



Speeds & Feeds

Product Table: Miniature End Mills - Ball - Stub & Standard
 Characteristics: 1.5x Length of Cut, 3 Flutes
 Series: 8234xx, 8235xx

Hardness: ≤ 28 Rc (≤ 271 HBn)																			
MATERIAL	SFM	Chip Load (IPT) by Dia						Depth of Cut			Chip Load (IPT) by Cutter Dia					Depth of Cut			
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial			
																	0.015	0.031	0.047
ALUMINUM ALLOYS	750	Slotting	.00019	.00039	.00059	1 x Dia	.20 x Dia	.00068	.00085	.00101	.00136	.00204	.00272	.00408	.00545	1 x Dia	.50 x Dia		
		Roughing	.00025	.00051	.00077	.30 x Dia	1 x Dia	.00088	.00111	.00132	.00178	.00266	.00356	.00534	.00712	.60 x Dia	1 x Dia		
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Finishing	.00027	.00056	.00085	.13 x Dia	1 x Dia	.00097	.00122	.00145	.00196	.00293	.00391	.00587	.00782	.25 x Dia	1 x Dia		
		Slotting	.00017	.00035	.00053	1 x Dia	.20 x Dia	.00061	.00076	.00091	.00123	.00183	.00245	.00368	.00490	1 x Dia	.50 x Dia		
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	Slotting	.00017	.00035	.00053	1 x Dia	.20 x Dia	.00061	.00076	.00091	.00123	.00183	.00245	.00368	.00490	1 x Dia	.50 x Dia		
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Slotting	.00017	.00035	.00053	1 x Dia	.20 x Dia	.00061	.00076	.00091	.00123	.00183	.00245	.00368	.00490	1 x Dia	.50 x Dia		
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Roughing	.00022	.00046	.00069	.30 x Dia	1 x Dia	.00079	.00100	.00119	.00160	.00240	.00320	.00480	.00640	.60 x Dia	1 x Dia		
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475	Slotting	.00017	.00035	.00053	1 x Dia	.20 x Dia	.00061	.00076	.00091	.00123	.00183	.00245	.00368	.00490	1 x Dia	.50 x Dia		
Wrought - 5%-8% Si (4xxx)	1000	Finishing	.00024	.00050	.00076	.13 x Dia	1 x Dia	.00087	.00110	.00131	.00176	.00263	.00352	.00528	.00704	.25 x Dia	1 x Dia		
Wrought - 8%-12% Si (4xxx)	800	Finishing	.00024	.00050	.00076	.13 x Dia	1 x Dia	.00087	.00110	.00131	.00176	.00263	.00352	.00528	.00704	.25 x Dia	1 x Dia		
MAGNESIUM ALLOYS	1500	Slotting	.00019	.00039	.00059	1 x Dia	.20 x Dia	.00068	.00085	.00101	.00136	.00204	.00272	.00408	.00545	1 x Dia	.50 x Dia		
		Roughing	.00025	.00051	.00077	.30 x Dia	1 x Dia	.00088	.00111	.00132	.00178	.00266	.00356	.00534	.00712	.60 x Dia	1 x Dia		
ZINC ALLOYS	800	Finishing	.00027	.00056	.00085	.13 x Dia	1 x Dia	.00097	.00122	.00145	.00196	.00293	.00391	.00587	.00782	.25 x Dia	1 x Dia		
		Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia		
COPPER ALLOYS	225	High Coppers - 90%+ (C1xxx)	500	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia
		Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C66400-C69800)		225	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia
Phosphor Bronzes (Copper Tin alloys, C5xxx)	500	Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	.60 x Dia	1 x Dia		
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	.60 x Dia	1 x Dia		
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500	Roughing	.00020	.00041	.00062	.30 x Dia	1 x Dia	.00071	.00089	.00106	.00142	.00213	.00285	.00427	.00569	.60 x Dia	1 x Dia		
Copper Nicksels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225	Slotting	.00015	.00031	.00047	1 x Dia	.20 x Dia	.00054	.00068	.00081	.00109	.00163	.00218	.00327	.00436	1 x Dia	.50 x Dia		
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550	Finishing	.00022	.00045	.00068	.13 x Dia	1 x Dia	.00078	.00098	.00116	.00156	.00234	.00313	.00469	.00626	.25 x Dia	1 x Dia		

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 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.

