

SPEEDS & FEEDS

7 Flute - Variable Pitch



HEV-7

HEV-7 / HEV-RN-7																	
Material Guide		Hardness	SFM	1/8		3/16		1/4		3/8		1/2		3/4		1	
				Rgh	Fin												
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	455	.0016	.0017	.0024	.0019	.0031	.0022	.0047	.0025	.0060	.0029	.0087	.0035	.0111	.0043
		75 - 98 HRB	445	.0011	.0015	.0017	.0016	.0023	.0019	.0034	.0022	.0044	.0025	.0064	.0030	.0081	.0036
		21 - 36 HRC	400	.0007	.0012	.0011	.0013	.0015	.0015	.0022	.0017	.0028	.0020	.0041	.0024	.0053	.0029
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB	390	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 36 HRC	340	.0007	.0012	.0011	.0013	.0015	.0015	.0022	.0017	.0028	.0020	.0041	.0024	.0052	.0029
		36 - 50 HRC	260	.0006	.0011	.0010	.0012	.0013	.0014	.0019	.0016	.0025	.0019	.0036	.0023	.0046	.0027
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	155	.0005	.0010	.0008	.0011	.0010	.0013	.0015	.0014	.0020	.0017	.0028	.0020	.0036	.0024
		75 - 98 HRB	340	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0070	.0034
		21 - 36 HRC	250	.0008	.0012	.0012	.0013	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	75 - 98 HRB	290	.0013	.0016	.0020	.0018	.0026	.0020	.0039	.0023	.0050	.0027	.0072	.0032	.0092	.0039
		21 - 36 HRC	175	.0008	.0012	.0012	.0014	.0016	.0016	.0024	.0018	.0031	.0021	.0045	.0025	.0057	.0030
		36 - 50 HRC	150	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0040	.0024	.0051	.0029
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75 - 98 HRB	265	.0010	.0013	.0015	.0015	.0019	.0017	.0029	.0020	.0037	.0023	.0054	.0028	.0069	.0034
		21 - 36 HRC	225	.0009	.0013	.0013	.0015	.0017	.0016	.0026	.0019	.0033	.0022	.0048	.0026	.0062	.0032
		36 - 50 HRC	180	.0007	.0012	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0049	.0028
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB	300	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0038	.0023	.0055	.0028	.0071	.0034
		21 - 36 HRC	280	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0033	.0022	.0048	.0026	.0061	.0032
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	200	.0007	.0012	.0011	.0013	.0015	.0015	.0022	.0017	.0028	.0020	.0041	.0024	.0052	.0029
		36 - 50 HRC	145	.0006	.0011	.0010	.0012	.0013	.0014	.0019	.0016	.0024	.0019	.0035	.0022	.0045	.0027
GRAY CAST IRON	SAE J431, ASTM A48	75 - 98 HRB	410	.0016	.0017	.0024	.0020	.0032	.0022	.0048	.0026	.0062	.0030	.0090	.0036	.0114	.0043
		21 - 36 HRC	370	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0033	.0022	.0049	.0026	.0062	.0032
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75 - 98 HRB	345	.0010	.0014	.0015	.0015	.0020	.0018	.0030	.0020	.0039	.0024	.0057	.0028	.0072	.0034
		21 - 36 HRC	335	.0009	.0013	.0013	.0014	.0017	.0016	.0026	.0019	.0034	.0022	.0049	.0026	.0062	.0032
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 897	75 - 98 HRB	310	.0011	.0014	.0016	.0016	.0021	.0018	.0032	.0021	.0041	.0024	.0059	.0029	.0075	.0035
		21 - 36 HRC	260	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0050	.0028
		36 - 50 HRC	135	.0005	.0009	.0007	.0010	.0009	.0012	.0013	.0014	.0017	.0016	.0025	.0019	.0032	.0023
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0014	.0016	.0021	.0018	.0027	.0020	.0041	.0023	.0052	.0027	.0076	.0033	.0097	.0040
		75 - 98 HRB	250	.0011	.0015	.0017	.0016	.0023	.0019	.0034	.0021	.0044	.0025	.0064	.0030	.0081	.0036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0007	.0011	.0011	.0013	.0014	.0015	.0021	.0017	.0027	.0020	.0039	.0023	.0049	.0028
		21 - 36 HRC	75	.0007	.0011	.0010	.0012	.0013	.0014	.0020	.0016	.0025	.0019	.0037	.0023	.0047	.0028
		36 - 50 HRC	70	.0006	.0010	.0008	.0011	.0011	.0013	.0017	.0015	.0022	.0018	.0032	.0021	.0040	.0026
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0019	.0019	.0028	.0021	.0037	.0024	.0056	.0028	.0072	.0032	.0105	.0039	.0134	.0047
		75 - 98 HRB	275	.0016	.0017	.0024	.0019	.0031	.0022	.0047	.0025	.0060	.0030	.0088	.0035	.0112	.0043
		21 - 36 HRC	250	.0012	.0015	.0018	.0017	.0023	.0019	.0035	.0022	.0045	.0026	.0066	.0031	.0084	.0037
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.0009	.0013	.0014	.0015	.0018	.0017	.0028	.0020	.0036	.0023	.0052	.0027	.0066	.0033
		36 - 50 HRC	160	.0009	.0013	.0013	.0014	.0017	.0016	.0025	.0019	.0033	.0022	.0047	.0026	.0060	.0031
COBALT ALLOY	ASTM F562, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0008	.0012	.0012	.0014	.0016	.0016	.0023	.0018	.0030	.0021	.0044	.0025	.0056	.0030
		21 - 36 HRC	170	.0008	.0012	.0012	.0013	.0015	.0015	.0023	.0017	.0029	.0020	.0042	.0024	.0054	.0030
		36 - 50 HRC	65	.0005	.0010	.0008	.0011	.0010	.0013	.0015	.0014	.0020	.0017	.0029	.0020	.0037	.0024

Milling Process	Hardness	ADOC	RDOC
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	10%-15% Diameter
	≥ 35 HRC	Up to Max LOC	10%-15% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

NOTES:

Hardness Scales: HRB = Rockwell B
HRC = Rockwell C

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. Values shown are for non-reached tools. For tools with reaches greater than 3xD, IPT should be reduced. For more accurate running parameters, please refer to Machining Advisor Pro.