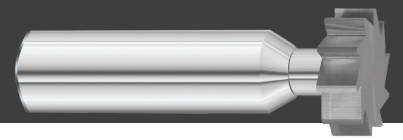


4375 KEYSEAT CUTTER



FULLERTON[®] S P E E D S / F E E D S

Straight Flute | Solid Head

Diameter	# of Teeth	Low Si Aluminum <10% (1200-1500) SFM (ft/min)	High Si Aluminum >10% (750-1000) SFM (ft/min)	Composites (0-0) SFM (ft/min)	Plastics (1500-2000) SFM (ft/min)	Brass & Copper (400-550) SFM (ft/min)	Graphite (0-0) SFM (ft/min)
		Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
3/8	8	.0013	.0016	-	.0013	.0018	-
1/2	10	.0012	.0014	-	.0012	.0014	-
5/8	10	.0012	.0013	-	.0011	.0013	-
3/4	10	.0011	.0013	-	.0011	.0013	-
7/8	12	.0009	.0011	-	.0009	.0011	-
1	12	.0012	.0014	-	.0012	.0013	-
1 1/8	14	.0010	.0012	-	.0009	.0011	-
1 1/4	14	.0010	.0011	-	.0009	.0010	-
1 1/2	16	.0008	.0009	-	.0007	.0008	-

Diameter	# of Teeth	Cast Iron (150-350) SFM (ft/min)	Hardened Steel >48 RC (60-140) SFM (ft/min)	Mild Steels <48 RC (150-400) SFM (ft/min)	Stainless Steels (75-175) SFM (ft/min)	Super Alloys (50-150) SFM (ft/min)	Titanium (75-200) SFM (ft/min)
		Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
3/8	8	.0023	.0061	.0029	.0021	.0027	.0026
1/2	10	.0017	.0045	.0021	.0016	.0018	.0018
5/8	10	.0015	.0039	.0018	.0014	.0014	.0014
3/4	10	.0013	.0035	.0016	.0013	.0012	.0012
7/8	12	.0011	.0030	.0014	.0011	.0010	.0010
1	12	.0013	.0035	.0016	.0013	.0012	.0011
1 1/8	14	.0011	.0027	.0011	.0011	.0008	.0008
1 1/4	14	.0009	.0025	.0010	.0009	.0008	.0008
1 1/2	16	.0008	.0019	.0007	.0007	.0007	.0007

IPT (in/tooth)

Diameter	# of Teeth	Low Si Aluminum <10% (365-457) SMM (m/min)	High Si Aluminum >10% (228-304) SMM (m/min)	Composites (0-0) SMM (m/min)	Plastics (457-609) SMM (m/min)	Brass & Copper (121-167) SMM (m/min)	Graphite (0-0) SMM (m/min)
		Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
10	8	.0325	.0407	-	.0332	.0452	-
12	10	.0305	.0343	-	.0296	.0366	-
15	10	.0293	.0332	-	.0286	.0342	-
20	10	.0280	.0320	-	.0278	.0321	-
22	12	.0235	.0270	-	.0232	.0269	-
25	12	.0300	.0345	-	.0300	.0338	-
28	14	.0248	.0293	-	.0240	.0278	-
31	14	.0242	.0284	-	.0228	.0260	-
38	16	.0204	.0224	-	.0190	.0215	-

Diameter	# of Teeth	Cast Iron (45-106) SMM (m/min)	Hardened Steel >48 RC (18-42) SMM (m/min)	Mild Steels <48 RC (45-121) SMM (m/min)	Stainless Steels (25-53) SMM (m/min)	Super Alloys (15-45) SMM (m/min)	Titanium (22-60) SMM (m/min)
		Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
10	8	.0582	.1558	.0727	.0540	.0686	.0665
12	10	.0437	.1140	.0532	.0406	.0460	.0455
15	10	.0374	.0987	.0457	.0356	.0364	.0361
20	10	.0332	.0887	.0399	.0332	.0315	.0296
22	12	.0280	.0754	.0345	.0283	.0255	.0251
25	12	.0332	.0887	.0399	.0328	.0302	.0286
28	14	.0272	.0680	.0285	.0267	.0214	.0214
31	14	.0237	.0643	.0254	.0230	.0212	.0213
38	16	.0192	.0490	.0187	.0178	.0166	.0187

MMPT (mm/tooth)

Not Recommended for Composites 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.