



Speeds & Feeds

Product Table: Variable Helix End Mills for High Temp Alloys - Square

Characteristics: 1.5x Length of Cut, 4 Flutes

Series: 8416xx-C6, 9738xx-C6

Material	Hardness (HBn)	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
Stainless Steels: 40x, 41x, 42x, 43x, 44x, 13-8, 15-5, 15-7, 17-4, 17-7	275 - 300	160	Slotting	.00005	.00011	.00017	.00022	.00028	.00033	.00045	.00067	.00089	.00117	.00140	.00187	1x Dia	.4x Dia
	300 - 350	140															
Tool Steels: D, H, M, T, S series	350 - 400	100															
	400 - 425	80															
Titanium: All alloys	275 - 300	200	Roughing	.00007	.00014	.00021	.00028	.00035	.00042	.00057	.00085	.00113	.00149	.00179	.00238	.4x Dia	.5x - .7x Dia
	300 - 350	125	Finishing	.00009	.00018	.00028	.00037	.00046	.00055	.00074	.00111	.00149	.00195	.00234	.00312	.1x Dia	.5x - 1x Dia
	350 - 400	75															
	400 - 425	75															
275 - 300	80																
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discology, Incoloy	300 - 350	60	Max	.00011	.00022	.00034	.00044	.00056	.00066	.00089	.00133	.00178	.00234	.00281	.00374	-	-
	350 - 400	50															
	400 - 425	40															

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**.
 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.