

MATERIAL	SMM	Hardness: ≤ 28 Rc (≤ 271 HBn)									Depth of Cut	
		Chip Load (mmPT) By Cutter Diameter									Radial	Axial
		20	30	40	50	60	70	80	90	100		
ALUMINUM ALLOYS												
Casting (2xx, 5xx, 7xx, 8xx)	380	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	460											
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	290											
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	275											
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	260	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	210											
Wrought - 5%-8% Si (4xxx)	460											
Wrought - 8%-12% Si (4xxx)	305											
MAGNESIUM ALLOYS	460	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
ZINC ALLOYS	305											
COPPER ALLOYS												
High Coppers - 90%+ (C1xxxx)	150											
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	210											
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	150											
Aluminum Bronzes (Copper Aluminum alloys, C66000-C64200)	210	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	210											
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	150											
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	230											



Speeds & Feeds

Product Table: Slitting Saws - Metric
Series: SMExxxx, SMQxxxx, SMSxxxx, SMTxxxx

Product notes:

When Thickness to Cutter Diameter ratio is less than 1%, reduce mmPT to 50% and Radial Depth of cut to 3x Thickness

For greater Radial Depth of cuts:
8x Thickness, reduce SFM by 10%

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 up to 15% if coated.

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 appropriate safety equipment in the vicinity of use.

MATERIAL	SMM	Hardness: 29-37 Rc (279-344 HBn)									Depth of Cut	
		Chip Load (mmPT) By Cutter Diameter									Radial	Axial
		20	30	40	50	60	70	80	90	100		
CARBON STEELS												
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	55	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xx, 3xx, 4xx & 4Lxx, 5xx & 5Lxx, 50xx & 50Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 6xx, 8xx, 9xx	45	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
STAINLESS STEELS												
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	60	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	38	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	30	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
TOOL STEELS												
A, L, O, P, W series	38	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
D, H, M, T, S series	30	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
TITANIUM ALLOYS	60	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK
HIGH TEMP ALLOYS												
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	25	.025	.025	.025	.025	.025	.025	.025	.025	.025	5x THK	Full THK

MATERIAL	SMM	Hardness: 38-45 Rc (353-421 HBn)									Depth of Cut	
		Chip Load (mmPT) By Cutter Diameter									Radial	Axial
		20	30	40	50	60	70	80	90	100		
	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-
	-	-	-	-	-	-	-	-	-	-	-	-
	30	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK
	27	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK
	30	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK
	27	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK
	55	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK
	15	.023	.023	.023	.023	.023	.023	.023	.023	.023	5x THK	Full THK