SPEEDS & FEEDS - IMPERIAL UNITS
3500 Fury End Mill

3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and titanium.

	High Si Aluminum (>10%) Recommended in Unique Situations					Hardened Steels > 48 RC (120-170) SFM (ft/min)					Steels (200-800) 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"	-	-	-	-	-	.0006	.0007	.0006	.0007	.0006	.0007	.0009	.0007	.0009	.0007
1/4"	-	-	-	-	-	.0012	.0014	.0012	.0014	.0012	.0015	.0018	.0015	.0018	.0015
3/8"	-	-	-	-	-	.0018	.0020	.0018	.0020	.0018	.0020	.0022	.0020	.0022	.0020
1/2"	-	-	-	-	-	.0020	.0022	.0020	.0022	.0020	.0022	.0024	.0022	.0024	.0022
3/4"	-	-	-	-	-	.0024	.0026	.0024	.0026	.0024	.0026	.0028	.0026	.0028	.0026
1"	-	-	-	-	-	.0025	.0027	.0025	.0027	.0025	.0028	.0030	.0028	.0030	.0028

	Stainless Steels (220-500) SFM (ft/min)					Super Alloys (Nickel Based, Inconel) (20-170) SMM (ft/min)					Titanium (60-500) SMM (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	.0007	.0007	.0010	.0007	.0004	.0005	.0004	.0008	.0004	.0004	.0005	.0004	.0010	.0004
1/4"	.0010	.0010	.0013	.0015	.0015	.0008	.0010	.0008	.0010	.0008	.0008	.0010	.0008	.0018	.0008
3/8"	.0013	.0012	.0020	.0026	.0024	.0013	.0015	.0013	.0020	.0013	.0012	.0015	.0012	.0025	.0012
1/2"	.0015	.0013	.0022	.0028	.0026	.0019	.0020	.0019	.0025	.0019	.0016	.0018	.0016	.0035	.0016
3/4"	.0018	.0015	.0030	.0032	.0028	.0025	.0028	.0025	.0040	.0025	.0020	.0022	.0020	.0045	.0020
1"	.0020	.0016	.0035	.0035	.0030	.0027	.0030	.0027	.0045	.0027	.0028	.0030	.0028	.0050	.0028

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

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
3500 Fury End Mill

FURY

3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and titanium.

	High Si Aluminum (>10%) Recommended in Unique Situations					Hardened Steels > 48 RC (39-51) SMM (m/min)					Steels (91-182) 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	-	-	-	-	-	.0152	.0178	.0152	.0178	.0152	.0178	.0229	.0178	.0229	.0178
6	-	-	-	-	-	.0305	.0356	.0305	.0356	.0305	.0381	.0457	.0381	.0457	.0381
10	-	-	-	-	-	.0457	.0508	.0457	.0508	.0457	.0508	.0559	.0508	.0559	.0508
12	-	-	-	-	-	.0508	.0559	.0508	.0559	.0508	.0559	.0610	.0559	.0610	.0559
20	-	-	-	-	-	.0610	.0660	.0610	.0660	.0610	.0660	.0711	.0660	.0711	.0660
25	-	-	-	-	-	.0635	.0686	.0635	.0686	.0635	.0711	.0762	.0711	.0762	.0711

	Stainless Steels (76-91) SMM (m/min)					Super Alloys (Nickel Based, Inconel) (30-36) SMM (m/min)					Titanium (36-45) 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	.0102	.0178	.0178	.0254	.0178	.0102	.0127	.0102	.0203	.0102	.0102	.0127	.0102	.0254	.0102
6	.0254	.0254	.0330	.0381	.0381	.0203	.0254	.0203	.0254	.0203	.0203	.0254	.0203	.0457	.0203
10	.0330	.0305	.0508	.0660	.0610	.0330	.0381	.0330	.0508	.0330	.0305	.0381	.0305	.0635	.0305
12	.0381	.0330	.0559	.0711	.0660	.0483	.0508	.0483	.0635	.0483	.0406	.0457	.0406	.0889	.0406
20	.0457	.0381	.0762	.0813	.0711	.0635	.0711	.0635	.1016	.0635	.0508	.0559	.0508	.1143	.0508
25	.0508	.0406	.0889	.0889	.0762	.0686	.0762	.0686	.1143	.0686	.0711	.0762	.0711	.1270	.0711

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

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