FULLERTON

SPEEDS & FEEDS - IMPERIAL UNITS
3990/3995 Hogger End Mill

Hogger



3990 Series Hogger End Mill is designed as a rougher for high volume material removal.

	Hi Si Aluminum (>10%) (200-600) SFM (ft/min)					Low Si Aluminum (<10%) (300-800) SFM (ft/min)					Brass & Copper (200-0) 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"	.0004	.0001	.0004	-	.0004	.0004	.0001	.0004	-	.0004	.0004	.0001	.0004	-	.0004
1/4"	.0006	.0002	.0006	-	.0006	.0006	.0002	.0006	-	.0006	.0006	.0002	.0006	-	.0006
3/8"	.0008	.0004	.0008	-	.0008	.0008	.0004	.0008	-	.0008	.0008	.0004	.0008	-	.0008
1/2"	.0010	.0006	.0010	-	.0010	.0010	.0006	.0010	-	.0010	.0010	.0006	.0010	-	.0010
3/4"	.0012	.0008	.0012	-	.0012	.0012	.0008	.0012	-	.0012	.0012	.0008	.0012	-	.0012
1"	.0015	.0010	.0015	-	.0015	.0015	.0010	.0015	-	.0015	.0015	.0010	.0015	-	.0015

	Cast Iron (400-600) SFM (ft/min)					Steels (100-300) SFM (ft/min)					Stainless Steels (100-250) 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"	.0008	-	-	-	-	.0004	.0001	.0004	-	.0004	.0004	.0001	.0004	-	.0004
1/4"	.0015	-	-	-	-	.0006	.0002	.0006	-	.0006	.0006	.0002	.0006	-	.0006
3/8"	.0023	-	-	-	-	.0008	.0004	.0008	-	.0008	.0008	.0004	.0008	-	.0008
1/2"	.0030	-	-	-	-	.0010	.0006	.0010	-	.0010	.0010	.0006	.0010	-	.0010
3/4"	.0045	-	-	-	-	.0012	.0008	.0012	-	.0012	.0012	.0008	.0012	-	.0012
1"	.0061	-	-	-	-	.0015	.0010	.0015	-	.0015	.0015	.0010	.0015	-	.0015

	Super Alloys (Nickel Based, Inconel) (100-250) SFM (m/min)					Titanium (100-250) SFM (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
1/8"	.1290	-	-	-	-	.1290	-	-	-	-
1/4"	.1935	-	-	-	-	.1935	-	-	-	-
3/8"	.3226	-	-	-	-	.3226	-	-	-	-
1/2"	.4516	-	-	-	-	.4516	-	-	-	-
3/4"	.6452	-	-	-	-	.6452	-	-	-	-
1"	.8387	-	-	-	-	.8387	-	-	-	-

Not Recommended for Composites, Plastics, Graphite, or Hardened Steels > 48 RC.

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
3990/3995 Hogger End Mill

Hogger



3990 Series Hogger End Mill is designed as a rougher for high volume material removal.

	Hi Si Aluminum (>10%) (60-182) SMM (m/min)					Low Si Aluminum (<10%) (91-243) SMM (m/min)					Brass & Copper (60-182) 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	.2581	.0645	.2581	-	.2581	.0102	.0025	.0102	-	.0102	.2581	.0645	.2581	-	.2581
6	.3871	.1290	.3871	-	.3871	.0152	.0051	.0152	-	.0152	.3871	.1290	.3871	-	.3871
10	.5161	.2581	.5161	-	.5161	.0203	.0102	.0203	-	.0203	.5161	.2581	.5161	-	.5161
12	.6452	.3871	.6452	-	.6452	.0254	.0152	.0254	-	.0254	.6452	.3871	.6452	-	.6452
20	.7742	.5161	.7742	-	.7742	.0305	.0203	.0305	-	.0305	.7742	.5161	.7742	-	.7742
25	.9677	.6452	.9677	-	.9677	.0381	.0254	.0381	-	.0381	.9677	.6452	.9677	-	.9677

	Cast Iron (121-182)SMM (m/min)					Steels (30-91) SMM (m/min)					Stainless Steels (30-76) 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	.5161	-	-	-	-	.2581	.0645	.2581	-	.2581	.2581	.0645	.2581	-	.2581
6	.9677	-	-	-	-	.3871	.1290	.3871	-	.3871	.3871	.1290	.3871	-	.3871
10	1.4839	-	-	-	-	.5161	.2581	.5161	-	.5161	.5161	.2581	.5161	-	.5161
12	1.9355	-	-	-	-	.6452	.3871	.6452	-	.6452	.6452	.3871	.6452	-	.6452
20	2.9032	-	-	-	-	.7742	.5161	.7742	-	.7742	.7742	.5161	.7742	-	.7742
25	3.9355	-	-	-	-	.9677	.6452	.9677	-	.9677	.9677	.6452	.9677	-	.9677

	Super Alloys (Nickel Based, Inconel) (30-76) SMM (m/min)					Titanium (30-76) 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	.1290	-	-	-	-	.1290	-	-	-	-
6	.1935	-	-	-	-	.1935	-	-	-	-
10	.3226	-	-	-	-	.3226	-	-	-	-
12	.4516	-	-	-	-	.4516	-	-	-	-
20	.6452	-	-	-	-	.6452	-	-	-	-
25	.8387	-	-	-	-	.8387	-	-	-	-

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