



Speeds & Feeds

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

Characteristics: 4x Length of Cut

Series: 8572xx, 8573xx, 8572xx-C8, 8573xx-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	ALUMINUM ALLOYS																
	Casting (2xx, 5xx, 7xx, 8xx)	750	Slotting	.00015	.00031	.00047	.00061	.00077	.00092	.00124	.00185	.00248	.00324	.00390	.00520	1x Dia	.35x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Roughing	.00017	.00036	.00054	.00072	.00090	.00107	.00144	.00216	.00289	.00378	.00455	.00606	.35x Dia	.5x - 1x Dia
	MAGNESIUM ALLOYS	1500	Finishing	.00019	.00038	.00058	.00077	.00097	.00115	.00155	.00231	.00309	.00405	.00487	.00650	.1x Dia	.5x - 1x Dia
	ZINC ALLOYS	800	Max	.00020	.00041	.00062	.00082	.00103	.00123	.00165	.00247	.00330	.00432	.00520	.00693	-	-
	COPPER ALLOYS																
	High Coppers - 90%+ (C1xxxx)	225	Slotting	.00012	.00025	.00037	.00049	.00062	.00074	.00099	.00148	.00198	.00259	.00312	.00416	1x Dia	.35x Dia
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500	Roughing	.00014	.00029	.00043	.00057	.00072	.00086	.00116	.00173	.00231	.00303	.00364	.00485	.35x Dia	.5x - 1x Dia
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225		.00014	.00029	.00043	.00057	.00072	.00086	.00116	.00173	.00231	.00303	.00364	.00485	.35x Dia	.5x - 1x Dia
	Aluminum Bronzes (Copper Aluminum alloys, C66600-C64200)	500		.00015	.00031	.00047	.00061	.00077	.00092	.00124	.00185	.00248	.00324	.00390	.00520	.1x Dia	.5x - 1x Dia
	Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500		.00015	.00031	.00047	.00061	.00077	.00092	.00124	.00185	.00248	.00324	.00390	.00520	.1x Dia	.5x - 1x Dia
	Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225	Max	.00016	.00033	.00050	.00065	.00082	.00098	.00132	.00197	.00264	.00346	.00416	.00554	-	-
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	.00016		.00033	.00050	.00065	.00082	.00098	.00132	.00197	.00264	.00346	.00416	.00554	-	-	
TiB2	ALUMINUM ALLOYS																
	Casting (2xx, 5xx, 7xx, 8xx)	1000	Slotting	.00019	.00040	.00060	.00080	.00100	.00120	.00161	.00241	.00322	.00422	.00507	.00676	1x Dia	.35x Dia
	Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1400	Roughing	.00023	.00047	.00071	.00093	.00117	.00140	.00188	.00281	.00375	.00492	.00591	.00788	.35x Dia	.5x - 1x Dia
	MAGNESIUM ALLOYS	2000	Finishing	.00024	.00050	.00076	.00100	.00125	.00150	.00201	.00301	.00402	.00527	.00633	.00845	.1x Dia	.5x - 1x Dia
ZINC ALLOYS	1100	Max	.00026	.00053	.00081	.00106	.00134	.00160	.00215	.00321	.00429	.00562	.00676	.00901	-	-	
Amorphous Diamond	ALUMINUM (High Silicon)																
	Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	2500	Slotting	.00016	.00034	.00051	.00068	.00085	.00101	.00136	.00204	.00272	.00357	.00429	.00572	1x Dia	.3x Dia
	Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	2000	Roughing	.00019	.00039	.00060	.00079	.00099	.00118	.00159	.00238	.00318	.00416	.00500	.00667	.3x Dia	.3x - .8x Dia
	Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1500		.00019	.00039	.00060	.00079	.00099	.00118	.00159	.00238	.00318	.00416	.00500	.00667	.3x Dia	.3x - .8x Dia
	Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1000	Finishing	.00020	.00042	.00064	.00084	.00106	.00127	.00170	.00255	.00340	.00446	.00536	.00715	.1x Dia	.5x - 1x Dia
	Wrought - 5%-8% Si (4xxx)	2200	Max	.00022	.00045	.00068	.00090	.00113	.00135	.00182	.00272	.00363	.00476	.00572	.00762	-	-
	Wrought - 8%-12% Si (4xxx)	1700		.00022	.00045	.00068	.00090	.00113	.00135	.00182	.00272	.00363	.00476	.00572	.00762	-	-
	COPPER ALLOYS																
	High Coppers - 90%+ (C1xxxx)	800	Slotting	.00013	.00027	.00041	.00054	.00068	.00081	.00109	.00163	.00218	.00285	.00343	.00457	1x Dia	.3x Dia
	Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	1500	Roughing	.00015	.00032	.00048	.00063	.00079	.00095	.00127	.00190	.00254	.00333	.00400	.00534	.3x Dia	.3x - .8x Dia
	Phosphor Bronzes (Copper Tin alloys, C5xxxx)	800		.00015	.00032	.00048	.00063	.00079	.00095	.00127	.00190	.00254	.00333	.00400	.00534	.3x Dia	.3x - .8x Dia
	Aluminum Bronzes (Copper Aluminum alloys, C66600-C64200)	1000		.00016	.00034	.00051	.00068	.00085	.00101	.00136	.00204	.00272	.00357	.00429	.00572	.1x Dia	.5x - 1x Dia
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	1000	.00016		.00034	.00051	.00068	.00085	.00101	.00136	.00204	.00272	.00357	.00429	.00572	.1x Dia	.5x - 1x Dia	
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	800	Max	.00017	.00036	.00055	.00072	.00091	.00108	.00145	.00217	.00290	.00381	.00457	.00610	-	-	
Cast Copper Alloys (C80100-C82800, C86300, C90200-C91700, C96200-C96600, C99300)	150		.00017	.00036	.00055	.00072	.00091	.00108	.00145	.00217	.00290	.00381	.00457	.00610	-	-	
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	750	.00017	.00036	.00055	.00072	.00091	.00108	.00145	.00217	.00290	.00381	.00457	.00610	-	-		

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.