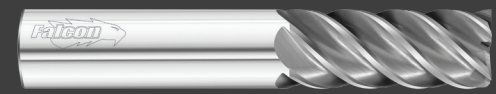


# 3845 FALCON - IMPERIAL



3845 Series Falcon End Mill allows for superior part finishes at extraordinary feed rates.

**Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, or Graphite.**

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**

	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)				500	520				275	300				400	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"				.0008	.0009				.0006	.0007				.0010	.0009
1/4"				.0016	.0018				.0013	.0014				.0017	.0018
3/8"				.0025	.0027				.0018	.0020				.0023	.0027
1/2"				.0030	.0035				.0024	.0026				.0033	.0035
3/4"				.0035	.0043				.0030	.0033				.0040	.0043
1"				.0040	.0050				.0035	.0039				.0045	.0050
	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)	260	300	325	350	350				125	125				250	260
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"	.0006	.0007	.0006	.0006	.0007				.0005	.0006				.0005	.0006
1/4"	.0010	.0015	.0010	.0010	.0015				.0010	.0012				.0010	.0012
3/8"	.0012	.0023	.0012	.0012	.0023				.0012	.0018				.0012	.0018
1/2"	.0020	.0029	.0020	.0020	.0029				.0018	.0023				.0018	.0023
3/4"	.0030	.0038	.0030	.0030	.0038				.0025	.0030				.0025	.0030
1"	.0040	.0046	.0040	.0040	.0046				.0030	.0036				.0030	.0036

IPT (in/tooth)

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# 3845 FALCON - METRIC



3845 Series Falcon End Mill allows for superior part finishes at extraordinary feed rates.

**Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, or Graphite.**

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**

	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)				152	158				83	91				121	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				.0203	.0229				.0152	.0178				.0254	.0229
6				.0406	.0457				.0330	.0356				.0432	.0457
10				.0635	.0686				.0457	.0508				.0584	.0686
12				.0762	.0889				.0610	.0660				.0838	.0889
20				.0889	.1092				.0762	.0838				.1016	.1092
25				.1016	.1270				.0889	.0991				.1143	.1270
	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)	79	91	99	106	106				38	38				76	79
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	.0152	.0178	.0152	.0152	.0178				.0127	.0152				.0127	.0152
6	.0254	.0381	.0254	.0254	.0381				.0254	.0305				.0254	.0305
10	.0305	.0584	.0305	.0305	.0584				.0305	.0457				.0305	.0457
12	.0508	.0737	.0508	.0508	.0737				.0457	.0584				.0457	.0584
20	.0762	.0965	.0762	.0762	.0965				.0635	.0762				.0635	.0762
25	.1016	.1168	.1016	.1016	.1168				.0762	.0914				.0762	.0914