



Speeds & Feeds

Product Table: Chamfer Cutters - Back Chamfer Cutters
Characteristics: 90° Included Angle, 3x Reach Multiple, 6 Flutes
Series: 9434xx

Product notes:

Due to a varying diameter, an Effective Cutter Diameter is needed for Chip Load selection and RPM calculation:

Effective Cutter Diameter = (Major Diameter + Minor Diameter)/2.

Or consider the actual diameter along the angle that is engaged with the workpiece.

For Full Chamfer engagement the Effective Cutter Diameter is 80% of the cutter diameter

Depth of Cut is shown as number of Passes with each pass resulting in a descending stepover

Chip Loads are given 3 ways:

Deburring refers to removing the burr only

Traditional Edge Break of .010"- .015"

Full Chamfer engagement

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 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 harveymech@harveypformance.com.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other

Table with columns: MATERIAL, SFM, Hardness: <= 28 Rc (<= 271 HBn), Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), and Depth of Cut Passes. Rows include ALUMINUM ALLOYS, MAGNESIUM ALLOYS, ZINC ALLOYS, and COPPER ALLOYS.

Table with columns: MATERIAL, SFM, Hardness: 29-37 Rc (279-344 HBn), Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), and Depth of Cut Passes. Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.

Table with columns: MATERIAL, SFM, Hardness: 38-45 Rc (353-421 HBn), Chip Load (IPT) By Effective Cutter Diameter (0.015 to 0.500), and Depth of Cut Passes. Rows include CARBON STEELS, STAINLESS STEELS, TOOL STEELS, and TITANIUM ALLOYS.