

3810 DREAM - IMPERIAL



3810 Series Dream End Mill is designed for high speed profiling of Titanium with superior wall finishes.

Not Recommended High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, Graphite, Cast Iron, Hardened Steels > 48RC, Steels, Stainless Steels, or Super Alloys (Nickel based, Inconel).

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

	Titanium (200-600) SFM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	-	-	-	-	-
1/4"	-	-	-	-	-
3/8"	-	-	-	-	-
1/2"	-	-	-	-	-
3/4"	.0030	-	-	.0040	.0040
1"	.0040	-	-	.0050	.0050

3810 DREAM - METRIC



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FULLERTON®
SPEEDS / FEEDS

	Titanium (60-182) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	-	-	-	-	-
6	-	-	-	-	-
10	-	-	-	-	-
12	-	-	-	-	-
20	.0762	-	-	.1016	.1016
25	.1016	-	-	.1270	.1270