



Speeds & Feeds

**Product Table:** Engraving Cutters - Tip Radius - 2 Flute - For Hardened Steels  
**Characteristics:** 2 Flutes

| Series or Item | RPM   | Chip Load (IPT) by Material |            | Axial DOC |
|----------------|-------|-----------------------------|------------|-----------|
|                |       | Hardened Steels             |            |           |
|                |       | 45 < 55 Rc                  | 56 < 68 Rc |           |
| 8208xx-C6      | 6000+ | .00032                      | .00025     | < .005    |
| 8209xx-C6      | 6000+ | .00029                      | .00023     | < .006    |
| 8210xx-C6      | 6000+ | .00020                      | .00016     | < .007    |
| 8211xx-C6      | 6000+ | .00032                      | .00025     | < .008    |
| 8212xx-C6      | 6000+ | .00020                      | .00016     | < .009    |
| 8371xx-C6      | 6000+ | .00040                      | .00032     | < .010    |
| 8375xx-C6      | 6000+ | .00026                      | .00020     | < .010    |
| 8381xx-C6      | 6000+ | .00034                      | .00027     | < .010    |
| 8437xx-C6      | 6000+ | .00025                      | .00020     | < .010    |
| 8458xx-C6      | 6000+ | .00036                      | .00029     | < .010    |
| 8490xx-C6      | 6000+ | .00036                      | .00029     | < .010    |
| 8512xx-C6      | 6000+ | .00025                      | .00020     | < .010    |
| 8531xx-C6      | 6000+ | .00035                      | .00028     | < .010    |
| 8575xx-C6      | 6000+ | .00022                      | .00017     | < .010    |
| 8583xx-C6      | 6000+ | .00022                      | .00018     | < .010    |
| 8593xx-C6      | 6000+ | .00029                      | .00023     | < .010    |
| 8600xx-C6      | 6000+ | .00034                      | .00027     | < .010    |
| 8694xx-C6      | 6000+ | .00025                      | .00020     | < .010    |
| 8733xx-C6      | 6000+ | .00036                      | .00029     | < .010    |
| 8773xx-C6      | 6000+ | .00036                      | .00029     | < .010    |

**Please note:**

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions (minimal runout is required for best results).

Suggested speed is 6000 rpm or more. Choose an rpm value that creates the least amount of internal machine vibration. In many cases, a speed increaser is helpful.  
Posted chip loads reflect axial depths of cut up to .009. For depths of cut = .010" -.015", reduce posted chip loads by 20%. For depths of cut = .016" -.020", reduce posted chip loads by 30%.  
Posted chip loads reflect uncoated cutters. Coating is better suited to prolong tool life rather than decrease cycle times.  
Posted chip loads reflect HORIZONTAL milling conditions. For VERTICAL plunge milling to depth, reduce posted chip loads by 70% (Do not plunge more than .009" depth, ramping is preferred to maintain tip integrity).

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.