HARVEY TOOL

Speeds & Feeds

Product Table: Variable Helix End Mills for High Temp Alloys - Corner Radius - Long Reach, Stub Flute
Characteristics: 10x Reach Multiple, 3 Flutes
Series: 8844xx-C6, 9325xx-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	.00004	.00008	.00012	.00016	.00020	.00024	.00047	.00063	.00253	.00100	.00133	.00266	.26x Dia	0
	300 - 350	140															
Tool Steels: D, H, M, T, S series	350 - 400	100															
	400 - 425	80	Roughing	.00005	.00010	.00015	.00020	.00025	.00030	.00060	.00080	.00322	.00127	.00169	.00338	.5x - 1x Dia	0
Titanium: All alloys	275 - 300	200															
	300 - 350	125															
	350 - 400	75	Finishing	.00006	.00013	.00020	.00026	.00033	.00039	.00079	.00105	.00422	.00166	.00221	.00443	.5x - 1x Dia	0
	400 - 425	75															
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	275 - 300	80															
	300 - 350	60	Max	.00008	.00016	.00024	.00031	.00039	.00047	.00095	.00126	.00506	.00199	.00266	.00531	-	-
	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.