



Product Table: Phenolic Cutters - Downcut

Material	Type	RPM	IPM by Cutter Diameter			Depth of Cut		
			.250	.375	.500	Radial	Axial	
Phenolics	Solid Laminate	Dia .250": 9000 Dia .375": 7500 Dia .500": 6000	Roughing	80	70	55	1 x Dia	1 x Dia
		Dia .250": 11000	Finishing	200	160	135	LOC .625": .08x Dia LOC .875": .08x Dia	LOC .625": 1x Dia LOC .875": 1x Dia
		Dia .375": 9000	Finishing	200	160	135	LOC .625": .08x Dia LOC .875": .08x Dia LOC 1.125": .08x Dia	LOC .625": 1x Dia LOC .875": 1.33x Dia LOC 1.125": 2x Dia
		Dia .500": 7500	Finishing	200	160	135	LOC .625": .06x Dia LOC .875": .06x Dia LOC 1.125": .06x Dia	LOC .625": 1x Dia LOC .875": 1.5x Dia LOC 1.125": 1.75x Dia

Product Notes:

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 use of safety glasses and other appropriate safety equipment in the vicinity of use.