



FULLERTON SPEEDS / FEEDS

Two Straight Flutes | 135° Notched Point

	Imperial (in)							Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
Hardened Steels >48RC	RPM	1,834	917	611	458	306	229	1,940	970	582	485	306	233
	IPM	1	1	1	1	1	1	23	16	16	23	23	20
	SFM	60	60	60	60	60	60	18	18	18	18	18	18
	IPR	.001	.001	.001	.002	.003	.004	0.01	0.02	0.03	0.05	0.08	0.09

Not Recommended for Plastics, Brass & Copper, Stainless Steels, Super Alloy (Nickel based, Inconel), or Titanium. High Si Aluminum >10%, Low Si Aluminum <10%, Composites, Graphite, Cast Iron, or Steels are only recommended in unique situations. 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.