

Product Table: Large Size Finishing Tools

Material	Type	Edge Type	RPM		IPM by Cutter Diameter				Depth of Cut	
					1.771 (45mm)	2.000	2.480 (63mm)	3.000	Radial	Axial
Honeycomb Core	Aluminum Core ≤ 6% Density	Smooth, Stagger Tooth, Wavy	Dia<2.00":18000 2.00≤Dia<2.50":16000 2.50≤Dia<3.00":14000 Dia≥3.00":12000	Rough	180	150	125	100	.5 x Dia	.150" - .500"
				Finish	200	200	200	200	.15 x Dia	.050"-.100"
	Aluminum Core ≥ 6% Density	Stagger Tooth, Sawtooth, Wavy	Dia<2.00":18000 2.00≤Dia<2.50":16000 2.50≤Dia<3.00":14000 Dia≥3.00":12000	Rough	200	200	150	150	.5 x Dia	.150" - .500"
				Finish	200	200	200	200	.15 x Dia	.050"-.100"
	Nomex	Smooth for Nomex, Stagger Tooth, Wavy	Dia≤2.00":12000-16250 2.00<Dia<3.00":10000-14000 Dia≥3.00":8000-12000	Rough	150-300	150-300	150-300	150-300	.5 x Dia	.500"
				Finish	150-300	150-300	150-300	150-300	.250"-.300"	.050"-.100"

Product Notes:

Aluminum Core: Use Conventional direction at all times unless beveling to a sharp edge. Recommend .25° to 2° Lead angle on all cuts. If using 3 axis machine, 0° degree can be used for facing. Watch cutting edges of tools closely to avoid grabbing "ribbons" which can cause severe damage to part. Standard "backers" such as peel ply are recommended if available. Also, application of hot glue bead around stock edges to strengthen workholding is recommended where applicable.

Nomex: Use Conventional direction at all times unless beveling to a sharp edge. Recommend .5° to 2° Lead angle on all cuts. If using 3 axis machine, 0° degree can be used for facing. Watch cutting edges of tools closely to avoid grabbing "ribbons" which can cause severe damage to part. Standard "backers" such as peel ply are recommended if available.

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at 833-584-3448 or corehogtech@harveyperformance.com

WARNING: Cutting tools may shatter under improper use. Government regulations require the use of safety glasses and other appropriate safety equipment in the vicinity of