Speeds & Feeds

Product Table: Slitting Saws - Full Radius
Series: SFRxxxx, SAKxxxx, SAHxxxx, SAJxxxx

Product notes:

When Thickness to Cutter Diameter ratio is less than 1%, reduce IPT to 50% and Radial Depth of cut to 3x Thickness

For greater Radial Depth of cuts:
8x Thickness, reduce SFM by 10%

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 up to 15% if coated.

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	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn) Chip Load (IPT) By Cutter Diameter 1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Depth of Cut Radial	Axial
ALUMINUM ALLOYS												
Casting (2xx, 5xx, 7xx, 8xx)	1250	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1500											
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	950	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	900											
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	850											
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700											
Wrought - 5%-8% Si (4xxx)	1500											
Wrought - 8%-12% Si (4xxx)	1000											
MAGNESIUM ALLOYS	1500	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
ZINC ALLOYS	1000											
COPPER ALLOYS												
High Coppers - 90%+ (C1xxxx)	500	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	700											
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	500											
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	700											
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	700											
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	500											
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	750											

MATERIAL	SFM	Hardness: 29-37 Rc (279-344 HBn) Chip Load (IPT) By Cutter Diameter 1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Depth of Cut Radial	Axial
CARBON STEELS												
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	175	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	150	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
STAINLESS STEELS												
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	200	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
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	125	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	100	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
TOOL STEELS												
A, L, O, P, W series	125	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
D, H, M, T, S series	100	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
TITANIUM ALLOYS	200	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK
HIGH TEMP ALLOYS												
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	80	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK

SFM	Hardness: 38-45 Rc (353-421 HBn) Chip Load (IPT) By Cutter Diameter 1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Depth of Cut Radial	Axial
-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-
100	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK
90	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK
100	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK
90	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK
175	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK
50	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	.00081	5x THK	Full THK