



Speeds & Feeds

Product Table: Runner Cutters
Characteristics: 30°, 2 Flutes
Series: 9345xx

Product Notes:

After calculating speed and feed, use the table below to determine number of axial passes needed (and their descending breakdown) to achieve the required depth of cut.

Table with 3 columns: Axial DOC, Passes, and Percentage breakdown of Descending Axial Passes. Rows include 2x DOC to 20x DOC with corresponding pass counts and percentage distributions.

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 Harvetechn@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.

Table: Hardness: ≤ 28 Rc (≤ 271 HBn). Columns: MATERIAL, SFM, Chip Load (IPT) by Ball Diameter (2 x Radius) (.015 to .500). Rows: ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS.

Table: Hardness: 29-37 Rc (279-344 HBn). Columns: MATERIAL, SFM, Chip Load (IPT) by Ball Diameter (2 x Radius) (.015 to .500). Rows: CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, HIGH TEMP ALLOYS.

Table: Hardness: 38-45 Rc (353-421 HBn). Columns: SFM, Chip Load (IPT) by Ball Diameter (2 x Radius) (.015 to .500). Rows: Data for hardness range 38-45 Rc.