3500 FURY - IMPERIAL

FULLERTON® SPEEDS / FEEDS

3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and 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.

	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
SFM (ft/min)	500	500	500	525	525	100	100	125	170	170	500	500	500	800	800
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”	.0005	.0007	.0005	.0005	.0007	.0006	.0007	.0006	.0006	.0007	.0007	.0008	.0005	.0005	.0010
1/4”	.0010	.0012	.0010	.0010	.0012	.0012	.0014	.0012	.0012	.0014	.0014	.0014	.0010	.0010	.0015
3/8”	.0020	.0020	.0020	.0020	.0020	.0018	.0020	.0018	.0018	.0020	.0020	.0026	.0020	.0020	.0026
1/2”	.0025	.0028	.0025	.0025	.0028	.0020	.0022	.0020	.0020	.0022	.0026	.0030	.0025	.0025	.0030
3/4”	.0030	.0035	.0030	.0030	.0035	.0024	.0026	.0024	.0024	.0026	.0033	.0033	.0030	.0030	.0033
1”	.0035	.0045	.0035	.0035	.0045	.0025	.0027	.0025	.0025	.0027	.0039	.0039	.0040	.0040	.0045

	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)	325	325	350	500	500	90	90	110	170	170	200	200	240	300	300
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”	.0004	.0007	.0007	.0007	.0010	.0004	.0005	.0004	.0004	.0008	.0004	.0005	.0004	.0004	.0010
1/4”	.0010	.0010	.0013	.0015	.0015	.0008	.0010	.0008	.0008	.0010	.0008	.0010	.0008	.0008	.0018
3/8”	.0013	.0012	.0020	.0024	.0026	.0013	.0015	.0013	.0013	.0020	.0012	.0015	.0012	.0012	.0025
1/2”	.0015	.0013	.0022	.0026	.0028	.0019	.0020	.0019	.0019	.0025	.0016	.0018	.0016	.0016	.0035
3/4”	.0018	.0015	.0030	.0028	.0032	.0025	.0028	.0025	.0025	.0040	.0020	.0022	.0020	.0020	.0045
1”	.0020	.0016	.0035	.0030	.0035	.0027	.0030	.0027	.0027	.0045	.0028	.0030	.0028	.0028	.0050

IPT (in/tooth)

3500 FURY - METRIC

3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and titanium.

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FULLERTON® 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)	160	160	160	160	160	30	30	38	51	51	152	152	152	243	243
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	.0127	.0178	.0127	.0127	.0178	.0152	.0178	.0152	.0152	.0178	.0178	.0203	.0127	.0127	.0254
6	.0254	.0305	.0254	.0254	.0305	.0305	.0356	.0305	.0305	.0356	.0356	.0356	.0254	.0254	.0381
10	.0508	.0508	.0508	.0508	.0508	.0457	.0508	.0457	.0457	.0508	.0508	.0660	.0508	.0508	.0660
12	.0635	.0711	.0635	.0635	.0711	.0508	.0559	.0508	.0508	.0559	.0660	.0762	.0635	.0635	.0762
20	.0762	.0889	.0762	.0762	.0889	.0610	.0660	.0610	.0610	.0660	.0838	.0838	.0762	.0762	.0838
25	.0889	.1143	.0889	.0889	.1143	.0635	.0686	.0635	.0635	.0686	.0991	.0991	.1016	.1016	.1143

	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)	99	99	106	152	152	27	27	33	51	51	60	60	73	91	91
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	.0102	.0178	.0178	.0178	.0254	.0102	.0127	.0102	.0102	.0203	.0102	.0127	.0102	.0102	.0254
6	.0254	.0254	.0330	.0381	.0381	.0203	.0254	.0203	.0203	.0254	.0203	.0254	.0203	.0203	.0457
10	.0330	.0305	.0508	.0610	.0660	.0330	.0381	.0330	.0330	.0508	.0305	.0381	.0305	.0305	.0635
12	.0381	.0330	.0559	.0660	.0711	.0483	.0508	.0483	.0483	.0635	.0406	.0457	.0406	.0406	.0889
20	.0457	.0381	.0762	.0711	.0813	.0635	.0711	.0635	.0635	.1016	.0508	.0559	.0508	.0508	.1143
25	.0508	.0406	.0889	.0762	.0889	.0686	.0762	.0686	.0686	.1143	.0711	.0762	.0711	.0711	.1270

MMPT (mm/tooth)