

# HV High Velocity Speeds and Feeds Including HV3HD / HV5HD and HV10



Material	Alloy	SFPM	FPT /CPT			GRADE
			HV3HD	HV5HD	HV10	
Non-Ferrous	6061 Aluminum	1000 to 3000+	.003 to .010	.003 to .012	.003 to .024	MTC20/MTC322
	Copper, Brass	800 to 1500	.003 to .008	.003 to .010	.003 to .018	MTC20/MTC322
	Plastics	500 to 3000+	.003 to .015	.003 to .015	.003 to .015	MTC20/MTC322
Steels	1018, 1020	800 to 1500	.002 to .006	.002 to .008		MTC357
	4140, 4340, P20	600 to 1200	.002 to .005	.002 to .007		MTC357
	A2, D2, H13	400 to 1000	.002 to .004	.002 to .006		MTC357
Stainless Steel	13-8, 15-5, 17-4	500 to 1200	.001 to .004	.001 to .006		MTC357/MTC327
	303, 304, 316	800 to 1500	.002 to .006	.002 to .006		MTC357/MTC327
	420, 440C	800 to 1500	.002 to .005	.002 to .005		MTC357/MTC327
High Temp	Inconel	100 to 300	.001 to .004	.001 to .004		MTC327/MTC357
	Titanium	70 to 250	.001 to .004	.001 to .004		MTC327/MTC357
Cast Iron	Gray Iron	500 to 1200	.002 to .004	.002 to .006		MTC327
	Dustile Iron	600 to 1200	.002 to .004	.002 to .006		MTC327

## Freedom Cutter Spare Parts

Part #	Description	Price	Package Quantity
FCS-1032T	T20 Torx Insert Screw for all Freedom Cutters	\$15.00	12 per pack
FCW-125T	T20 Torx wrench Standard Wire Style	\$15.00	10 per pack
FCW-T20	Upgraded T20 Torx Wrench	\$10.00	1 each
MLS-632	Mil-Loc Screw	\$15.00	12 per pack
MLK-62	Mil-Loc Wrench	\$15.00	12 per pack
HDS-28	Heavy Duty Screw	\$16.50	6 per pack
HT-1	Hardness Tester	\$150.00	1 each

## High Velocity Spare Parts

Part #	Description	Price	Package Quantity
HVS-440	HV3HD Insert Screw	\$15.00	9 per pack
HVS-832	HV5HD Insert Screw	\$15.00	9 per pack
HV10-1032	HV10 Insert Screw	\$16.50	9 per pack
HVW-062	HV3HD Wrench	\$15.00	10 per pack
HVW-093	HV5HD Wrench	\$15.00	10 per pack

## Special Application Inserts

Part #	Description	Price
NP45L-.635-MTX001	Silicon Nitride for Cast Iron	\$22.95
NP032-.635-MTX001	Silicon Nitride for Cast Iron	\$22.95
PCD Tipped Freedom Inserts	Single PCD added to an Insert	\$86.00
PCD Tipped HV3 /HV5 Inserts	Single PCD added to an Insert	\$93.00
Diamond Coated CVD	CVD Diamond Coated Insert	\$70.00