



Speeds & Feeds

Product Table: Miniature End Mills - Corner Radius - Long Flute
Characteristics: 5x Length of Cut, 4 Flutes
Series: 7936xx, 8008xx, 8309xx, 8842xx, 8850xx, 8858xx, 8866xx, 9125xx, 9126xx, 9281xx, 9171xx, 9324xx, 9509xx, 9596xx, 9643xx, 9644xx, 9814xx

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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, Chip Load (IPT) by Cutter Dia, Depth of Cut. Hardness: ≤ 28 Rc (≤ 271 HBn)

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, Chip Load (IPT) by Cutter Dia, Depth of Cut. Hardness: 29-37 Rc (279-344 HBn)

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, Chip Load (IPT) by Cutter Dia, Depth of Cut. Hardness: 38-45 Rc (353-421 HBn)