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.

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.

Product Table: Chamfer Cutters - Pointed & Flat End

Characteristics: 6 Flutes

Series: 8932xx, 8847xx, 9493xx, 9528xx

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.

Depth of Cut is shown as number of Passes with each pass resulting in a descending stepover.

Chip Loads are given 3 ways:
- Traditional Edge Break of .010" - .015" Full Chamfer engagement for cutters with angles GREATER than 25° per side (50° included)
- Full Chamfer engagement for cutters with angles LESS than 25° per side (50° included)

For machining on two sides, reduce Chip loads to 60% - 80% depending on contact length and finish

For vertical plunging, reduce Chip Loads to 40% - 50% depending on finish

Generals 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 10%-20% if coated. For ferrous materials with hardness ≤ 28 Rc, chip loads can be increased 10%-20%.

A, L, O, P, W series


C97300-C97800, C99400-C99700


ALUMINUM ALLOYS

A, L, O, P, W series


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