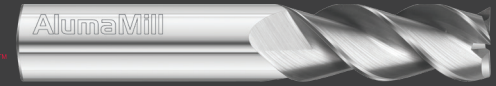


3835 ALUMAMILL - IMPERIAL

AlumaMill



3835 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

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%) (800-1500) SFM (ft/min)					Low Si Aluminum (<10%) (1500-2500) SFM (ft/min)				
	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish
SFM (ft/min)	800	800	900	1,500	1,500	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	.0020	.0020	.0030	.0010	.0020	.0010	.0010	.0030
1/4"	.0020	.0030	.0030	.0030	.0040	.0015	.0020	.0020	.0020	.0035
3/8"	.0030	.0040	.0040	.0040	.0050	.0035	.0040	.0045	.0045	.0055
1/2"	.0040	.0060	.0050	.0050	.0065	.0050	.0050	.0055	.0055	.0065
3/4"	.0070	.0080	.0065	.0065	.0075	.0060	.0085	.0080	.0080	.0090
1"	.0080	.0100	.0075	.0075	.0085	.0080	.0100	.0110	.0110	.0110
	Plastics Recommended in Unique Situations					Brass & Copper (600-900) SFM (ft/min)				
	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	1,000	1,500	1,500
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"	.0030	.0035	.0030	.0030	.0035	.0015	.0020	.0015	.0015	.0020
1/4"	.0060	.0065	.0060	.0060	.0065	.0020	.0025	.0020	.0020	.0025
3/8"	.0080	.0085	.0080	.0080	.0085	.0025	.0030	.0025	.0025	.0030
1/2"	.0100	.0105	.0100	.0100	.0105	.0035	.0040	.0040	.0040	.0045
3/4"	.0140	.0145	.0140	.0140	.0145	.0050	.0055	.0055	.0055	.0070
1"	.0180	.0185	.0180	.0180	.0185	.0060	.0065	.0060	.0060	.0075

3835 ALUMAMILL - METRIC

AlumaMill



3835 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

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%) (243-457) SMM (m/min)					Low Si Aluminum (<10%) (762) SMM (m/min)				
	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish
SMM (m/min)	243	243	274	457	457	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	.0508	.0508	.0762	.0254	.0508	.0254	.0254	.0762
6	.0508	.0762	.0762	.0762	.1016	.0381	.0508	.0508	.0508	.0889
10	.0762	.1016	.1016	.1016	.1270	.0889	.1016	.1143	.1143	.1397
12	.1016	.1524	.1270	.1270	.1651	.1270	.1270	.1397	.1397	.1651
20	.1778	.2032	.1651	.1651	.1905	.1524	.2159	.2032	.2032	.2286
25	.2032	.2540	.1905	.1905	.2159	.2032	.2540	.2794	.2794	.2794
	Plastics Recommended in Unique Situations					Brass & Copper (182-274) SMM (m/min)				
	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish
SMM (m/min)	304	304	365	426	426	243	243	304	457	457
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	.0381	.0508	.0381	.0381	.0508
6	.1524	.1651	.1524	.1524	.1651	.0508	.0635	.0508	.0508	.0635
10	.2032	.2159	.2032	.2032	.2159	.0635	.0762	.0635	.0635	.0762
12	.2540	.2667	.2540	.2540	.2667	.0889	.1016	.1016	.1016	.1143
20	.3556	.3683	.3556	.3556	.3683	.1270	.1397	.1397	.1397	.1778
25	.4572	.4699	.4572	.4572	.4699	.1524	.1651	.1524	.1524	.1905