



Speeds & Feeds

Product Table: Chamfer Cutters - Plate Chamfer Cutter
Series: 9552xx, 9659xx, 9711xx, 9808xx

Product notes: Due to a varying diameter, an Effective Cutter Diameter is needed for Chip Load selection and RPM calculation:
Effective Cutter Diameter = (Major Diameter + Minor Diameter)/2.
Or consider the actual diameter along the angle that is engaged with the workpiece.

Depth of Cut is shown as number of Passes with each pass resulting in a descending stepover
Chip Loads are given 3 ways:
Double Chamfer - Engaged on either or both chamfer angles only (not minor diameter)
Minor Diameter - Milling on the minor diameter (D3) only
Full Form - Using the chamfer angles and minor diameter simultaneously
Use double chamfer chiploads for first pass to hog the chamfer profile before full engagement
Chip Loads within table pertain to machining on one side of workpiece.
For machining on two sides, reduce Chip Loads to 60%-80% depending on contact length and finish
For max opening widths (L2) greater than .500", reduce chiploads by 5%

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 10%-20% if coated. For ferrous materials with hardness <= 28 Rc, chip loads can be increased 10%-20%.
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

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Effective Diameter (0.015 to 0.500), Depth of Cut Passes. Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS, and HIGH TEMP ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Effective Diameter (0.015 to 0.500), Depth of Cut Passes. Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.

Table with columns: SFM, Chip Load (IPT) By Effective Diameter (0.015 to 0.500), Depth of Cut Passes. Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.