HARVEY TOOL

Speeds & Feeds

Product Table: Hexalobeular Combined Drills and Countersinks
Series: 7411xx, 7250xx

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.

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 (IPR - Inches Per Revolution) By Cutter Diameter								
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
STAINLESS STEELS										
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	180	.00035	.00073	.00111	.00146	.00184	.00220	.00295	.00442	.00591
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	150	.00032	.00067	.00102	.00134	.00168	.00201	.00270	.00404	.00540
TITANIUM ALLOYS	100	.00020	.00042	.00063	.00084	.00105	.00126	.00169	.00252	.00338

Hardness: 38-45 Rc (353-421 HBn)									
SFM	Chip Load (IPR - Inches Per Revolution) By Cutter Diameter								
	0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
-	-	-	-	-	-	-	-	-	-
100	.00022	.00045	.00068	.00089	.00112	.00134	.00180	.00269	.00360
75	.00014	.00028	.00042	.00056	.00070	.00084	.00113	.00168	.00225