

KEYSEAT CUTTERS - HIGH SPEED STEEL

Technical Information

Keyseat Cutters - Woodruff - Straight Tooth - High Speed Steel											
Material Guidet		Machinability	HRc	SFM	Effective Cutter Diameter						
					≤ 1/16"	1/16"-1/8"	1/8"-1/4"	1/4"-3/8"	3/8"-1/2"	1/2"-3/4"	3/4"-1"
					Inch Per Tooth						
COBALT BASE ALLOYS	Stellite, HS-21, Haynes 25/188, X-40, L-605	Difficult	≤28	20-50	.0002-.0005	.0003-.0007	.0004-.0010	.0005-.0011	.0006-.0011	.0007-.0011	.0007-.0013
NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	Difficult	≤28	20-50	.0002-.0005	.0003-.0007	.0004-.0010	.0005-.0011	.0006-.0011	.0007-.0011	.0007-.0013
IRON BASE ALLOYS	Incoloy 800-802, Multimet N-155, Timken 16-25-6, Carpenter 22-b3	Difficult	≤28	20-50	.0002-.0005	.0003-.0007	.0004-.0010	.0005-.0011	.0006-.0011	.0007-.0011	.0007-.0013
MONEL	Monel - 65% Nickel	Difficult	-	-	-	-	-	-	-	-	-
TITANIUM ALLOYS	Commercially Pure, 6AL-4V, STM 1/2/3, 6AL-25N-4Zr-2Mo-Si	Difficult	≤28	30-65	.0002-.0007	.0003-.0009	.0004-.0010	.0005-.0011	.0006-.0012	.0007-.0012	.0007-.0016
STAINLESS STEEL (PH)	13/8, 15/5, 17-4	Difficult	≤28	30-75	.0003-.0008	.0003-.0009	.0004-.0012	.0005-.0014	.0006-.0016	.0009-.0018	.0010-.0020
STAINLESS STEEL (AUSTENTIC)	303, 303Se	Free-Machining	≤28	50-100	.0002-.0009	.0003-.0009	.0004-.0012	.0005-.0014	.0006-.0016	.0009-.0018	.0010-.0022
	304, 304L, 316, 316L, 200 Series	Difficult	≤28	30-75	.0003-.0008	.0003-.0009	.0004-.0012	.0005-.0014	.0006-.0016	.0009-.0018	.0010-.0020
STAINLESS STEEL (MARTENSITIC)	416	Free-Machining	≤28	50-100	.0002-.0009	.0003-.0009	.0004-.0012	.0005-.0014	.0006-.0016	.0009-.0018	.0010-.0022
	403, 410, 440	Difficult	≤28	30-75	.0003-.0008	.0003-.0009	.0004-.0012	.0005-.0014	.0006-.0016	.0009-.0018	.0010-.0020
HIGH STRENGTH TOOL STEELS	4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	Difficult	≤55	30-65	.0002-.0009	.0003-.0009	.0004-.0012	.0005-.0014	.0007-.0016	.0009-.0018	.0010-.0025
MEDIUM ALLOY STEELS	4140, 8620, 52100	Moderate	≤40	60-150	.0003-.0009	.0003-.0009	.0004-.0011	.0005-.0012	.0006-.0013	.0009-.0015	.0010-.0030
CARBON STEELS	1018, 1045, 1117, 1215, 1300 Series	Free-Machining	≤28	80-200	.0003-.0009	.0003-.0009	.0004-.0011	.0005-.0012	.0006-.0013	.0009-.0015	.0010-.0030
DUCTILE	Ductile Cast Irons	Moderate	≤26	50-120	.0003-.0009	.0003-.0009	.0004-.0011	.0005-.0012	.0006-.0013	.0009-.0015	.0010-.0030
CAST IRONS	Gray Cast Irons	Moderate	≤19	60-180	.0002-.0009	.0003-.0010	.0004-.0012	.0005-.0014	.0007-.0016	.0009-.0018	.0010-.0025
ALUMINUM	2014, 2024, 6061 - (T1 - T6), 7075, Die Cast, Extruded	Free-Machining	≤28	70-300	.0003-.0009	.0003-.0011	.0004-.0013	.0005-.0015	.0006-.0017	.0009-.0020	.0010-.0035
MAGNESIUM	AZ31B, AZ61A, AZ91D, AM60	Free-Machining	-	-	-	-	-	-	-	-	-
COPPER, COPPER ALLOYS	C101 (Oxygen-Free Copper), C110 (Electrolytic Tough-Pitch Copper)	Free-Machining	-	70-300	.0003-.0009	.0003-.0011	.0004-.0013	.0005-.0015	.0006-.0017	.0009-.0020	.0010-.0035
BRASS, BRONZE	Brass, C260 (Cartridge Brass), Alum/Bronze, Low Silicon Bronze	Free-Machining	-	70-300	.0003-.0009	.0003-.0011	.0004-.0013	.0005-.0015	.0006-.0017	.0009-.0020	.0010-.0035
COMPOSITES	G-10 Fiberglass, Graphite, Graphite/Epoxy, Plastics	Moderate/ Difficult	-	-	-	-	-	-	-	-	-