



Speeds & Feeds

Product Table: Miniature End Mills - Corner Radius - Long Reach, Stub Flute Characteristics: 15x Reach Multiple, 4 Flutes Series: 9197xx, 9393xx, 9478xx, 9479xx

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Hardness: ≤ 28 Rc (≤ 271 HBn). Rows include Aluminum Alloys, Magnesium Alloys, Zinc Alloys, Copper Alloys, and High Temp Alloys.

Please note:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. Chip loads reflect uncoated cutters and may be increased 10%-20% if coated. For ferrous materials with hardness ≤ 28 Rc, chip loads can be increased 10%-20%.

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 Harvetechn@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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Hardness: 29-37 Rc (279-344 HBn). Rows include Carbon Steels, Stainless Steels, Tool Steels, Titanium Alloys, and High Temp Alloys.

Table with columns: MATERIAL, SFM, Chip Load (IPT) by Dia, Depth of Cut, and Hardness: 38-45 Rc (353-421 HBn). Rows include Carbon Steels, Stainless Steels, Tool Steels, Titanium Alloys, and High Temp Alloys.