00025	.00037	.00049	.00074	.00099	.15 x Dia	1.5 x Dia
100	Slotting	.00003	.00007	.00010	1 x Dia	.14 x Dia	.00012	.00015	.00017	.00023	.00035	.00047	.00070	.00093	1 x Dia	.35 x Dia
	Roughing	.00004	.00007	.00011	.33 x Dia	.45 x Dia	.00013	.00016	.00020	.00026	.00039	.00052	.00079	.00105	.65 x Dia	.45 x Dia
	Finishing	.00005	.00011	.00017	.08 x Dia	1.5 x Dia	.00020	.00025	.00029	.00039	.00059	.00079	.00118	.00158	.15 x Dia	1.5 x Dia
90	Slotting	.00002	.00004	.00006	1 x Dia	.14 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	1 x Dia	.35 x Dia
	Roughing	.00002	.00005	.00007	.33 x Dia	.45 x Dia	.00008	.00010	.00012	.00016	.00025	.00033	.00049	.00066	.65 x Dia	.45 x Dia
	Finishing	.00003	.00007	.00011	.08 x Dia	1.5 x Dia	.00012	.00015	.00018	.00025	.00037	.00049	.00074	.00099	.15 x Dia	1.5 x Dia
75	Slotting	.00002	.00004	.00006	1 x Dia	.14 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	1 x Dia	.35 x Dia
	Roughing	.00002	.00005	.00007	.33 x Dia	.45 x Dia	.00008	.00010	.00012	.00016	.00025	.00033	.00049	.00066	.65 x Dia	.45 x Dia
	Finishing	.00003	.00007	.00011	.08 x Dia	1.5 x Dia	.00012	.00015	.00018	.00025	.00037	.00049	.00074	.00099	.15 x Dia	1.5 x Dia
50	Slotting	.00002	.00004	.00006	1 x Dia	.14 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00058	1 x Dia	.35 x Dia
	Roughing	.00002	.00005	.00007	.33 x Dia	.45 x Dia	.00008	.00010	.00012	.00016	.00025	.00033	.00049	.00066	.65 x Dia	.45 x Dia
	Finishing	.00003	.00007	.00011	.08 x Dia	1.5 x Dia	.00012	.00015	.00018	.00025	.00037	.00049	.00074	.00099	.15 x Dia	1.5 x Dia

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.