



**Product Table:** Valve Stem Cutters - Integrated Shank

Material	Type	Edge Type	RPM	IPM by Cutter Diameter			Depth of Cut		
				.750	.750	1.000	Radial	Axial	
Honeycomb Core	Aluminum Core $\leq$ 6% Density	Smooth, Stagger Tooth	16000	Finish	110	110	125	.050"-.070"	.050"
	Aluminum Core $\geq$ 6% Density	Stagger Tooth, Sawtooth	16000	Finish	110	110	125	.050"-.070"	.050"
	Nomex	Smooth, Stagger Tooth	Dia $\leq$ .750":18000-24000 Dia $>$ .750":12000-16250	Finish	150-300	150-300	150-300	.080"-.100"	.050"

**Product Notes:**

Aluminum Core: Use Conventional direction at all times unless beveling to a sharp edge. Recommend .25° to 2° Lead angle on all cuts. If using 3 axis machine, 0° degree can be used for facing. Watch cutting edges of tools closely to avoid grabbing "ribbons" which can cause severe damage to part. Standard "backers" such as peel ply are recommended if available. Also, application of hot glue bead around stock edges to strengthen workholding is recommended where applicable.

Nomex: Use Conventional direction at all times unless beveling to a sharp edge. Recommend .5° to 2° Lead angle on all cuts. If using 3 axis machine, 0° degree can be used for facing. Watch cutting edges of tools closely to avoid grabbing "ribbons" which can cause severe damage to part. Standard "backers" such as peel ply are recommended if available.

**General Notes:**

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **833-584-3448** or **corehogtech@harveypformance.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.