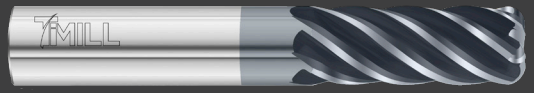
3116 TiMILL - IMPERIAL



FULLERTON®

SPEEDS / FEEDS

3116 Series TiMill designed to excel in titanium.

Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, or Graphite.

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.

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SFM (ft/min)			300	325	325
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8”			.0003	.0003	.0004
1/4”			.0008	.0008	.0010
3/8”			.0010	.0010	.0015
1/2”			.0015	.0015	.0020
3/4”			.0020	.0020	.0025
1”			.0032	.0032	.0035

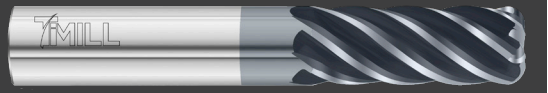
Examples: Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al, (with the exception of β Ti)

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SFM (ft/min)			400	400	400
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8”			.0003	.0003	.0004
1/4”			.0008	.0008	.0010
3/8”			.0010	.0010	.0015
1/2”			.0015	.0015	.0020
3/4”			.0020	.0020	.0025
1”			.0032	.0032	.0035

Examples: Ti Grade 1, Ti Grade 2, Ti Grade 3,Ti Grade 4, Ti Grade 7, Ti Grade 12

IPT (in/tooth)

3116 TiMILL - METRIC



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FULLERTON®

SPEEDS / FEEDS

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SMM (ft/min)			90	100	100
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3			.0076	.0076	.0102
6			.0203	.0203	.0254
10			.0254	.0254	.0381
12			.0381	.0381	.0508
20			.0508	.0508	.0635
25			.0813	.0813	.0889

Examples: Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al, (with the exception of β Ti)

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SMM (ft/min)			125	125	125
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3			.0076	.0076	.0102
6			.0203	.0203	.0254
10			.0254	.0254	.0381
12			.0381	.0381	.0508
20			.0508	.0508	.0635
25			.0813	.0813	.0889

Examples: Ti Grade 1, Ti Grade 2, Ti Grade 3,Ti Grade 4, Ti Grade 7, Ti Grade 12

MMPT (mm/tooth)