

**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														
<b>CARBON STEELS</b>																										
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	-	-	-	-	-	-	-	-	-	-	-	-	
<b>STAINLESS STEELS</b>																										
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	100	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	90	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
<b>TOOL STEELS</b>																										
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	100	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	90	Finishing	.00003	.00006	.00009	.05 x Dia	6 x Dia	.00012	.00015	.00018	.00024	.10 x Dia	6 x Dia
<b>TITANIUM ALLOYS</b>																										
	150	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
<b>HIGH TEMP ALLOYS</b>																										
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	50	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	45	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia

MATERIAL	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	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	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	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	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	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	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	45	Finishing	.00005	.00009	.00014	.05 x Dia	6 x Dia	.00019	.00024	.00028	.00038	.10 x Dia	6 x Dia