



Speeds & Feeds

Product Table: Chamfer Cutters - Back Chamfer Cutters
Characteristics: 90° Included Angle, 1.5x Reach Multiple, 4 Flutes
Series: 9060xx

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.
For Full Chamfer engagement the Effective Cutter Diameter is 80% of the cutter diameter

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

Chip Loads are given 3 ways:

- Deburring refers to removing the burr only
Traditional Edge Break of .010"-.015"
Full Chamfer engagement

Chip Loads within table pertain to machining on one side an existing slot.

For machining on two sides, reduce Chip Loads to 60%-80% depending on contact length and 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

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), Depth of Cut Passes. Includes sections for ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), Depth of Cut Passes. Includes sections for CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, HIGH TEMP ALLOYS.

Table with columns: SFM, Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), Depth of Cut Passes. Includes sections for HARDNESS: 38-45 Rc (353-421 HBn).