



Speeds & Feeds

Product Table: End Mills for Hardened Steels - Finishers - Corner Radius

Characteristics: 8x Reach Multiple, 4 Flutes

Series: 9990xx-C6, 9991xx-C6

Material	Hardness	SFM		Chip Load (IPT) By Cutter Diameter											Depth of Cut		
				.015	.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	.500	Radial	Axial
Hardened Steels	45-55 RC	700	Finishing	.00008	.00017	.00026	.00034	.00043	.00051	.00068	.00102	.00137	.00170	.00205	.00273	.35 x Dia	.02 x Dia
	56-68 Rc	600	Finishing	.00007	.00014	.00021	.00027	.00034	.00041	.00055	.00082	.00109	.00136	.00164	.00218	.25 x Dia	.02 x Dia

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.