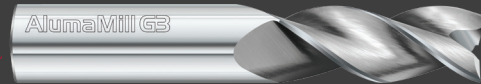


3833 ALUMAMILL G3 - IMPERIAL **AlumaMill G3**



3833 Series AlumaMill G3 End Mill generates superior wall finishes.

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

	High Si Aluminum (>10%)					Low Si Aluminum (<10%)				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	800	800	800	800	800	1,500	1,500	2,000	2,500	2,500
Axial Depth	< (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
1/8"	.0010	.0020	.0010	.0010	.0030	.0010	.0020	.0010	.0010	.0030
1/4"	.0015	.0020	.0020	.0020	.0035	.0015	.0020	.0020	.0020	.0035
3/8"	.0035	.0040	.0045	.0045	.0055	.0035	.0040	.0045	.0045	.0055
1/2"	.0050	.0050	.0055	.0055	.0065	.0050	.0050	.0055	.0055	.0065
3/4"	.0060	.0085	.0080	.0080	.0090	.0060	.0085	.0080	.0080	.0090
1"	.0080	.0100	.0100	.0100	.0110	.0080	.0100	.0100	.0100	.0110

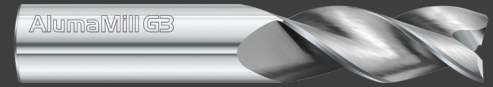
	Plastics Recommended in Unique Situations					Brass & Copper				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	1,000	1,000	1,200	1,400	1,400	800	800	800	800	800
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (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
1/8"	.0030	.0035	.0030	.0030	.0035	.0030	.0035	.0020	.0020	.0025
1/4"	.0060	.0065	.0060	.0060	.0065	.0040	.0045	.0030	.0030	.0035
3/8"	.0080	.0085	.0080	.0080	.0085	.0050	.0055	.0040	.0040	.0045
1/2"	.0100	.0105	.0100	.0100	.0105	.0060	.0065	.0045	.0045	.0055
3/4"	.0140	.0145	.0140	.0140	.0145	.0080	.0085	.0060	.0060	.0075
1"	.0180	.0185	.0180	.0180	.0185	.0100	.0110	.0070	.0070	.0085

IPT (in/tooth)

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3833 ALUMAMILL G3 - METRIC

AlumaMill G3



3833 Series AlumaMill G3 End Mill generates superior wall finishes.

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 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

	High Si Aluminum (>10%)					Low Si Aluminum (<10%)				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	243	243	243	243	243	1500	1500	2000	2500	2500
Axial Depth	< (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
3	.0254	.0508	.0254	.0254	.0762	.0010	.0020	.0010	.0010	.0030
6	.0381	.0508	.0508	.0508	.0889	.0015	.0020	.0020	.0020	.0035
10	.0889	.1016	.1143	.1143	.1397	.0035	.0040	.0045	.0045	.0055
12	.1270	.1270	.1397	.1397	.1651	.0050	.0050	.0055	.0055	.0065
20	.1524	.2159	.2032	.2032	.2286	.0060	.0085	.0080	.0080	.0090
25	.2032	.2540	.2540	.2540	.2794	.0080	.0100	.0100	.0100	.0110
	Plastics Recommended in Unique Situations					Brass & Copper				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	304	304	365	426	426	243	243	243	243	243
Axial Depth	< (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
3	.0762	.0889	.0762	.0762	.0889	.0762	.0889	.0508	.0508	.0635
6	.1524	.1651	.1524	.1524	.1651	.1016	.1143	.0762	.0762	.0889
10	.2032	.2159	.2032	.2032	.2159	.1270	.1397	.1016	.1016	.1143
12	.2540	.2667	.2540	.2540	.2667	.1524	.1651	.1143	.1143	.1397
20	.3556	.3683	.3556	.3556	.3683	.2032	.2159	.1524	.1524	.1905
25	.4572	.4699	.4572	.4572	.4699	.2540	.2794	.1778	.1778	.2159