Hardness: 29-37 Rc (279-344 HBn)																	
MATERIAL	SFM	Chip Load (IPT) by Dia						Depth of Cut			Chip Load (IPT) by Cutter Dia					Depth of Cut	
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial	
																	0.015
CARBON STEELS	600	Slotting	.00006	.00013	.00020	1 x Dia	.20 x Dia	.00023	.00029	.00035	.00047	.00070	.00094	.00140	.00187	1 x Dia	.50 x Dia
		Roughing	.00008	.00016	.00024	.30 x Dia	1 x Dia	.00027	.00034	.00041	.00055	.00082	.00110	.00165	.00220	.60 x Dia	1 x Dia
		Finishing	.00008	.00017	.00026	.13 x Dia	1 x Dia	.00030	.00038	.00045	.00061	.00091	.00122	.00183	.00245	.25 x Dia	1 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4xLxx, 50xx & 5xLxx, 50xxx & 50Lxxx, 51xx & 51Lxxx, 52xxx & 52Lxxx, 60xx, 80xx, 90xx	200	Slotting	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00027	.00032	.00043	.00064	.00086	.00128	.00171	1 x Dia	.50 x Dia
		Roughing	.00007	.00014	.00022	.30 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00075	.00101	.00151	.00201	.60 x Dia	1 x Dia
		Finishing	.00008	.00016	.00024	.13 x Dia	1 x Dia	.00028	.00035	.00042	.00056	.00084	.00112	.00168	.00224	.25 x Dia	1 x Dia
STAINLESS STEELS	450	Slotting	.00006	.00013	.00020	1 x Dia	.20 x Dia	.00023	.00029	.00035	.00047	.00070	.00094	.00140	.00187	1 x Dia	.50 x Dia
		Roughing	.00008	.00016	.00024	.30 x Dia	1 x Dia	.00027	.00034	.00041	.00055	.00082	.00110	.00165	.00220	.60 x Dia	1 x Dia
		Finishing	.00008	.00017	.00026	.13 x Dia	1 x Dia	.00030	.00038	.00045	.00061	.00091	.00122	.00183	.00245	.25 x Dia	1 x Dia
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Slotting	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00027	.00032	.00043	.00064	.00086	.00128	.00171	1 x Dia	.50 x Dia
		Roughing	.00007	.00014	.00022	.30 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00075	.00101	.00151	.00201	.60 x Dia	1 x Dia
		Finishing	.00008	.00016	.00024	.13 x Dia	1 x Dia	.00028	.00035	.00042	.00056	.00084	.00112	.00168	.00224	.25 x Dia	1 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00004	.00008	.00012	1 x Dia	.20 x Dia	.00013	.00017	.00020	.00027	.00040	.00053	.00080	.00107	1 x Dia	.50 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	1 x Dia	.00016	.00020	.00023	.00031	.00047	.00063	.00094	.00126	.60 x Dia	1 x Dia
		Finishing	.00005	.00010	.00015	.13 x Dia	1 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00105	.00140	.25 x Dia	1 x Dia
TOOL STEELS	200	Slotting	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00027	.00032	.00043	.00064	.00086	.00128	.00171	1 x Dia	.50 x Dia
		Roughing	.00007	.00014	.00022	.30 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00075	.00101	.00151	.00201	.60 x Dia	1 x Dia
		Finishing	.00008	.00016	.00024	.13 x Dia	1 x Dia	.00028	.00035	.00042	.00056	.00084	.00112	.00168	.00224	.25 x Dia	1 x Dia
A, L, O, P, W series	150	Slotting	.00004	.00008	.00012	1 x Dia	.20 x Dia	.00013	.00017	.00020	.00027	.00040	.00053	.00080	.00107	1 x Dia	.50 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	1 x Dia	.00016	.00020	.00023	.00031	.00047	.00063	.00094	.00126	.60 x Dia	1 x Dia
		Finishing	.00005	.00010	.00015	.13 x Dia	1 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00105	.00140	.25 x Dia	1 x Dia
D, H, M, T, S series	150	Slotting	.00004	.00008	.00012	1 x Dia	.20 x Dia	.00013	.00017	.00020	.00027	.00040	.00053	.00080	.00107	1 x Dia	.50 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	1 x Dia	.00016	.00020	.00023	.00031	.00047	.00063	.00094	.00126	.60 x Dia	1 x Dia
		Finishing	.00005	.00010	.00015	.13 x Dia	1 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00105	.00140	.25 x Dia	1 x Dia
TITANIUM ALLOYS	150	Slotting	.00004	.00008	.00012	1 x Dia	.20 x Dia	.00013	.00017	.00020	.00027	.00040	.00053	.00080	.00107	1 x Dia	.50 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	1 x Dia	.00016	.00020	.00023	.00031	.00047	.00063	.00094	.00126	.60 x Dia	1 x Dia
		Finishing	.00005	.00010	.00015	.13 x Dia	1 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00105	.00140	.25 x Dia	1 x Dia
HIGH TEMP ALLOYS	70	Slotting	.00004	.00008	.00012	1 x Dia	.20 x Dia	.00013	.00017	.00020	.00027	.00040	.00053	.00080	.00107	1 x Dia	.50 x Dia
		Roughing	.00004	.00009	.00014	.30 x Dia	1 x Dia	.00016	.00020	.00023	.00031	.00047	.00063	.00094	.00126	.60 x Dia	1 x Dia
		Finishing	.00005	.00010	.00015	.13 x Dia	1 x Dia	.00017	.00022	.00026	.00035	.00052	.00070	.00105	.00140	.25 x Dia	1 x Dia

Hardness: 38-45 Rc (353-421 HBn)																	
MATERIAL	SFM	Chip Load (IPT) by Dia						Depth of Cut			Chip Load (IPT) by Cutter Dia					Depth of Cut	
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial	
																	0.015
CARBON STEELS	600	Slotting	.00006	.00013	.00020	1 x Dia	.20 x Dia	.00023	.00029	.00035	.00047	.00070	.00094	.00140	.00187	1 x Dia	.50 x Dia
		Roughing															