



Speeds & Feeds

**Product Table:** Miniature End Mills - Square - Long Reach, Standard Flute  
**Characteristics:** 6x, 7x, 8x, 9x Reach Multiple, 3x Length of Cut, 2 Flutes  
**Series:** 762xx, 763xx, 8987xx, 9608xx, 9609xx

**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](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.

MATERIAL		Hardness: ≤ 28 Rc (≤ 271 HBn)																
		SFM	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	
<b>ALUMINUM ALLOYS</b>		750	Slotting	.0010	.0021	.0032	1 x Dia	.07 x Dia	.00037	.00047	.00056	.00075	.00112	.00150	.00224	.00299	1 x Dia	.18 x Dia
Casting (2xx, 5xx, 7xx, 8xx)			Roughing	.00013	.00027	.00040	.28 x Dia	.30 x Dia	.00046	.00058	.00070	.00094	.00140	.00187	.00281	.00374	.55 x Dia	.30 x Dia
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)		1000	Finishing	.00022	.00045	.00068	.05 x Dia	3 x Dia	.00078	.00098	.00116	.00156	.00234	.00313	.00469	.00626	.10 x Dia	3 x Dia
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)		750	Slotting	.00009	.00019	.00029	1 x Dia	.07 x Dia	.00033	.00042	.00050	.00067	.00101	.00135	.00202	.00269	1 x Dia	.18 x Dia
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)		700	Slotting	.00009	.00019	.00029	1 x Dia	.07 x Dia	.00033	.00042	.00050	.00067	.00101	.00135	.00202	.00269	1 x Dia	.18 x Dia
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)		650	Roughing	.00012	.00024	.00036	.28 x Dia	.30 x Dia	.00042	.00053	.00063	.00084	.00126	.00168	.00252	.00337	.55 x Dia	.30 x Dia
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)		475	Slotting	.00009	.00019	.00029	1 x Dia	.07 x Dia	.00033	.00042	.00050	.00067	.00101	.00135	.00202	.00269	1 x Dia	.18 x Dia
Wrought - 5%-8% Si (4xxx)		1000	Finishing	.00019	.00040	.00061	.05 x Dia	3 x Dia	.00070	.00088	.00105	.00141	.00211	.00282	.00422	.00563	.10 x Dia	3 x Dia
Wrought - 8%-12% Si (4xxx)		800	Finishing	.00019	.00040	.00061	.05 x Dia	3 x Dia	.00070	.00088	.00105	.00141	.00211	.00282	.00422	.00563	.10 x Dia	3 x Dia
<b>MAGNESIUM ALLOYS</b>		1500	Slotting	.00010	.00021	.00032	1 x Dia	.07 x Dia	.00037	.00047	.00056	.00075	.00112	.00150	.00224	.00299	1 x Dia	.18 x Dia
			Roughing	.00013	.00027	.00040	.28 x Dia	.30 x Dia	.00046	.00058	.00070	.00094	.00140	.00187	.00281	.00374	.55 x Dia	.30 x Dia
<b>ZINC ALLOYS</b>		800	Finishing	.00022	.00045	.00068	.05 x Dia	3 x Dia	.00078	.00098	.00116	.00156	.00234	.00313	.00469	.00626	.10 x Dia	3 x Dia
<b>COPPER ALLOYS</b>		225	Slotting	.00008	.00017	.00026	1 x Dia	.07 x Dia	.00030	.00037	.00045	.00060	.00090	.00120	.00180	.00239	1 x Dia	.18 x Dia
High Coppers - 90%+ (C1xxx)		500	Slotting	.00008	.00017	.00026	1 x Dia	.07 x Dia	.00030	.00037	.00045	.00060	.00090	.00120	.00180	.00239	1 x Dia	.18 x Dia
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C69800)		225	Slotting	.00008	.00017	.00026	1 x Dia	.07 x Dia	.00030	.00037	.00045	.00060	.00090	.00120	.00180	.00239	1 x Dia	.18 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)		225	Slotting	.00008	.00017	.00026	1 x Dia	.07 x Dia	.00030	.00037	.00045	.00060	.00090	.00120	.00180	.00239	1 x Dia	.18 x Dia
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)		500	Roughing	.00010	.00021	.00032	.28 x Dia	.30 x Dia	.00037	.00047	.00056	.00075	.00112	.00150	.00224	.00299	.55 x Dia	.30 x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C68100)		500	Roughing	.00010	.00021	.00032	.28 x Dia	.30 x Dia	.00037	.00047	.00056	.00075	.00112	.00150	.00224	.00299	.55 x Dia	.30 x Dia
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)		225	Slotting	.00008	.00017	.00026	1 x Dia	.07 x Dia	.00030	.00037	.00045	.00060	.00090	.00120	.00180	.00239	1 x Dia	.18 x Dia
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)		550	Finishing	.00017	.00036	.00054	.05 x Dia	3 x Dia	.00062	.00078	.00093	.00125	.00187	.00250	.00375	.00501	.10 x Dia	3 x Dia

