**Product: Back Chamfer Cutters, 90° Incl Angle, 8x Reach, 4 Fl Series: 9103xx, 9104xx**

**Product notes:**
- Due to a varying diameter, an Effective Cutter Diameter is needed for Chip Load selection and RPM calculation.
- Effective Cutter Diameter = (Major Diameter + Minor Diameter)/2
- Or consider the actual diameter along the angle that is engaged with the workpiece.
- For Full Chamfer engagement the Effective Cutter Diameter is 80% of the cutter diameter
- Depth of Cut is shown as number of Passes with each pass resulting in a descending stepover

**Chip Loads are given 3 ways:**
- Deburring refers to removing the burr only
- Traditional Edge Break of .010"-.015"
- Full Chamfer engagement

**Chip Loads within table pertain to machining on one side an existing slot.**
- For machining on two sides, reduce Chip Loads to 60% to 80% depending on contact length and finish

**General notes:**
- All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.
- Chip loads reflect uncoved cutters and may be increased 10%-20% if coated. For ferrous materials with hardness ≤ 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 800-645-5569 or tech@harveytool.com

**WARNING:** Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other personal protective equipment.

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**SFM**

**Hardness: 28-38 Rc (271-421 HBN)**

**Depth of Cut**

**Chip Load (FL) By Effective Cutter Diameter**

**Material**

**Hardness: ≤ 28 Rc (271 HBN)**

**Depth of Cut**

**Chip Load (FL) By Effective Cutter Diameter**

**Material**

**Hardness: 28-38 Rc (271-421 HBN)**

**Depth of Cut**

**Chip Load (FL) By Effective Cutter Diameter**

**Material**

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**SFM**

**Hardness: 29-37 Rc (279-344 HBN)**

**Depth of Cut**

**Chip Load (FL) By Effective Cutter Diameter**

**Material**

**Hardness: ≥ 28 Rc (≥ 271 HBN)**

**Depth of Cut**

**Chip Load (FL) By Effective Cutter Diameter**

**Material**

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