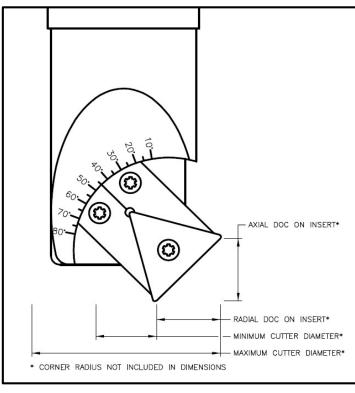


**Product Table:** Chamfer Cutters - Adjustable Chamfer Cutters

**Series:** Tool #81250, Tool #81260

| MATERIAL | SPEED (RPM)     | FEED (Inches/Min) | DEPTH (Inches) |
|----------|-----------------|-------------------|----------------|
| STEEL    | 600 - 2000      | 1" - 4"           | 1/8" MAX       |
| ALUMINUM | 1000 - 6000 MAX | 3" - 8"           | 1/8" MAX       |



|               |           |           | 1          |            |
|---------------|-----------|-----------|------------|------------|
| Angle Setting | Minimum   | Maximum   | Radial DOC | Axial DOC  |
| on Tool       | Diameter* | Diameter* | of Insert* | of Insert* |
| 10°           | 0.0717    | 1.2466    | 0.587      | 0.104      |
| 15°           | 0.1149    | 1.2672    | 0.576      | 0.154      |
| 20°           | 0.1617    | 1.2828    | 0.561      | 0.204      |
| 25°           | 0.2119    | 1.2931    | 0.541      | 0.252      |
| 30°           | 0.2649    | 1.2981    | 0.517      | 0.298      |
| 35°           | 0.3205    | 1.2977    | 0.489      | 0.342      |
| 40°           | 0.3781    | 1.2920    | 0.457      | 0.383      |
| 45°           | 0.4374    | 1.2810    | 0.422      | 0.422      |
| 50°           | 0.4978    | 1.2647    | 0.383      | 0.457      |
| 55°           | 0.5590    | 1.2433    | 0.342      | 0.489      |
| 60°           | 0.6205    | 1.2170    | 0.298      | 0.517      |
| 65°           | 0.6818    | 1.1860    | 0.252      | 0.541      |
| 70°           | 0.7424    | 1.1504    | 0.204      | 0.561      |
| 75°           | 0.8018    | 1.1106    | 0.154      | 0.576      |
| 80°           | 0.8597    | 1.0669    | 0.104      | 0.587      |

## **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  $\leq 28$  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.