



Speeds & Feeds

Product Table: Keyseat Cutters - Square - For Hardened Steels

Characteristics: 10 Flutes

Series: 8913xx-C6, 8947xx-C6

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 .4x diameter.

If the cutter is engaged on both sides, reduce chiploads to 50-60% of posted values.

If .6x diameter > cutter width > .4x diameter, reduce radial step over to 80% of posted values.

If cutter width > .6x diameter, reduce radial step over to 60% of posted values.

Material	Hardness	SFM	Chip Load (IPT) By Cutter Diameter													Depth of Cut	
			.031	.047	.062	.078	.093	.125	.187	.250	.312	.375	.500	.750	1.000	Radial	Axial
Hardened Steels	45 - 55 Rc	60	.00002	.00003	.00005	.00006	.00007	.00009	.00014	.00018	.00023	.00028	.00037	.00055	.00074	.05 x Dia	Full Width
Titanium Alloys	56 - 68 Rc	50	.00002	.00003	.00004	.00005	.00005	.00007	.00011	.00015	.00018	.00022	.00030	.00044	.00059	.04 x Dia	Full Width
Nickel Alloys																	

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.