

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)									Chip Load (IPT) By Cutter Diameter		Depth of Cut	
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Radial	Axial		
												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													
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	900													
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	850	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK		
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													
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C6400-C6900)	700													
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	500													
Aluminum Bronzes (Copper Aluminum alloys, C6000-C64200)	700	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	.00090	5x THK	Full THK		
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													



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: 29-37 Rc (279-344 HBn)											Chip Load (IPT) By Cutter Diameter		Depth of Cut	
		1.000	1.250	1.500	1.750	2.000	2.500	3.000	3.500	4.000	Radial	Axial				
												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 & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 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				

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