



# SERIES 3833 and 9833 ALUMA-MILL G3



INCH SIZE	Aluminum Alloys, Magnesium (1500 - 2000) SFM					Cast Aluminum (Si > 10%) (800 - 1500) SFM					Plastics (contact Fullerton for special considerations) (600 - 900) SFM						
	Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)				
	Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish		
	(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D				
	Radial Width	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	
	1/4	.0020	.0030	.0020	.0040	.0024	.0015	.0020	.0020	.0035	.0020	.0020	.0025	.0020	.0025	.0025	
	3/8	.0030	.0040	.0040	.0060	.0045	.0035	.0040	.0045	.0055	.0040	.0025	.0030	.0025	.0030	.0030	
	1/2	.0040	.0060	.0050	.0075	.0070	.0050	.0050	.0055	.0065	.0050	.0035	.0040	.0040	.0045	.0045	
	3/4	.0070	.0080	.0085	.0110	.0100	.0060	.0085	.0080	.0090	.0070	.0050	.0055	.0055	.0070	.0070	
	1	.0080	.0100	.0095	.0120	.0110	.0080	.0100	.0110	.0110	.0090	.0060	.0065	.0060	.0075	.0075	
		FPT (in/tooth)					FPT (in/tooth)					FPT (in/tooth)					
		Copper Alloys (800 - 1200) SFM					Brass / Bronze (800 - 1500) SFM					<i>D</i> cutter diameter (inches) <i>T</i> tooth count (flutes) <i>FPT</i> feed per tooth (in/tooth) <i>SFM</i> surface speed (ft/min) = $FPT \times T \times RPM$ <i>RPM</i> spindle speed (rpm) = $(SFM \times 3.82) \div D$ <i>IPM</i> feed rate (inch/min) = $FPT \times T \times RPM$					
		Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)								
		Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish						
		(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D								
		Radial Width	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D						(.03 - .06) x D
		1/4	.0020	.0025	.0020	.0020	.0020	.0040	.0030	.0030	.0035						.0035
		3/8	.0025	.0030	.0030	.0025	.0025	.0050	.0035	.0040	.0045						.0045
		1/2	.0035	.0040	.0040	.0030	.0030	.0060	.0045	.0045	.0055						.0055
		3/4	.0045	.0055	.0055	.0070	.0070	.0080	.0070	.0060	.0075						.0075
		1	.0100	.0065	.0060	.0050	.0080	.0100	.0085	.0070	.0085						.0085
		FPT (in/tooth)					FPT (in/tooth)										

METRIC SIZE	Aluminum Alloys, Magnesium (450 - 610) SMPM					Cast Aluminum (Si > 10%) (245 - 460) SMPM					Plastics (contact Fullerton for special considerations) (180 - 275) SMPM						
	Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)				
	Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish		
	(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D				
	Radial Width	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	
	6.0	0.05	0.08	0.05	0.10	0.06	0.04	0.05	0.05	0.09	0.05	0.05	0.06	0.05	0.06	0.06	
	10.0	0.08	0.10	0.10	0.15	0.11	0.09	0.10	0.11	0.14	0.10	0.06	0.08	0.06	0.08	0.08	
	12.0	0.10	0.15	0.13	0.19	0.18	0.13	0.13	0.14	0.17	0.13	0.09	0.10	0.10	0.11	0.11	
	20.0	0.18	0.20	0.22	0.28	0.25	0.15	0.22	0.20	0.23	0.18	0.13	0.14	0.14	0.18	0.18	
	25.0	0.20	0.25	0.24	0.30	0.28	0.20	0.25	0.28	0.28	0.23	0.15	0.17	0.15	0.19	0.19	
		FPT (mm/tooth)					FPT (mm/tooth)					FPT (mm/tooth)					
		Copper Alloys (245 - 370) SMPM					Brass / Bronze (245 - 460) SMPM					<i>D</i> cutter diameter (mm) <i>T</i> tooth count (flutes) <i>FPT</i> feed per tooth (mm/tooth) <i>SMPM</i> surface speed (m/min) = $FPT \times T \times RPM$ <i>RPM</i> spindle speed (rpm) = $(SMPM \times 3.82) \div D$ <i>MPM</i> feed rate (m/min) = $FPT \times T \times RPM$					
		Slotting		Side Milling (Profiling)			Slotting		Side Milling (Profiling)								
		Rough	Finish	Heavy	Light	Finish	Rough	Finish	Heavy	Light	Finish						
		(.5 - 1) x D	(.2 - .4) x D	1.5 x D			(.5 - 1) x D	(.2 - .4) x D	1.5 x D								
		Radial Width	full	full	(.3 - .5) x D	(.1 - .2) x D	(.03 - .06) x D	full	full	(.3 - .5) x D	(.1 - .2) x D						(.03 - .06) x D
		6.0	0.05	0.06	0.05	0.05	0.05	0.10	0.08	0.08	0.09						0.09
		10.0	0.06	0.08	0.08	0.06	0.06	0.13	0.09	0.10	0.11						0.11
		12.0	0.09	0.10	0.10	0.08	0.08	0.15	0.11	0.11	0.14						0.14
		20.0	0.11	0.14	0.14	0.18	0.18	0.20	0.18	0.15	0.19						0.19
		25.0	0.25	0.17	0.15	0.13	0.20	0.25	0.22	0.18	0.22						0.22
		FPT (mm/tooth)					FPT (mm/tooth)										