FULLERTON

SPEEDS & FEEDS - IMPERIAL UNITS
3815 AlumaMill End Mill

AlumaMill™



3815 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

	High Si Aluminum (>10%) (500-1000) SFM (ft/min)					Low Si Aluminum (<10%) (1500-2000) SFM (ft/min)					Composites (400-800) SFM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
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”	.0010	.0011	.0010	.0011	.0010	.0010	.0012	.0010	.0012	.0010	.0030	.0035	.0030	.0035	.0030
1/4”	.0030	.0032	.0030	.0032	.0030	.0030	.0033	.0030	.0033	.0030	.0060	.0065	.0060	.0065	.0060
3/8”	.0045	.0050	.0045	.0050	.0045	.0045	.0050	.0045	.0050	.0045	.0080	.0085	.0080	.0085	.0080
1/2”	.0060	.0065	.0060	.0065	.0060	.0060	.0070	.0060	.0070	.0060	.0100	.0105	.0100	.0105	.0100
3/4”	.0080	.0090	.0080	.0090	.0080	.0080	.0095	.0080	.0095	.0080	.0140	.0145	.0140	.0145	.0140
1”	.0100	.0110	.0100	.0110	.0100	.0100	.0110	.0100	.0110	.0100	.0180	.0185	.0180	.0185	.0180

	Plastics (1000-1400) SFM (ft/min)					Brass & Copper (800-1000) SFM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (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
1/8”	.0030	.0035	.0030	.0035	.0030	.0010	.0015	.0010	.0015	.0010
1/4”	.0060	.0065	.0060	.0065	.0060	.0020	.0025	.0020	.0025	.0020
3/8”	.0080	.0085	.0080	.0085	.0080	.0025	.0030	.0025	.0030	.0025
1/2”	.0100	.0105	.0100	.0105	.0100	.0030	.0035	.0030	.0035	.0030
3/4”	.0140	.0145	.0140	.0145	.0140	.0040	.0045	.0040	.0045	.0040
1”	.0180	.0185	.0180	.0185	.0180	.0050	.0055	.0050	.0055	.0050

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

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 analyizing the rigidity of the process.
Then cautiously progress incrementally to achieve optimum performance.

Contact Engineering at 800.248.8315 or engineering@fullertontool.com

FULLERTON

SPEEDS & FEEDS - METRIC UNITS
3815 AlumaMill End Mill

AlumaMill™



3815 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

	High Si Aluminum (>10%) (152-304) SMM (m/min)					Low Si Aluminum (<10%) (457-609) SMM (m/min)					Composites (121-243) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
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	.0254	.0279	.0254	.0279	.0254	.0254	.0305	.0254	.0305	.0254	.0762	.0889	.0762	.0889	.0762
6	.0762	.0813	.0762	.0813	.0762	.0762	.0838	.0762	.0838	.0762	.1524	.1651	.1524	.1651	.1524
10	.1143	.1270	.1143	.1270	.1143	.1143	.1270	.1143	.1270	.1143	.2032	.2159	.2032	.2159	.2032
12	.1524	.1651	.1524	.1651	.1524	.1524	.1778	.1524	.1778	.1524	.2540	.2667	.2540	.2667	.2540
20	.2032	.2286	.2032	.2286	.2032	.2032	.2413	.2032	.2413	.2032	.3556	.3683	.3556	.3683	.3556
25	.2540	.2794	.2540	.2794	.2540	.2540	.2794	.2540	.2794	.2540	.4572	.4699	.4572	.4699	.4572

	Plastics (304-426) SMM (m/min)					Brass & Copper (243-304) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (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
3	.0762	.0889	.0762	.0889	.0762	.0254	.0381	.0254	.0381	.0254
6	.1524	.1651	.1524	.1651	.1524	.0508	.0635	.0508	.0635	.0508
10	.2032	.2159	.2032	.2159	.2032	.0635	.0762	.0635	.0762	.0635
12	.2540	.2667	.2540	.2667	.2540	.0762	.0889	.0762	.0889	.0762
20	.3556	.3683	.3556	.3683	.3556	.1016	.1143	.1016	.1143	.1016
25	.4572	.4699	.4572	.4699	.4572	.1270	.1397	.1270	.1397	.1270

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

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 analyizing the rigidity of the process.
Then cautiously progress incrementally to achieve optimum performance.

Contact Engineering at 800.248.8315 or engineering@fullertontool.com