



## **FULLERTON** S P E E D S / F E E D S

### Three RH Spiral Flutes | 90° Point

		Imperial (in)						Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
Composites	RPM	1,681	840	560	420	280	210	1,779	889	534	445	281	213
	IPM	1	1	1	1	1	1	21	15	14	21	21	19
	SFM	55	55	55	55	55	55	17	17	17	17	17	17
	IPR	.001	.001	.001	.002	.003	.004	0.01	0.02	0.03	0.05	0.08	0.09
Plastics	RPM	1,681	840	560	420	280	210	1,779	889	534	445	281	213
	IPM	1	1	1	1	1	1	21	15	14	21	21	19
	SFM	55	55	55	55	55	55	17	17	17	17	17	17
	IPR	.001	.001	.001	.002	.003	.004	0.01	0.02	0.03	0.05	0.08	0.09
Graphite	RPM	2,139	1,070	713	535	357	267	2,264	1,132	679	566	357	272
	IPM	1	1	1	1	1	1	33	22	18	27	27	27
	SFM	70	70	70	70	70	70	21	21	21	21	21	21
	IPR	.001	.001	.001	.002	.003	.004	0.01	0.02	0.03	0.05	0.08	0.10

Not Recommended for High Si Aluminum >10%, Low Si Aluminum <10%, Brass & Copper, Cast Iron, Hardened Steels >48 RC, Steels, Stainless Steels, Super Alloy (Nickel based, Inconel), or Titanium. The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.