



Speeds & Feeds

Product Table: End Mills for Composites - Compression Cutter
Characteristics: CVD Diamond, 3x Length of Cut, 4 Flutes
Series: 9977xx

MATERIAL	SFM	Chip Load (IPT) By Cutter Diameter			Depth of Cut		Chip Load (IPT) By Cutter Diameter											Depth of Cut			
		.015	.031	.047	Radial	Axial	.062	.078	.093	.125	.187	.250	.312	.375	.500	.625	.750	1.000	Radial	Axial	
PLASTICS 21% - 40% Filled or Fiber Reinforced	450 - 750	Roughing	.00015	.00030	.00046	.25 x Dia	1 x Dia	.00053	.00066	.00079	.00106	.00159	.00213	.00266	.00319	.00426	.00532	.00638	.00851	.50 x Dia	1 x Dia
		Profiling	.00012	.00024	.00037	.08 x Dia	3 x Dia	.00042	.00053	.00063	.00085	.00127	.00170	.00212	.00255	.00340	.00426	.00511	.00681	.15 x Dia	3 x Dia

Product Notes:

Due to Edge Rounding and Surface Texture inherent in CVD diamond, plastic materials should be closely supervised for galling and/or flute packing.

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. In cases where starting parameters are not given, traditional carbide speeds & feeds may be substituted (diamond is not suited for ferrous materials or materials with low machinability).

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.