



FULLERTON[®]

S P E E D S / F E E D S

Two RH Spiral Flutes | 120° /130° Double Angle Point | Coolant Fed

		Imperial (in)						Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
High Si Aluminum >10%	RPM	19,864	9,932	6,621	4,966	3,311	2,483	21,021	10,510	6,306	5,255	3,319	2,522
	IPM	117	78	78	69	50	40	2977	1993	1984	1741	1261	1015
	SFM	650	650	650	650	650	650	198	198	198	198	198	198
	IPR	.006	.008	.012	.014	.015	.016	0.14	0.19	0.31	0.33	0.38	0.40
Low Si Aluminum <10%	RPM	22,920	11,460	7,640	5,730	3,820	2,865	24,254	12,127	7,276	6,064	3,830	2,911
	IPM	126	91	84	79	68	53	3202	2299	2134	2008	1717	1346
	SFM	750	750	750	750	750	750	229	229	229	229	229	229
	IPR	.006	.008	.011	.014	.018	.019	0.13	0.19	0.29	0.33	0.45	0.46
Brass & Copper	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	90	60	60	53	38	31	2290	1533	1526	1339	970	776
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.006	.008	.012	.014	.015	.016	0.14	0.19	0.31	0.33	0.38	0.40
Cast Iron	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	78	60	46	40	34	28	1979	1533	1177	1028	867	699
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.005	.008	.009	.011	.013	.014	0.12	0.19	0.24	0.25	0.34	0.36
Steels	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	84	60	51	47	34	28	2134	1533	1294	1184	867	699
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.006	.008	.010	.012	.013	.014	0.13	0.19	0.27	0.29	0.34	0.36
Stainless Steels	RPM	7,640	3,820	2,547	1,910	1,273	955	8,085	4,042	2,425	2,021	1,277	970
	IPM	24	23	19	17	14	11	602	572	485	422	356	291
	SFM	250	250	250	250	250	250	76	76	76	76	76	76
	IPR	.003	.006	.008	.009	.011	.012	0.07	0.14	0.20	0.21	0.28	0.30
Super Alloy (Nickel based Inconel)	RPM	3,820	1,910	1,273	955	637	478	4,042	2,021	1,213	1,011	638	485
	IPM	9	7	6	5	4	3	233	189	152	124	95	75
	SFM	125	125	125	125	125	125	38	38	38	38	38	38
	IPR	.002	.004	.005	.005	.006	.006	0.06	0.09	0.13	0.12	0.15	0.16
Titanium	RPM	6,112	3,056	2,037	1,528	1,019	764	6,468	3,234	1,940	1,617	1,021	776
	IPM	19	14	12	10	9	8	481	365	305	244	235	194
	SFM	200	200	200	200	200	200	61	61	61	61	61	61
	IPR	.003	.005	.006	.006	.009	.010	0.07	0.11	0.16	0.15	0.23	0.25

Not Recommended for Composites, Plastics, Graphite, and Hardened Steels >48RC. 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.