



Product Table: Hexalobe Cutters
Characteristics: 6x Length of cut
Series: 7933xx-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													
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Finishing	.00005	.00010	.00016	.05 x Dia	6 x Dia	.00021	.00026	.00031	.00041	.10 x Dia	6 x Dia
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia
STAINLESS STEELS													
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	Finishing	.00005	.00010	.00016	.05 x Dia	6 x Dia	.00021	.00026	.00031	.00041	.10 x Dia	6 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	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
TOOL STEELS													
A, L, O, P, W series	200	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia
D, H, M, T, S series	150	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
TITANIUM ALLOYS													
	150	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
HIGH TEMP ALLOYS													
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
Cobalt Chromium Alloys	60	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 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	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia
90	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
100	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia
90	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
75	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
50	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
45	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia