

HSV-4

SPEEDS & FEEDS

4 Flute - Variable Pitch

HSV-4 / HSV-RN-4 / HSM-4

Material Guide		Hardness	SFM	Inches per Tooth (IPT)																										
				1/16			3/32			1/8			3/16			1/4			3/8			1/2			3/4			1		
				Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	455	.0004	.0006	.0008	.0005	.0009	.0012	.0007	.0012	.0016	.0010	.0018	.0019	.0014	.0024	.0021	.0020	.0036	.0024	.0027	.0047	.0028	.0038	.0067	.0034	.0049	.0086	.0041
		75 - 98 HRB	445	.0003	.0005	.0007	.0004	.0007	.0011	.0005	.0009	.0014	.0008	.0013	.0016	.0010	.0018	.0018	.0015	.0026	.0021	.0020	.0034	.0024	.0028	.0049	.0029	.0036	.0063	.0035
		21 - 36 HRC	400	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0011	.0014	.0010	.0017	.0017	.0013	.0022	.0019	.0018	.0032	.0023	.0023	.0041	.0028
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB	390	.0003	.0004	.0007	.0004	.0006	.0010	.0005	.0008	.0013	.0007	.0011	.0015	.0009	.0015	.0017	.0013	.0023	.0019	.0017	.0030	.0023	.0024	.0043	.0027	.0031	.0054	.0033
		21 - 36 HRC	340	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0012	.0014	.0010	.0017	.0017	.0013	.0022	.0019	.0018	.0032	.0023	.0023	.0040	.0028
		36 - 50 HRC	260	.0002	.0003	.0006	.0002	.0004	.0008	.0003	.0005	.0011	.0004	.0007	.0012	.0006	.0010	.0013	.0008	.0015	.0016	.0011	.0019	.0018	.0016	.0028	.0022	.0020	.0034	.0026
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC	155	.0001	.0002	.0005	.0002	.0003	.0007	.0002	.0004	.0009	.0003	.0006	.0010	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0015	.0016	.0012	.0022	.0019	.0016	.0028	.0023
		75 - 98 HRB	340	.0003	.0004	.0007	.0004	.0006	.0010	.0005	.0008	.0013	.0007	.0011	.0015	.0009	.0015	.0017	.0013	.0023	.0019	.0017	.0030	.0023	.0024	.0043	.0027	.0031	.0054	.0033
		21 - 36 HRC	250	.0002	.0003	.0006	.0003	.0005	.0009	.0004	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0018	.0017	.0013	.0024	.0020	.0019	.0034	.0024	.0025	.0043	.0029
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	75 - 98 HRB	290	.0003	.0005	.0008	.0005	.0008	.0011	.0006	.0010	.0015	.0009	.0015	.0017	.0011	.0020	.0019	.0017	.0030	.0022	.0022	.0039	.0026	.0032	.0056	.0031	.0040	.0071	.0037
		21 - 36 HRC	175	.0002	.0003	.0006	.0003	.0005	.0009	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0018	.0015	.0027	.0021	.0022	.0038	.0025	.0028	.0049	.0031
		36 - 50 HRC	150	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0031	.0023	.0022	.0039	.0028
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75 - 98 HRB	265	.0002	.0004	.0007	.0003	.0006	.0010	.0004	.0008	.0013	.0006	.0011	.0015	.0009	.0015	.0017	.0013	.0022	.0019	.0017	.0029	.0022	.0024	.0042	.0026	.0030	.0053	.0032
		21 - 36 HRC	225	.0002	.0004	.0006	.0003	.0005	.0009	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0026	.0021	.0021	.0038	.0025	.0027	.0048	.0030
		36 - 50 HRC	180	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0022	.0038	.0027
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB	300	.0003	.0004	.0007	.0004	.0006	.0010	.0005	.0008	.0013	.0007	.0011	.0015	.0009	.0016	.0017	.0013	.0023	.0019	.0017	.0030	.0023	.0024	.0043	.0027	.0031	.0055	.0033
		21 - 36 HRC	280	.0002	.0004	.0006	.0003	.0005	.0009	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0013	.0016	.0011	.0020	.0018	.0015	.0026	.0021	.0021	.0037	.0025	.0027	.0047	.0030
		36 - 50 HRC	200	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0010	.0017	.0016	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0040	.0028
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	200	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0010	.0017	.0016	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0040	.0028
		36 - 50 HRC	145	.0002	.0003	.0006	.0002	.0004	.0008	.0003	.0005	.0011	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0015	.0011	.0019	.0018	.0016	.0027	.0021	.0020	.0035	.0026
