



Speeds & Feeds

Product Table: Chamfer Cutters - Pointed & Flat End - Double-Ended
Characteristics: 3 Flutes
Series: 8739xx, 8910xx, 8971xx, 9340xx, 9666xx

Product notes:

Due to a varying diameter, an **Effective Cutter Diameter** is needed for Chip Load selection and RPM calculation:
Effective Cutter Diameter = (Major Diameter + Minor Diameter)/2.
 Or consider the actual diameter along the angle that is engaged with the workpiece.

Depth of Cut is shown as number of Passes with each pass resulting in a **descending** stepover

Chip Loads are given 3 ways:

- Traditional Edge Break of .010"-.015"
- Full Chamfer engagement for cutters with angles GREATER than or equal to 25° per side (50° included)
- Full Chamfer engagement for cutters with angles LESS than 25° per side (50° included)

Chip Loads within table pertain to machining on one side of workpiece.
 For machining on two sides, reduce Chip Loads to 60%-80% depending on contact length and finish
 For vertical plunging, reduce Chip Loads to 40%-50% depending on finish

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 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.

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)											Depth of Cut Passes		
		Chip Load (IPT) By Effective Cutter Diameter													
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375		0.500	
ALUMINUM ALLOYS Casting (2xx, 5xx, 7xx, 8xx)	750	Edge Break	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00421	.00506	.00675	1
		Full Chamfer (≥ 25°)	.00017	.00035	.00053	.00070	.00088	.00105	.00141	.00210	.00281	.00351	.00422	.00563	2
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000	Full Chamfer (< 25°)	.00013	.00026	.00040	.00052	.00066	.00078	.00105	.00158	.00211	.00263	.00316	.00422	3
	750	Edge Break	.00018	.00038	.00057	.00075	.00095	.00113	.00152	.00227	.00304	.00379	.00456	.00608	1
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700	Edge Break	.00018	.00038	.00057	.00075	.00095	.00113	.00152	.00227	.00304	.00379	.00456	.00608	1
	700	Full Chamfer (< 25°)	.00015	.00031	.00048	.00063	.00079	.00094	.00127	.00189	.00253	.00316	.00380	.00506	2
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	Full Chamfer (< 25°)	.00015	.00031	.00048	.00063	.00079	.00094	.00127	.00189	.00253	.00316	.00380	.00506	2
	475	Edge Break	.00018	.00038	.00057	.00075	.00095	.00113	.00152	.00227	.00304	.00379	.00456	.00608	1
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	1000	Full Chamfer (< 25°)	.00011	.00024	.00036	.00047	.00059	.00071	.00095	.00142	.00190	.00237	.00285	.00380	3
	800	Edge Break	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338	.00421	.00506	.00675	1
MAGNESIUM ALLOYS	1500	Full Chamfer (≥ 25°)	.00017	.00035	.00053	.00070	.00088	.00105	.00141	.00210	.00281	.00351	.00422	.00563	2
	800	Full Chamfer (< 25°)	.00013	.00026	.00040	.00052	.00066	.00078	.00105	.00158	.00211	.00263	.00316	.00422	3
ZINC ALLOYS	800	Full Chamfer (< 25°)	.00013	.00026	.00040	.00052	.00066	.00078	.00105	.00158	.00211	.00263	.00316	.00422	3
	225	Edge Break	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00337	.00405	.00540	1
COPPER ALLOYS High Coppers - 90%+ (C1xxx)	500	Edge Break	.00016	.00033	.00051	.00067	.00084	.00100	.00135	.00202	.00270	.00337	.00405	.00540	1
	225	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
Brass (Copper-Zinc alloys, C2xxx, C3xxx, C4xxx, C66400-C69800)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3
Phosphor Bronzes (Copper-Tin alloys, C5xxx)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3
Aluminum Bronzes (Copper-Aluminum alloys, C60600-C64200)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3
Silicon Bronzes (Copper-Silicon alloys, C64700-C66100)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3
Copper-Nickels, Nickel-Silvers (Copper-Nickel alloys, C7xxx)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	500	Full Chamfer (< 25°)	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225	.00281	.00338	.00450	2
	225	Full Chamfer (< 25°)	.00010	.00021	.00032	.00042	.00053	.00063	.00084	.00126	.00169	.00211	.00253	.00338	3

