

3505 FURY VICOR - IMPERIAL



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

Not Recommended for Graphite, Cast Iron, Hardened Steels > 48RC, Steels, Stainless Steels, Super Alloys (Nickel based, Inconel), or Titanium. Plastics 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

	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)	250	250	250	525	525	100	100	125	170	170	200	200	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	.0009	.0007	.0007	.0009
1/4"	.0010	.0012	.0010	.0010	.0012	.0012	.0014	.0012	.0012	.0014	.0015	.0018	.0015	.0015	.0018
3/8"	.0020	.0020	.0020	.0020	.0020	.0018	.0020	.0018	.0018	.0020	.0020	.0022	.0020	.0020	.0022
1/2"	.0025	.0028	.0025	.0025	.0028	.0020	.0022	.0020	.0020	.0022	.0022	.0024	.0022	.0022	.0024
3/4"	.0030	.0035	.0030	.0030	.0035	.0024	.0026	.0024	.0024	.0026	.0026	.0028	.0026	.0026	.0028
1"	.0035	.0045	.0035	.0035	.0045	.0025	.0027	.0025	.0025	.0027	.0028	.0030	.0028	.0028	.0030

	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)	220	220	350	500	500	40	40	60	170	170	60	60	100	500	500
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)

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3505 FURY VICOR - 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)	76	76	76	160	160	30	30	38	51	51	60	60	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	114.3	160.02	.0127	.0178	.0127	36.576	51.816	.0152	.0178	.0152	.0178	.0229	.0178	.0178	.0229
6	114.3	160.02	.0254	.0305	.0254	36.576	51.816	.0305	.0356	.0305	.0381	.0457	.0381	.0381	.0457
10	114.3	160.02	.0508	.0508	.0508	36.576	51.816	.0457	.0508	.0457	.0508	.0559	.0508	.0508	.0559
12	114.3	160.02	.0635	.0711	.0635	36.576	51.816	.0508	.0559	.0508	.0559	.0610	.0559	.0559	.0610
20	114.3	160.02	.0762	.0889	.0762	36.576	51.816	.0610	.0660	.0610	.0660	.0711	.0660	.0660	.0711
25	114.3	160.02	.0889	.1143	.0889	36.576	51.816	.0635	.0686	.0635	.0711	.0762	.0711	.0711	.0762
	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)	67	67	106	152	152	12	12	18	51	51	18	18	30	152	152
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