



Speeds & Feeds

Product Table: Variable Helix End Mills for High Temp Alloys - Square - Long Reach, Stub Flute
Characteristics: 7x Reach Multiple, 3 Flutes
Series: 8807xx-C6, 8808xx-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	.00009	.00014	.00019	.00023	.00028	.00038	.00056	.00075	.00098	.00118	.00158	1x Dia	.28x Dia
	300 - 350	140															
	350 - 400	100															
Tool Steels: D, H, M, T, S series	400 - 425	80	Roughing	.00006	.00012	.00018	.00024	.00030	.00036	.00048	.00071	.00096	.00125	.00150	.00201	.28x Dia	.5x - .7x Dia
	275 - 300	200															
Titanium: All alloys	300 - 350	125	Finishing	.00008	.00016	.00024	.00031	.00039	.00047	.00063	.00094	.00125	.00164	.00197	.00263	.1x Dia	.5x - 1x Dia
	350 - 400	75															
	400 - 425	75															
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	275 - 300	80	Max	.00009	.00019	.00028	.00037	.00047	.00056	.00075	.00112	.00150	.00197	.00236	.00315	-	-
	300 - 350	60															
	350 - 400	50															
	400 - 425	40															