

# 5500 MATRIX - IMPERIAL



5500 Series EM-1 End Mills allow for high shear and low cutting forces that provide a clean edge without fibers.

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

	Carbon, Carbon Graphite, Unfilled Plastics				Composites				Fiber Reinforced Plastics				Green Ceramics, Green Carbide			
	Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)	
1/8"	1000	3200	.0030	.0060	700	2800	.0020	.0050	1000	2800	.0040	.0080	800	1600	.0020	.0050
3/16"	1000	2800	.0040	.0080	700	2800	.0030	.0070	1000	2800	.0050	.0100	800	1600	.0020	.0050
1/4"	1000	2800	.0080	.0130	700	2800	.0070	.0120	1000	2800	.0080	.0150	800	1600	.0040	.0070
5/16"	1000	2800	.0100	.0017	700	2800	.0100	.0150	1000	2800	.0100	.0150	800	1600	.0080	.0140
3/8"	1000	2800	.0100	.0180	700	2800	.0150	.0250	1000	3200	.0150	.0200	800	1600	.0080	.0180
1/2"	1000	2800	.0150	.0200	700	2800	.0200	.0400	1000	3200	.0150	.0250	800	1600	.0100	.0250

# 5500 MATRIX - METRIC



5500 Series EM-1 End Mills allow for high shear and low cutting forces that provide a clean edge without fibers.

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<sup>®</sup>**  
**SPEEDS / FEEDS**

	Carbon, Carbon Graphite, Unfilled Plastics				Composites				Fiber Reinforced Plastics				Green Ceramics, Green Carbide			
	Speed (SMM)		Feed (IPR)		Speed (SMM)		Feed (IPR)		Speed (SMM)		Feed (IPR)		Speed (SMM)		Feed (IPR)	
3.00	305	975	.076	.152	213	853	.051	.127	305	853	.102	.203	244	488	.051	.127
5.00	305	853	.102	.203	213	853	.076	.178	305	853	.127	.254	244	488	.051	.127
6.00	305	853	.203	.330	213	853	.178	.305	305	853	.203	.381	244	488	.102	.178
8.00	305	853	.254	.043	213	853	.254	.381	305	853	.254	.381	244	488	.203	.356
10.00	305	853	.254	.457	213	853	.381	.635	305	975	.381	.508	244	488	.203	.457
12.00	305	853	.381	.508	213	853	.508	1.016	305	975	.381	.635	244	488	.254	.635