MATERIAL		Hardness: 29-37 Rc (279-344 HBn)																
		SFM	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	
<b>CARBON STEELS</b>		600	Slotting	.00004	.00007	.00011	1 x Dia	.07 x Dia	.00013	.00016	.00019	.00026	.00038	.00051	.00077	.00103	1 x Dia	.18 x Dia
Free-Machining/Low Carbon steels, 10xx-1029 & all 10Lxx, 11xx-1139 & all 11Lxx, 12xx-1215 & all 12Lxx			Roughing	.00004	.00008	.00013	.28 x Dia	.30 x Dia	.00014	.00018	.00022	.00029	.00043	.00058	.00087	.00116	.55 x Dia	.30 x Dia
			Finishing	.00007	.00014	.00021	.05 x Dia	3 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.10 x Dia	3 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 44Lxx, 50xx & 54Lxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx		200	Slotting	.00003	.00007	.00010	1 x Dia	.07 x Dia	.00012	.00015	.00017	.00024	.00035	.00047	.00071	.00094	1 x Dia	.18 x Dia
		Roughing	.00004	.00008	.00011	.28 x Dia	.30 x Dia	.00013	.00016	.00020	.00026	.00040	.00053	.00079	.00106	.55 x Dia	.30 x Dia	
		Finishing	.00006	.00013	.00019	.05 x Dia	3 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	.10 x Dia	3 x Dia	
<b>STAINLESS STEELS</b>		450	Slotting	.00004	.00007	.00011	1 x Dia	.07 x Dia	.00013	.00016	.00019	.00026	.00038	.00051	.00077	.00103	1 x Dia	.18 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe			Roughing	.00004	.00008	.00013	.28 x Dia	.30 x Dia	.00014	.00018	.00022	.00029	.00043	.00058	.00087	.00116	.55 x Dia	.30 x Dia
			Finishing	.00007	.00014	.00021	.05 x Dia	3 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.00147	.00196	.10 x Dia	3 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	.00003	.00007	.00010	1 x Dia	.07 x Dia	.00012	.00015	.00017	.00024	.00035	.00047	.00071	.00094	1 x Dia	.18 x Dia
		Roughing	.00004	.00008	.00011	.28 x Dia	.30 x Dia	.00013	.00016	.00020	.00026	.00040	.00053	.00079	.00106	.55 x Dia	.30 x Dia	
		Finishing	.00006	.00013	.00019	.05 x Dia	3 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	.10 x Dia	3 x Dia	
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7		150	Slotting	.00002	.00004	.00006	1 x Dia	.07 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00059	1 x Dia	.18 x Dia
		Roughing	.00002	.00005	.00007	.28 x Dia	.30 x Dia	.00008	.00010	.00012	.00017	.00025	.00033	.00050	.00066	.55 x Dia	.30 x Dia	
		Finishing	.00004	.00008	.00012	.05 x Dia	3 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	.10 x Dia	3 x Dia	
<b>TOOL STEELS</b>		200	Slotting	.00003	.00007	.00010	1 x Dia	.07 x Dia	.00012	.00015	.00017	.00024	.00035	.00047	.00071	.00094	1 x Dia	.18 x Dia
A, L, O, P, W series			Roughing	.00004	.00008	.00011	.28 x Dia	.30 x Dia	.00013	.00016	.00020	.00026	.00040	.00053	.00079	.00106	.55 x Dia	.30 x Dia
			Finishing	.00006	.00013	.00019	.05 x Dia	3 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.00134	.00179	.10 x Dia	3 x Dia
D, H, M, T, S series		150	Slotting	.00002	.00004	.00006	1 x Dia	.07 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00059	1 x Dia	.18 x Dia
		Roughing	.00002	.00005	.00007	.28 x Dia	.30 x Dia	.00008	.00010	.00012	.00017	.00025	.00033	.00050	.00066	.55 x Dia	.30 x Dia	
		Finishing	.00004	.00008	.00012	.05 x Dia	3 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	.10 x Dia	3 x Dia	
<b>TITANIUM ALLOYS</b>		150	Slotting	.00002	.00004	.00006	1 x Dia	.07 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00059	1 x Dia	.18 x Dia
		Roughing	.00002	.00005	.00007	.28 x Dia	.30 x Dia	.00008	.00010	.00012	.00017	.00025	.00033	.00050	.00066	.55 x Dia	.30 x Dia	
		Finishing	.00004	.00008	.00012	.05 x Dia	3 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	.10 x Dia	3 x Dia	
<b>HIGH TEMP ALLOYS</b>		70	Slotting	.00002	.00004	.00006	1 x Dia	.07 x Dia	.00007	.00009	.00011	.00015	.00022	.00029	.00044	.00059	1 x Dia	.18 x Dia
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy			Roughing	.00002	.00005	.00007	.28 x Dia	.30 x Dia	.00008	.00010	.00012	.00017	.00025	.00033	.00050	.00066	.55 x Dia	.30 x Dia
			Finishing	.00004	.00008	.00012	.05 x Dia	3 x Dia	.00014	.00017	.00021	.00028	.00042	.00056	.00084	.00112	.10 x Dia	3 x Dia

MATERIAL		Hardness: 38-45 Rc (353-421 HBn)																
		SFM	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	
			Slotting	-	-	-	1 x Dia	.07 x Dia	-	-	-	-	-	-	-	-	-	-
			Roughing	-	-	-	.28 x Dia	.30 x Dia	-	-	-	-	-	-	-	-	-	-
			Finishing	-	-	-	.05 x Dia	3 x Dia	-	-	-	-	-	-	-	-	-	-
		100	Slotting	.00002	.00003	.00005	1 x Dia	.07 x Dia	.00006	.00007	.00009	.00012	.00018	.00024	.00035	.00047	1 x Dia	.18 x Dia
			Roughing	.00002	.00004	.00006	.28 x Dia	.30 x Dia	.00007	.00008	.00010	.00013	.00020	.00026	.00040	.00053	.55 x Dia	.30 x Dia
			Finishing	.00003	.00006	.00010	.05 x Dia	3 x Dia	.00011	.00014	.00017	.00023	.00034	.00045	.00068	.00090	.10 x Dia	3 x Dia
		90</																