Product Table: Variable Helix End Mills for High Temp Alloys - Corner Radius
Characteristics: 0.8x Length of Cut, 3 Flutes
Series: 9542xx-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															
	300 - 350	140	Slotting	.00006	.00012	.00019	.00025	.00031	.00037	.00050	.00075	.00100	.00131	.00157	.00209	1x Dia	.4x Dia
	350 - 400	100															
Tool Steels: D, H, M, T, S series	400 - 425	80															
	275 - 300	200	Roughing	.00008	.00016	.00024	.00031	.00040	.00047	.00063	.00095	.00127	.00166	.00200	.00266	.4x Dia	.5x - .7x Dia
	300 - 350	125															
Titanium: All alloys	350 - 400	75															
	400 - 425	75	Finishing	.00010	.00021	.00031	.00041	.00052	.00062	.00083	.00124	.00166	.00218	.00261	.00349	.1x Dia	.5x - .8x Dia
	275 - 300	80															
Nickel Alloys: Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	300 - 350	60															
	350 - 400	50	Max	.00012	.00025	.00037	.00049	.00062	.00074	.00100	.00149	.00199	.00261	.00314	.00418	-	-
	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.