

Speeds & Feeds

Product Table: Keyseat Cutters - Square - For Non-Ferrous Materials **Characteristics:** Standard Slotting (Type I), 4 Flutes **Series:** 9629xx, 9703xx, 9843xx, 9980xx

Product notes:

Chip Loads (IPT) within table pertain to applications where the cutter is engaged on one side only and the cutter width is less than .5x diameter. If the cutter is engaged on both sides, reduce chiploads to 50-60% of posted values.

General notes:

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 up to 15% if coated. For ferrous materials with hardness \leq 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.

MATERIAL		Hardness: ≤ 28 Rc (≤ 271 HBn)														
	SFM	Chip Load (IPT) By Cutter Diameter													Depth of Cut	
		0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.438	0.500	0.625	0.750	1.000	Radial	Axial
ALUMINUM ALLOYS	750		8 .00047	.00056	.00076	.00113	.00151	.00189	.00227	.00265	.00303	.00378	.00454	.00605	.12 x Dia	Full Width
Casting (2xx, 5xx, 7xx, 8xx)	730	.00038														
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000															
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750		.00042	.00051	.00068	.00102	.00136	.00170	.00204	.00238	.00272	.00340	.00408	.00545	.12 x Dia	Full Width
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	.00034														
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650															
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475															
Wrought - 5%-8% Si (4xxx)	1000															
Wrought - 8%-12% Si (4xxx)	800															
MAGNESIUM ALLOYS	1500	.00038	.00047	.00056	.00076	.00113	.00151	.00189	.00227	.00265	.00303	.00378	.00454	.00605	.12 x Dia	Full Width
ZINC ALLOYS	800	.00000														
COPPER ALLOYS																
High Coppers - 90%+ (C1xxxx)	225		.00038	.00045	.00061	.00091	.00121	.00151	.00182	.00212	.00242	.00303	.00363	.00484	.12 x Dia	Full Width
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500 225															
Phosphor Bronzes (Copper Tin alloys, C5xxxx)																
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	.00030														
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500															
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225															
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	550															