



Speeds & Feeds

**Product Table:** Variable Helix End Mills for Aluminum Alloys - Finishers - Square

**Characteristics:** 5x Length of Cut

**Series:** 667xx, 668xx, 9155xx, 667xx-C8, 668xx-C8, 9155xx-C8

Cutter Series	MATERIAL	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	
Uncoated	<b>ALUMINUM ALLOYS</b>		Finishing	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00442	.00532	.00709	.09x Dia	.5x - 5x Dia
	Casting (2xx, 5xx, 7xx, 8xx)	750															
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000															
	<b>MAGNESIUM ALLOYS</b>	1500															
	<b>ZINC ALLOYS</b>	800															
	<b>COPPER ALLOYS</b>																
	High Coppers - 90%+ (C1xxxx)	225															
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500															
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225															
	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																
TiB2	<b>ALUMINUM ALLOYS</b>		Finishing	.00026	.00054	.00082	.00109	.00137	.00163	.00219	.00328	.00439	.00575	.00691	.00921	.09x Dia	.5x - 5x Dia
	Casting (2xx, 5xx, 7xx, 8xx)	1000															
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1400															
	<b>MAGNESIUM ALLOYS</b>	2000															
<b>ZINC ALLOYS</b>	1100																

**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 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](mailto: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.