



Speeds & Feeds

Product Table: Thread Milling Cutters - Thread Relief Cutter

Characteristics: Short Reach

Series: 9429xx, 9460xx, 9525xx, 9553xx, 9754xx, 9796xx, 9857xx, 9888xx

Product notes:

Typical thread reliefs are done before threading to avoid any damage to the threads. Depth of Cut is shown as number of Passes with each pass resulting in a descending stepover.

Chip Loads within table pertain to machining on one side (from tool centerline) of the cutter head. This chart represents a linear feed rate chip load. Since this tool is used in a helical interpolation environment, adjusting the feed rate for a circular motion is needed to avoid deflection and tool breakage. To calculate use the formula:

Adj Internal Circular Feed = [(Hole Dia - Cutter Dia) / Hole Dia] x Linear Feed

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. 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.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Diameter (0.062 to 1.000), Depth of Cut (Radial, Axial). Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, COPPER ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Diameter (0.062 to 1.000), Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, HIGH TEMP ALLOYS.

Table with columns: MATERIAL, SFM, Chip Load (IPT) By Cutter Diameter (0.062 to 1.000), Depth of Cut (Radial, Axial). Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, TITANIUM ALLOYS, HIGH TEMP ALLOYS.