MATERIAL	SFM	Hardness: 29-37 Rc (279-344 HBn)											Depth of Cut Passes		
		Chip Load (IPT) By Effective Cutter Diameter													
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375		0.500	
CARBON STEELS Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Edge Break	.00008	.00016	.00024	.00032	.00040	.00047	.00064	.00095	.00128	.00159	.00191	.00255	1
		Full Chamfer (≥ 25°)	.00006	.00013	.00020	.00026	.00033	.00040	.00053	.00080	.00106	.00133	.00159	.00213	3
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4xLxx, 50xx & 5xLxx, 50xx & 50Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 60xx, 80xx, 90xx	200	Edge Break	.00007	.00014	.00022	.00029	.00036	.00043	.00058	.00087	.00117	.00146	.00175	.00233	1
		Full Chamfer (≥ 25°)	.00006	.00012	.00018	.00024	.00030	.00036	.00049	.00073	.00097	.00121	.00146	.00194	3
STAINLESS STEELS 203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Edge Break	.00008	.00016	.00024	.00032	.00040	.00047	.00064	.00095	.00128	.00159	.00191	.00255	1
		Full Chamfer (≥ 25°)	.00006	.00013	.00020	.00026	.00033	.00040	.00053	.00080	.00106	.00133	.00159	.00213	3
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	Edge Break	.00007	.00014	.00022	.00029	.00036	.00043	.00058	.00087	.00117	.00146	.00175	.00233	1
		Full Chamfer (≥ 25°)	.00006	.00012	.00018	.00024	.00030	.00036	.00049	.00073	.00097	.00121	.00146	.00194	3
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Edge Break	.00004	.00009	.00014	.00018	.00023	.00027	.00036	.00055	.00073	.00091	.00109	.00146	1
		Full Chamfer (≥ 25°)	.00004	.00008	.00011	.00015	.00019	.00023	.00030	.00045	.00061	.00076	.00091	.00122	3
TOOL STEELS A, L, O, P, W series	200	Edge Break	.00007	.00014	.00022	.00029	.00036	.00043	.00058	.00087	.00117	.00146	.00175	.00233	1
		Full Chamfer (≥ 25°)	.00006	.00012	.00018	.00024	.00030	.00036	.00049	.00073	.00097	.00121	.00146	.00194	3
D, H, M, T, S series	150	Edge Break	.00004	.00009	.00014	.00018	.00023	.00027	.00036	.00055	.00073	.00091	.00109	.00146	1
		Full Chamfer (≥ 25°)	.00004	.00008	.00011	.00015	.00019	.00023	.00030	.00045	.00061	.00076	.00091	.00122	3
TITANIUM ALLOYS	150	Edge Break	.00004	.00009	.00014	.00018	.00023	.00027	.00036	.00055	.00073	.00091	.00109	.00146	1
		Full Chamfer (≥ 25°)	.00004	.00008	.00011	.00015	.00019	.00023	.00030	.00045	.00061	.00076	.00091	.00122	3
HIGH TEMP ALLOYS Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Incoloy	70	Edge Break	.00004	.00009	.00014	.00018	.00023	.00027	.00036	.00055	.00073	.00091	.00109	.00146	1
		Full Chamfer (≥ 25°)	.00004	.00008	.00011	.00015	.00019	.00023	.00030	.00045	.00061	.00076	.00091	.00122	3

MATERIAL	SFM	Hardness: 38-45 Rc (353-421 HBn)											Depth of Cut Passes		
		Chip Load (IPT) By on Effective Cutter Diameter													
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375		0.500	
CARBON STEELS	600	Edge Break	.00008	.00016	.00024	.00032	.00040	.00047	.00064	.00095	.00128	.00159	.00191	.00255	1
		Full Chamfer (≥ 25°)	.00006	.00013	.00020	.00026	.00033	.00040	.00053	.00080	.00106	.00133	.00159	.00213	3
1030 - 1095, 1140 - 1151, 13xx, 15xx, 20xx, 30xx, 40xx & 4xLxx, 50xx & 5xLxx, 50xx & 50Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 60xx, 80xx, 90xx	200	Edge Break	.00007	.00014	.00022	.00029	.00036	.00043	.00058	.00087	.00117	.00146	.00175	.00233	1
		Full Chamfer (≥ 25°)	.00006	.00012	.00018	.00024	.00030	.00036	.00049	.00073	.00097	.00121	.00146	.00194	3
STAINLESS STEELS	450	Edge Break	.00008	.00016	.00024	.00032	.00040	.00047	.00064	.00095	.00128	.00159	.00191	.00255	1
		Full Chamfer (≥ 25°)	.00006	.00013	.00020	.00026	.00033	.00040	.00053	.00080	.00106	.00133	.00159	.00213	3
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	Edge Break	.00007	.00014	.00022	.00029	.00036	.00043	.00058	.00087	.00117	.00146	.00175	.00233	1
		Full Chamfer (≥ 25°)	.00006	.00012	.00018	.00024	.00030	.00036	.00049	.00073	.00097	.00121	.00146	.00194	3
414, 431, 440A, 4															