

3400 HARMON-I-CUT - IMPERIAL



3400 Series Harmon-i-cut End Mill is designed to maximize tool life and optimize metal removal rates.

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.

	Cast Iron					Hardened Steels > 48RC					Steels				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	250	250	250	525	525	100	100	150	300	300	200	200	300	600	600
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
1/8"	.0005	.0007	.0005	.0005	.0007	.0002	.0006	.0002	.0002	.0006	.0002	.0007	.0002	.0002	.0007
1/4"	.0010	.0012	.0010	.0010	.0012	.0008	.0012	.0008	.0008	.0012	.0010	.0014	.0010	.0010	.0014
3/8"	.0020	.0020	.0020	.0020	.0020	.0012	.0018	.0012	.0012	.0018	.0020	.0021	.0020	.0020	.0021
1/2"	.0025	.0028	.0025	.0025	.0028	.0020	.0025	.0020	.0020	.0025	.0025	.0028	.0025	.0025	.0028
3/4"	.0030	.0035	.0030	.0030	.0035	.0025	.0035	.0025	.0025	.0035	.0030	.0035	.0030	.0030	.0035
1"	.0035	.0045	.0035	.0035	.0045	.0035	.0040	.0035	.0035	.0040	.0035	.0040	.0035	.0035	.0040
	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
SFM (ft/min)	200	200	250	300	300	75	75	75	125	125	100	100	125	200	200
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
1/8"	.0002	.0007	.0002	.0002	.0007	.0002	.0003	.0002	.0002	.0003	.0002	.0004	.0002	.0002	.0004
1/4"	.0008	.0014	.0008	.0008	.0014	.0010	.0010	.0010	.0010	.0010	.0012	.0015	.0012	.0012	.0015
3/8"	.0019	.0021	.0019	.0019	.0021	.0013	.0015	.0013	.0013	.0015	.0020	.0025	.0020	.0020	.0025
1/2"	.0025	.0028	.0025	.0025	.0028	.0016	.0020	.0016	.0016	.0020	.0025	.0035	.0025	.0025	.0035
3/4"	.0029	.0035	.0029	.0029	.0035	.0022	.0025	.0022	.0022	.0025	.0032	.0045	.0032	.0032	.0045
1"	.0033	.0040	.0033	.0033	.0040	.0024	.0030	.0024	.0024	.0030	.0040	.0050	.0040	.0040	.0050

FULLERTON®
SPEEDS / FEEDS

IPT (in/tooth)

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3400 HARMON-I-CUT - METRIC



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SPEEDS / FEEDS

	Cast Iron					Hardened Steels > 48 RC					Steels				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	76	76	76	160	160	30	30	45	91	91	60	60	91	182	182
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	.0127	.0178	.0127	.0127	.0178	.0051	.0152	.0051	.0051	.0152	.0051	.0178	.0051	.0051	.0178
6	.0254	.0305	.0254	.0254	.0305	.0203	.0305	.0203	.0203	.0305	.0254	.0356	.0254	.0254	.0356
10	.0508	.0508	.0508	.0508	.0508	.0305	.0457	.0305	.0305	.0457	.0508	.0533	.0508	.0508	.0533
12	.0635	.0711	.0635	.0635	.0711	.0508	.0635	.0508	.0508	.0635	.0635	.0711	.0635	.0635	.0711
20	.0762	.0889	.0762	.0762	.0889	.0635	.0889	.0635	.0635	.0889	.0762	.0889	.0762	.0762	.0889
25	.0889	.1143	.0889	.0889	.1143	.0889	.1016	.0889	.0889	.1016	.0889	.1016	.0889	.0889	.1016
	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
SMM (m/min)	60	60	76	91	91	22	22	22	38	38	30	30	38	60	60
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	.0051	.0178	.0051	.0051	.0178	.0051	.0076	.0051	.0051	.0076	.0051	.0102	.0051	.0051	.0102
6	.0203	.0356	.0203	.0203	.0356	.0254	.0254	.0254	.0254	.0254	.0305	.0381	.0305	.0305	.0381
10	.0483	.0533	.0483	.0483	.0533	.0330	.0381	.0330	.0330	.0381	.0508	.0635	.0508	.0508	.0635
12	.0635	.0711	.0635	.0635	.0711	.0406	.0508	.0406	.0406	.0508	.0635	.0889	.0635	.0635	.0889
20	.0737	.0889	.0737	.0737	.0889	.0559	.0635	.0559	.0559	.0635	.0813	.1143	.0813	.0813	.1143