

3000 INTIMIDATOR - IMPERIAL



3000 Series Intimidator End Mill is designed for tough-to-machine ferrous materials.

Not Recommended for Composites, Plastics, or Graphite. High Si Aluminum and Low Si Aluminum 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.

FULLERTON
SPEEDS / FEEDS

	Graphite					Cast Iron					Hardened Steels > 48 RC				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	500	500	800	800	800	400	400	400	600	600	130	130	130	170	170
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0030	.0030	.0040	.0040	.0040	.0008	.0010	.0007	.0007	.0010	.0006	.0007	.0006	.0006	.0007
1/4"	.0050	.0050	.0060	.0060	.0060	.0015	.0020	.0015	.0015	.0020	.0012	.0014	.0012	.0012	.0014
3/8"	.0070	.0070	.0080	.0080	.0080	.0025	.0030	.0025	.0025	.0030	.0018	.0020	.0018	.0018	.0020
1/2"	.0090	.0090	.0100	.0100	.0100	.0028	.0032	.0028	.0028	.0032	.0020	.0022	.0020	.0020	.0022
3/4"	.0120	.0120	.0150	.0150	.0150	.0030	.0035	.0030	.0030	.0035	.0024	.0026	.0024	.0024	.0026
1"	.0180	.0180	.0200	.0200	.0200	.0040	.0045	.0040	.0040	.0045	.0025	.0027	.0025	.0025	.0027

	Steels					Stainless Steels					Super Alloys (Nickel Based, Inconel)					Titanium				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	300	300	300	600	600	250	250	250	300	300	90	90	90	120	120	90	90	120	150	150
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0007	.0009	.0007	.0007	.0009	.0007	.0009	.0007	.0007	.0009	.0004	.0005	.0004	.0004	.0005	.0004	.0005	.0004	.0004	.0005
1/4"	.0015	.0018	.0015	.0015	.0018	.0015	.0018	.0015	.0015	.0018	.0008	.0010	.0008	.0008	.0010	.0008	.0010	.0008	.0008	.0010
3/8"	.0020	.0022	.0020	.0020	.0022	.0024	.0026	.0024	.0024	.0026	.0013	.0015	.0013	.0013	.0015	.0012	.0015	.0012	.0012	.0015
1/2"	.0022	.0024	.0022	.0022	.0024	.0026	.0028	.0026	.0026	.0028	.0019	.0020	.0019	.0019	.0020	.0016	.0018	.0016	.0016	.0018
3/4"	.0026	.0028	.0026	.0026	.0028	.0028	.0032	.0028	.0028	.0032	.0025	.0028	.0025	.0025	.0028	.0020	.0022	.0020	.0020	.0022
1"	.0028	.0030	.0028	.0028	.0030	.0030	.0035	.0030	.0030	.0035	.0027	.0030	.0027	.0027	.0030	.0028	.0030	.0028	.0028	.0030

3000 INTIMIDATOR - METRIC



3000 Series Intimidator End Mill is designed for tough-to-machine ferrous materials.

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FULLERTON
SPEEDS / FEEDS

	Graphite					Cast Iron					Hardened Steels > 48 RC				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	152	152	243	243	243	121	121	121	182	182	39	39	39	51	51
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD
3	.0762	.0762	.1016	.1016	.1016	.0203	.0254	.0178	.0178	.0254	.0152	.0178	.0152	.0152	.0178
6	.1270	.1270	.1524	.1524	.1524	.0381	.0508	.0381	.0381	.0508	.0305	.0356	.0305	.0305	.0356
10	.1778	.1778	.2032	.2032	.2032	.0635	.0762	.0635	.0635	.0762	.0457	.0508	.0457	.0457	.0508
12	.2286	.2286	.2540	.2540	.2540	.0711	.0813	.0711	.0711	.0813	.0508	.0559	.0508	.0508	.0559
20	.3048	.3048	.3810	.3810	.3810	.0762	.0889	.0762	.0762	.0889	.0610	.0660	.0610	.0610	.0660
25	.4572	.4572	.5080	.5080	.5080	.1016	.1143	.1016	.1016	.1143	.0635	.0686	.0635	.0635	.0686

	Steels					Stainless Steels					Super Alloys (Nickel Based, Inconel)					Titanium				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	91	91	91	182	182	76	76	76	91	91	27	27	27	36	36	27	27	36	45	45
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(1-.25)xD	(.05-.08)xD
3	.0178	.0229	.0178	.0178	.0229	.0178	.0229	.0178	.0178	.0229	.0102	.0127	.0102	.0102	.0127	.0102	.0127	.0102	.0102	.0127
6	.0381	.0457	.0381	.0381	.0457	.0381	.0457	.0381	.0381	.0457	.0203	.0254	.0203	.0203	.0254	.0203	.0254	.0203	.0203	.0254
10	.0508	.0559	.0508	.0508	.0559	.0610	.0660	.0610	.0610	.0660	.0330	.0381	.0330	.0330	.0381	.0305	.0381	.0305	.0305	.0381
12	.0559	.0610	.0559	.0559	.0610	.0660	.0711	.0660	.0660	.0711	.0483	.0508	.0483	.0483	.0508	.0406	.0457	.0406	.0406	.0457
20	.0660	.0711	.0660	.0660	.0711	.0711	.0813	.0711	.0711	.0813	.0635	.0711	.0635	.0635	.0711	.0508	.0559	.0508	.0508	.0559
25	.0711	.0762	.0711	.0711	.0762	.0762	.0889	.0762	.0762	.0889	.0686	.0762	.0686	.0686	.0762	.0711	.0762	.0711	.0711	.0762