HARVEY TOOL

Speeds & Feeds

Product Table: Engraving Cutters - Tipped Off - 2 Flute - For Hardened Steels
Characteristics: 2 Flutes

Series or Item	RPM	Chip Load (IPT) by Material		Axial DOC
		Hardened Steels		
		45 < 55 Rc	56 < 68 Rc	
7625xx-C6	6000+	.00036	.00029	< .010
7639xx-C6	6000+	.00025	.00020	< .010
8115xx-C6	6000+	.00034	.00027	< .010
8116xx-C6	6000+	.00027	.00022	< .010
8117xx-C6	6000+	.00026	.00020	< .010
8174xx-C6	6000+	.00044	.00035	< .010
8175xx-C6	6000+	.00040	.00032	< .010
8176xx-C6	6000+	.00028	.00022	< .010
8177xx-C6	6000+	.00044	.00035	< .010
8179xx-C6	6000+	.00028	.00022	< .010
8653xx-C6	6000+	.00048	.00038	< .010
8667xx-C6	6000+	.00032	.00026	< .010
8681xx-C6	6000+	.00040	.00032	< .010
8684xx-C6	6000+	.00044	.00035	< .010
8751xx-C6	6000+	.00032	.00026	< .010
8765xx-C6	6000+	.00044	.00035	< .010
8796xx-C6	6000+	.00028	.00022	< .010
8809xx-C6	6000+	.00035	.00028	< .010
8820xx-C6	6000+	.00028	.00022	< .010
8896xx-C6	6000+	.00040	.00032	< .010
8923xx-C6	6000+	.00040	.00032	< .010

Please note:

All posted speed and feed parameters are suggested starting val
runout is required for best results).

Suggested speed is 6000 rpm or more. Choose an rpm value tha
cases, a speed increaser is helpful.
Posted chip loads reflect axial depths of cut up to .009. For dept
of cut = .016" -.020", reduce posted chip loads by 30%.
Posted chip loads reflect uncoated cutters. Coating is better suit
Posted chip loads reflect HORIZONTAL milling conditions. For V
(Do not plunge more than .009" depth, ramping is preferred to ma

If you require additional information, Harvey Tool has a team of t
challenging applications. Please contact us at **800-645-5609** or **H**

WARNING: Cutting tools may shatter under improper use. Gove
appropriate safety equipment in the vicinity of use.

lues that may be increased given optimal setup conditions (minimal

at creates the least amount of internal machine vibration. In many

hs of cut = .010" -.015", reduce posted chip loads by 20%. For depths

ed to prolong tool life rather than decrease cycle times.
/ERTICAL plunge milling to depth, reduce posted chip loads by 70%
aintain tip integrity).

echnical experts available to assist you through even the most
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rnment regulations require use of safety glasses and other