

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)									Depth of Cut	
		Chip Load (IPT) By Cutter Diameter									Radial	Axial
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000		
ALUMINUM ALLOYS												
Casting (2xx, 5xx, 7xx, 8xx)	1250	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1500											
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	950											
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	900											
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	850	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700											
Wrought - 5%-8% Si (4xxx)	1500											
Wrought - 8%-12% Si (4xxx)	1000											
MAGNESIUM ALLOYS	1500											
		.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
ZINC ALLOYS	1000											
COPPER ALLOYS												
High Coppers - 90%+ (C1xxxx)	500											
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C6400-C69800)	700											
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	500											
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	700	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	700											
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	500											
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	750											



Speeds & Feeds

Product Table: Slitting Saws
Series: SAAxxxx, SABxxxx, SACxxxx, SADxxxx, SAExxxx, SAFxxxx, SAGxxxx, SAWxxxx

Product notes:

When Thickness to Cutter Diameter ratio is less than 1%, reduce IPT to 50% and Radial Depth of cut to 3x Thickness

For greater Radial Depth of cuts:
 8x Thickness, reduce SFM by 10%

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.

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: 29-37 Rc (279-344 HBn)									Depth of Cut	
		Chip Load (IPT) By Cutter Diameter									Radial	Axial
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000		
CARBON STEELS												
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	175	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx	150	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
STAINLESS STEELS												
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	200	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
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	125	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
TOOL STEELS												
A, L, O, P, W series	125	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
D, H, M, T, S series	100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
TITANIUM ALLOYS	200	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK
HIGH TEMP ALLOYS												
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	80	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	.00100	5x THK	Full THK

MATERIAL	SFM	Hardness: 38-45 Rc (353-421 HBn)									Depth of Cut	
		Chip Load (IPT) By Cutter Diameter									Radial	Axial
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000		
		-	-	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-	-	-	-
	100	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
	90	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
	100	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
	90	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
	175	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
	50	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK