



3600 Series Force End Mill designed for optimal performance in high spindle speed and feed rates.

	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	.0009	.0007
1/4"	-	-	-	-	-	-	-	.0012	.0014	.0012	-	-	.0015	.0018	.0015
3/8"	-	-	-	-	-	-	-	.0018	.0020	.0018	-	-	.0020	.0022	.0020
1/2"	-	-	-	-	-	-	-	.0020	.0022	.0020	-	-	.0022	.0024	.0022
3/4"	-	-	-	-	-	-	-	.0024	.0026	.0024	-	-	.0026	.0028	.0026
1"	-	-	-	-	-	-	-	.0025	.0027	.0025	-	-	.0028	.0030	.0028

IPT (in/tooth)

	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"	-	-	.0007	.0010	.0007	-	-	.0004	.0008	.0004	-	-	.0004	.0010	.0004
1/4"	-	-	.0013	.0015	.0015	-	-	.0008	.0010	.0008	-	-	.0008	.0018	.0008
3/8"	-	-	.0020	.0026	.0024	-	-	.0013	.0020	.0013	-	-	.0012	.0025	.0012
1/2"	-	-	.0022	.0028	.0026	-	-	.0019	.0025	.0019	-	-	.0016	.0035	.0016
3/4"	-	-	.0030	.0032	.0028	-	-	.0025	.0040	.0025	-	-	.0020	.0045	.0020
1"	-	-	.0035	.0035	.0030	-	-	.0027	.0045	.0027	-	-	.0028	.0050	.0028

IPT (in/tooth)

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

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.

Contact Engineering at 800.248.8315 or [engineering@fullertontool.com](mailto:engineering@fullertontool.com)

# FORCE



3600 Series Force End Mill designed for optimal performance in high spindle speed and feed rates.

	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	.0229	.0178
6	-	-	-	-	-	-	-	.0305	.0356	.0305	-	-	.0381	.0457	.0381
10	-	-	-	-	-	-	-	.0457	.0508	.0457	-	-	.0508	.0559	.0508
12	-	-	-	-	-	-	-	.0508	.0559	.0508	-	-	.0559	.0610	.0559
20	-	-	-	-	-	-	-	.0610	.0660	.0610	-	-	.0660	.0711	.0660
25	-	-	-	-	-	-	-	.0635	.0686	.0635	-	-	.0711	.0762	.0711

IPT (in/tooth)

	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	-	-	.0178	.0254	.0178	-	-	.0102	.0203	.0102	-	-	.0102	.0254	.0102
6	-	-	.0330	.0381	.0381	-	-	.0203	.0254	.0203	-	-	.0203	.0457	.0203
10	-	-	.0508	.0660	.0610	-	-	.0330	.0508	.0330	-	-	.0305	.0635	.0305
12	-	-	.0559	.0711	.0660	-	-	.0483	.0635	.0483	-	-	.0406	.0889	.0406
20	-	-	.0762	.0813	.0711	-	-	.0635	.1016	.0635	-	-	.0508	.1143	.0508
25	-	-	.0889	.0889	.0762	-	-	.0686	.1143	.0686	-	-	.0711	.1270	.0711

IPT (in/tooth)

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