

Product Table: Honeycomb CoreRoughing Tools – CoreHogger – Ball End

Material	Type	RPM	IPM by Cutter Diameter					Depth of Cut		
				.250	.375	.500	.750	1.000	Radial	Axial
Honeycomb Core	Nomex	Dia<.750":18000-24000 .750≤Dia<1.00":16000-20000 Dia≥1.00":12000-16250	Rough	35-70	70-100	125-250	150-300	150-300	.5 x Dia	1.5 x Dia
		Dia<.750":18000-24000 .750≤Dia<1.00":16000-20000 Dia≥1.00":12000-16250	Finish	35-70	70-100	125-250	150-300	150-300	.05-.20 x Dia	.05-.20 x Dia

Product Notes:

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