		75 - 98 HRB	410	.0004	.0007	.0009	.0005	.0010	.0013	.0007	.0013	.0017	.0011	.0019	.0019	.0014	.0025	.0021	.0021	.0037	.0025	.0027	.0048	.0029	.0039	.0069	.0034	.0050	.0088	.0042
GRAY CAST IRON	SAE J431, ASTM A48	21 - 36 HRC	370	.0002	.0004	.0006	.0003	.0005	.0009	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0013	.0016	.0011	.0020	.0018	.0015	.0026	.0021	.0021	.0038	.0025	.0027	.0048	.0031
		75 - 98 HRB	345	.0003	.0004	.0007	.0004	.0006	.0010	.0005	.0008	.0013	.0007	.0012	.0015	.0009	.0016	.0017	.0013	.0023	.0019	.0017	.0031	.0023	.0025	.0044	.0027	.0032	.0056	.0033
		21 - 36 HRC	335	.0002	.0004	.0006	.0003	.0005	.0009	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0026	.0021	.0021	.0038	.0025	.0027	.0048	.0031
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75 - 98 HRB	310	.0003	.0004	.0007	.0004	.0006	.0011	.0005	.0008	.0014	.0007	.0012	.0015	.0009	.0016	.0017	.0014	.0024	.0020	.0018	.0032	.0023	.0026	.0046	.0028	.0033	.0058	.0034
		21 - 36 HRC	260	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0022	.0039	.0027
		36 - 50 HRC	135	.0001	.0002	.0005	.0002	.0003	.0007	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0010	.0013	.0008	.0013	.0015	.0011	.0019	.0018	.0014	.0024	.0022
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 897	75 - 98 HRB	310	.0003	.0004	.0007	.0004	.0006	.0011	.0005	.0008	.0014	.0007	.0012	.0015	.0009	.0016	.0017	.0014	.0024	.0020	.0018	.0032	.0023	.0026	.0046	.0028	.0033	.0058	.0034
		21 - 36 HRC	260	.0002	.0003	.0006	.0002	.0005	.0008	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0022	.0039	.0027
		36 - 50 HRC	135	.0001	.0002	.0005	.0002	.0003	.0007	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0010	.0013	.0008	.0013	.0015	.0011	.0019	.0018	.0014	.0024	.0022
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0003	.0006	.0008	.0005	.0008	.0011	.0006	.0011	.0015	.0009	.0016	.0017	.0012	.0021	.0020	.0018	.0031	.0023	.0023	.0041	.0026	.0033	.0059	.0031	.0042	.0075	.0038
		75 - 98 HRB	250	.0003	.0005	.0007	.0004	.0007	.0011	.0005	.0009	.0014	.0008	.0013	.0016	.0010	.0018	.0018	.0015	.0026	.0021	.0019	.0034	.0024	.0028	.0049	.0029	.0035	.0063	.0035
		21 - 36 HRC	75	.0002	.0003	.0006	.0002	.0004	.0008	.0003	.0005	.0011	.0004	.0008	.0012	.0006	.0010	.0014	.0009	.0015	.0016	.0011	.0020	.0018	.0016	.0029	.0022	.0021	.0036	.0027
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0002	.0003	.0006	.0002	.0004	.0008	.0003	.0005	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0022	.0038	.0027
		21 - 36 HRC	75	.0002	.0003	.0006	.0002	.0004	.0008	.0003	.0005	.0011	.0004	.0008	.0012	.0006	.0010	.0014	.0009	.0015	.0016	.0011	.0020	.0018	.0016	.0029	.0022	.0021	.0036	.0027
		36 - 50 HRC	70	.0002	.0003	.0005	.0002	.0004	.0008	.0003	.0005	.0010	.0004	.0007	.0011	.0005	.0009	.0013	.0007	.0013	.0015	.0010	.0017	.0017	.0014	.0025	.0020	.0018	.0031	.0025
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0004	.0008	.0009	.0006	.0011	.0014	.0008	.0015	.0018	.0013	.0022	.0020	.0017	.0029	.0023	.0025	.0043	.0027	.0032	.0057	.0031	.0046	.0081	.0037	.0059	.0103	.0045
		75 - 98 HRB	275	.0004	.0006	.0009	.0005	.0009	.0013	.0007	.0012	.0017	.0010	.0018	.0019	.0014	.0024	.0021	.0021	.0036	.0024	.0027	.0047	.0028	.0039	.0068	.0034	.0049	.0087	.0041
		21 - 36 HRC	250	.0003	.0005	.0007	.0004	.0007	.0011	.0005	.0009	.0014	.0008	.0014	.0016	.0010	.0018	.0018	.0015	.0027	.0021	.0020	.0036	.0025	.0029	.0051	.0029	.0037	.0065	.0036
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	75 - 98 HRB	180	.0002	.0004	.0007	.0003	.0005	.0010	.0004	.0007	.0013	.0006	.0011	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0016	.0028	.0022	.0023	.0040	.0026	.0029	.0051	.0031
		21 - 36 HRC	160	.0002	.0004	.0006	.0003	.0005	.0																					