HARVEY TOOL

Speeds & Feeds

Product Table: Hexalobe Cutters - Long Reach
Characteristics: 6x Reach
Series: 7918xx-C6

Please note:

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 appropriate safety equipment in the vicinity of use.

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)													
	SFM		Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia				Depth of Cut	
			0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	Radial	Axial
CARBON STEELS		Slotting	.00006	.00013	.00020	1 x Dia	.08 x Dia	.00026	.00033	.00039	.00053	1 x Dia	.19 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Roughing	.00007	.00015	.00022	.29 x Dia	.33 x Dia	.00030	.00037	.00044	.00060	.58 x Dia	.33 x Dia
		Finishing	.00011	.00023	.00035	.08 x Dia	1.5 x Dia	.00046	.00058	.00070	.00094	.15 x Dia	1.5 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
		Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
		Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia
STAINLESS STEELS		Slotting	.00006	.00013	.00020	1 x Dia	.08 x Dia	.00026	.00033	.00039	.00053	1 x Dia	.19 x Dia
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Roughing	.00007	.00015	.00022	.29 x Dia	.33 x Dia	.00030	.00037	.00044	.00060	.58 x Dia	.33 x Dia
		Finishing	.00011	.00023	.00035	.08 x Dia	1.5 x Dia	.00046	.00058	.00070	.00094	.15 x Dia	1.5 x Dia
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	200	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
		Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
		Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
		Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
		Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
TOOL STEELS		Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
A, L, O, P, W series	200	Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
		Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia
D, H, M, T, S series	150	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
		Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
		Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
TITANIUM ALLOYS		Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
	150	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
		Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
HIGH TEMP ALLOYS		Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
		Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
Cobalt Chromium Alloys	60	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
		Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
		Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia

Hardness: 38-45 Rc (353-421 HBn)													
SFM		Chip Load (IPT) by Dia			Depth of Cut		Chip Load (IPT) by Cutter Dia				Depth of Cut	
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.125	Radial	Axial
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
100	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
	Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
	Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia
90	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
	Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
100	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
	Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
	Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia
90	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
	Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
75	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
	Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
50	Slotting	.00004	.00008	.00011	1 x Dia	.08 x Dia	.00015	.00019	.00023	.00030	1 x Dia	.19 x Dia
	Roughing	.00004	.00008	.00013	.29 x Dia	.33 x Dia	.00017	.00021	.00025	.00034	.58 x Dia	.33 x Dia
	Finishing	.00006	.00013	.00020	.08 x Dia	1.5 x Dia	.00027	.00033	.00040	.00054	.15 x Dia	1.5 x Dia
45	Slotting	.00006	.00012	.00018	1 x Dia	.08 x Dia	.00024	.00030	.00036	.00049	1 x Dia	.19 x Dia
	Roughing	.00007	.00014	.00021	.29 x Dia	.33 x Dia	.00027	.00034	.00041	.00055	.58 x Dia	.33 x Dia
	Finishing	.00010	.00021	.00032	.08 x Dia	1.5 x Dia	.00042	.00053	.00064	.00086	.15 x Dia	1.5 x Dia