



3800 Series Twister End Mill provides high shear and chip clearing benefits.

	Brass & Copper Recommended in Unique Situations					Hardened Steels > 48RC Recommended in Unique Situations					Stainless Steels Recommended in Unique Situations				
	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"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1/4"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3/8"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1/2"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3/4"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

IPT (in/tooth)

	Super Alloys (Nickel based, Inconel) (70-110) SFM (ft/min)					Titanium (150-325) SFM (ft/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"	.0003	.0005	.0003	.0005	.0003	.0003	.0006	.0003	.0006	.0003
1/4"	.0007	.0009	.0007	.0009	.0007	.0007	.0012	.0007	.0012	.0007
3/8"	.0011	.0014	.0011	.0014	.0011	.0011	.0017	.0011	.0017	.0011
1/2"	.0014	.0019	.0014	.0019	.0014	.0015	.0023	.0015	.0023	.0015
3/4"	.0022	.0028	.0022	.0028	.0022	.0022	.0034	.0022	.0034	.0022
1"	.0028	.0038	.0028	.0038	.0028	.0030	.0046	.0030	.0046	.0030

IPT (in/tooth)

Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Graphite, Cast Iron, or Steels.

Brass & Copper, Hardened Steels >48RC, and Stainless Steels 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



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	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	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
12	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
20	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

IPT (in/tooth)

	Super Alloys (Nickel based, Inconel) (21-33) SMM (m/min)					Titanium (45-99) 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	.0076	.0127	.0076	.0127	.0076	.0076	.0152	.0076	.0152	.0076
6	.0178	.0229	.0178	.0229	.0178	.0178	.0305	.0178	.0305	.0178
10	.0279	.0356	.0279	.0356	.0279	.0279	.0432	.0279	.0432	.0279
12	.0356	.0483	.0356	.0483	.0356	.0381	.0584	.0381	.0584	.0381
20	.0559	.0711	.0559	.0711	.0559	.0559	.0864	.0559	.0864	.0559
25	.0711	.0965	.0711	.0965	.0711	.0762	.1168	.0762	.1168	.0762

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