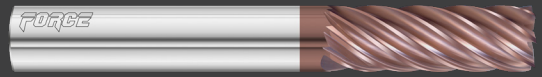
3600 FORCE - IMPERIAL



FULLERTON®

SPEEDS / FEEDS

3600 Series Force End Mill designed for optimal performance in high spindle speed and feed rates.

Not Recommended for Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, Graphite, or Cast Iron. High Si Aluminum Recommended in Unique Situations.

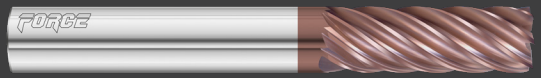
The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

	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	525	525			120	170	170			200	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	.0005	.0007			.0006	.0006	.0007			.0007	.0007	.0009
1/4”			.0010	.0010	.0012			.0012	.0012	.0014			.0015	.0015	.0018
3/8”			.0020	.0020	.0020			.0018	.0018	.0020			.0020	.0020	.0022
1/2”			.0025	.0025	.0028			.0020	.0020	.0022			.0022	.0022	.0024
3/4”			.0030	.0030	.0035			.0024	.0024	.0026			.0026	.0026	.0028
1”			.0035	.0035	.0045			.0025	.0025	.0027			.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	500	500			110	170	170			60	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”			.0007	.0007	.0010			.0004	.0004	.0008			.0004	.0004	.0010
1/4”			.0013	.0015	.0015			.0008	.0008	.0010			.0008	.0008	.0018
3/8”			.0020	.0024	.0026			.0013	.0013	.0020			.0012	.0012	.0025
1/2”			.0022	.0026	.0028			.0019	.0019	.0025			.0016	.0016	.0035
3/4”			.0030	.0028	.0032			.0025	.0025	.0040			.0020	.0020	.0045
1”			.0035	.0030	.0035			.0027	.0027	.0045			.0028	.0028	.0050

IPT (in/tooth)

3600 FORCE - METRIC



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	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	160	160			36	51	51			60	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	.0127	.0178	-	-	.0152	.0152	.0178	-	-	.0178	.0178	.0229
6	-	-	.0254	.0254	.0305	-	-	.0305	.0305	.0356	-	-	.0381	.0381	.0457
10	-	-	.0508	.0508	.0508	-	-	.0457	.0457	.0508	-	-	.0508	.0508	.0559
12	-	-	.0635	.0635	.0711	-	-	.0508	.0508	.0559	-	-	.0559	.0559	.0610
20	-	-	.0762	.0762	.0889	-	-	.0610	.0610	.0660	-	-	.0660	.0660	.0711
25	-	-	.0889	.0889	.1143	-	-	.0635	.0635	.0686	-	-	.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	152	152			33	51	51			18	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	-	-	.0178	.0178	.0254	-	-	.0102	.0102	.0203	-	-	.0102	.0102	.0254
6	-	-	.0330	.0381	.0381	-	-	.0203	.0203	.0254	-	-	.0203	.0203	.0457
10	-	-	.0508	.0610	.0660	-	-	.0330	.0330	.0508	-	-	.0305	.0305	.0635
12	-	-	.0559	.0660	.0711	-	-	.0483	.0483	.0635	-	-	.0406	.0406	.0889
20	-	-	.0762	.0711	.0813	-	-	.0635	.0635	.1016	-	-	.0508	.0508	.1143
25	-	-	.0889	.0762	.0889	-	-	.0686	.0686	.1143	-	-	.0711	.0711	.1270

MMPT (mm/tooth)