

Product Table: Multi-Axis Finishers for High Temp Alloys - Lens Form

Characteristics: 4 Flutes

Series: 6984xx-C10, 6985xx-C10

Hardness	CEM	EM .									Depth of Cut	
(HBn)	5		0.062	0.078	0.093	0.125	0.187	0.250	0.375	0.500	Radial	Axial
275 - 300	400	Finishing	.00096	.00100	.00103	.00110	.00130	.00150	.00170	.00200	.025 x Dia x	.005"010"
300 - 350	350	Finishing	.00085	.00089	.00092	.00110	.00120	.00140	.00160	.00180	Benefit Multiple	
300 - 350	500	Finishing	.00096	.00100	.00104	.00120	.00130	.00150	.00170	.00200	.025 x Dia x Benefit Multiple	.005"010"
350 - 400	450	Finishing	.00094	.00098	.00101	.00110	.00120	.00140	.00150	.00180		
400 - 540	400	Finishing	.00083	.00086	.00089	.00100	.00110	.00120	.00140	.00160		
275 - 300	300	Finishing	.00108	.00113	.00117	.00130	.00150	.00170	.00190	.00220	.025 x Dia x Benefit Multiple	.005"010"
300 - 350	250											
350 - 400	200	Finishing	.00098	.00102	.00106	.00120	.00140	.00160	.00180	.00210	.025 x Dia x Benefit Multiple	.005"010"
400 - 425	150											
275 - 300	200	Finishing	.00086	.00090	.00094	.00110	.00130	.00140	.00160	.00190	.025 x Dia x Benefit Multiple	.005"010"
300 - 350	180											
350 - 400	150	Finishing	.00084	.00088	.00091	.00100	.00110	.00130	.00150	.00170	.025 x Dia x Benefit Multiple	.005"010"
400 - 425	120											
	(HBn) 275 - 300 300 - 350 350 - 400 400 - 540 275 - 300 300 - 350 350 - 400 400 - 425 275 - 300 300 - 350 350 - 400	(HBn) 275 - 300	(HBn) SFM 275 - 300 400 Finishing 300 - 350 350 Finishing 300 - 350 500 Finishing 350 - 400 450 Finishing 400 - 540 400 Finishing 275 - 300 300 Finishing 350 - 400 200 Finishing 400 - 425 150 Finishing 300 - 350 180 Finishing 350 - 400 150 Finishing	(HBn) SFM 0.062 275 - 300 400 Finishing .00096 300 - 350 350 Finishing .00085 300 - 350 500 Finishing .00096 350 - 400 450 Finishing .00094 400 - 540 400 Finishing .00083 275 - 300 300 Finishing .00108 350 - 400 200 Finishing .00098 400 - 425 150 Finishing .00086 350 - 400 150 Finishing .00084	(HBn) SFM 0.062 0.078 275 - 300 400 Finishing .00096 .00100 300 - 350 350 Finishing .00085 .00089 300 - 350 500 Finishing .00096 .00100 350 - 400 450 Finishing .00094 .00098 400 - 540 400 Finishing .00083 .00086 275 - 300 300 Finishing .00108 .00113 350 - 400 200 Finishing .00098 .00102 275 - 300 200 Finishing .00086 .00090 300 - 350 180 Finishing .00084 .00088	(HBn) SFM 0.062 0.078 0.093 275 - 300 400 Finishing .00096 .00100 .00103 300 - 350 350 Finishing .00085 .00089 .00092 300 - 350 500 Finishing .00096 .00100 .00104 350 - 400 450 Finishing .00094 .00098 .00101 400 - 540 400 Finishing .00083 .00086 .00089 275 - 300 300 Finishing .00108 .00113 .00117 350 - 400 200 Finishing .00098 .00102 .00106 275 - 300 200 Finishing .00086 .00090 .00094 300 - 350 180 Finishing .00086 .00090 .00094 350 - 400 150 Finishing .00084 .00088 .00091	(HBn) SFM 0.062 0.078 0.093 0.125 275 - 300 400 Finishing .00096 .00100 .00103 .00110 300 - 350 350 Finishing .00085 .00089 .00092 .00110 300 - 350 500 Finishing .00096 .00100 .00104 .00120 350 - 400 450 Finishing .00094 .00098 .00101 .00110 400 - 540 400 Finishing .00083 .00086 .00089 .00100 275 - 300 300 Finishing .00108 .00113 .00117 .00130 350 - 400 200 Finishing .00098 .00102 .00106 .00120 275 - 300 200 Finishing .00086 .00090 .00094 .00110 350 - 400 150 Finishing .00084 .00088 .00091 .00100	(HBn) SFM 0.062 0.078 0.093 0.125 0.187 275 - 300 400 Finishing .00096 .00100 .00103 .00110 .00130 300 - 350 350 Finishing .00085 .00089 .00092 .00110 .00120 300 - 350 500 Finishing .00096 .00100 .00104 .00120 .00130 350 - 400 450 Finishing .00094 .00098 .00101 .00110 .00120 400 - 540 400 Finishing .00083 .00086 .00089 .00100 .00110 275 - 300 300 Finishing .00108 .00113 .00117 .00130 .00150 350 - 400 200 Finishing .00098 .00102 .00106 .00120 .00140 275 - 300 200 Finishing .00086 .00090 .00094 .00110 .00130 350 - 400 150 Finishing .00084 .00088 .00091 <td>(HBn) SFM 0.062 0.078 0.093 0.125 0.187 0.250 275 - 300 400 Finishing .00096 .00100 .00103 .00110 .00130 .00150 300 - 350 350 Finishing .00085 .00089 .00092 .00110 .00120 .00140 300 - 350 500 Finishing .00096 .00100 .00104 .00120 .00130 .00150 350 - 400 450 Finishing .00094 .00098 .00101 .00110 .00120 .00140 400 - 540 400 Finishing .00083 .00086 .00089 .00100 .00110 .00120 275 - 300 300 Finishing .00108 .00113 .00117 .00130 .00140 .00160 400 - 425 150 Finishing .00086 .00090 .00094 .00110 .00130 .00140 300 - 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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 tech@harveytool.com.