



Series 3400, 3400B, 3400LR, 9400, 9400B & 9400LR Harmon-i-Cut



Material	Cast Iron: Gray, Ductile / Nodular, Malleable				High Temp Alloys: Inconel, Waspalloy				Stainless Steel: 300 Series 400 Series PH Series				Steel: Soft Low Carbon Medium Carbon				Titanium: Ti - 6 Al - 4 V Alloy				Tool Steels: D2-D7 Annealed H10-H19 Annealed A2-A10			
	TOOL DIAMETER	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM	FPT	RPM	IPM	SFM
1/8"	11460	9	375	0.0002	2292	2	75	0.0002	6112	5	200	0.0002	9168	7	300	0.0002	3820	3	125	0.0002	4584	4	150	0.0002
1/4"	5730	23	375	0.0010	1146	5	75	0.0010	3056	10	200	0.0008	4584	18	300	0.0010	1910	9	125	0.0012	2292	7	150	0.0008
3/8"	3820	31	375	0.0020	764	4	75	0.0013	2037	15	200	0.0019	3056	24	300	0.0020	1273	10	125	0.0020	1528	7	150	0.0012
1/2"	2865	29	375	0.0025	573	4	75	0.0016	1528	15	200	0.0025	2292	23	300	0.0025	955	10	125	0.0025	1146	9	150	0.0020
3/4"	1910	23	375	0.0030	382	3	75	0.0022	1019	12	200	0.0029	1528	18	300	0.0030	637	8	125	0.0032	764	8	150	0.0025
1.0"	1433	20	375	0.0035	287	3	75	0.0024	764	10	200	0.0033	1146	16	300	0.0035	478	8	125	0.0040	573	8	150	0.0035

TOOL DIAMETER	RPM	MM/MIN	SMM	FPT	RPM	MM/MIN	SMM	FPT	RPM	MM/MIN	SMM	FPT	RPM	MM/MIN	SMM	FPT	RPM	MM/MIN	SMM	FPT	RPM	MM/MIN	SMM	FPT
3.0MM	12130	246	114	0.0051	2426	49	23	0.0051	6469	131	61	0.0051	9704	197	91	0.0051	4043	82	38	0.0051	4852	99	46	0.0051
6.0MM	6065	616	114	0.0254	1213	123	23	0.0254	3235	263	61	0.0203	4852	493	91	0.0254	2022	246	38	0.0305	2426	197	46	0.0203
10.0MM	3639	739	114	0.0508	728	96	23	0.0330	1941	375	61	0.0483	2911	591	91	0.0508	1213	246	38	0.0508	1455	177	46	0.0305
12.0MM	3032	770	114	0.0635	606	99	23	0.0406	1617	411	61	0.0635	2426	616	91	0.0635	1011	257	38	0.0635	1213	246	46	0.0508
19.0MM	1915	584	114	0.0762	383	86	23	0.0559	1021	301	61	0.0737	1532	467	91	0.0762	638	208	38	0.0813	766	195	46	0.0635
25.0MM	1455	518	114	0.0889	291	71	23	0.0610	776	260	61	0.0838	1164	414	91	0.0889	485	197	38	0.1016	582	207	46	0.0889

Suggested speeds & feeds are for machining a slot depth of 1X diameter of the tool

