SPEEDS & FEEDS - IMPERIAL UNITS
3825 AlumaMill End Mill

AlumaMill™

3825 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

	High Si Aluminum (>10%) (800-1000) SFM (ft/min)					Low Si Aluminum (<10%) (1300-2500) SFM (ft/min)					Composites (400-800) 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”	.0010	.0011	.0010	.0011	.0010	.0010	.0012	.0010	.0012	.0010	.0030	.0035	.0030	.0035	.0030
1/4”	.0030	.0032	.0025	.0035	.0025	.0030	.0033	.0030	.0033	.0030	.0060	.0065	.0060	.0065	.0060
3/8”	.0045	.0050	.0035	.0050	.0035	.0045	.0050	.0045	.0050	.0045	.0080	.0085	.0080	.0085	.0080
1/2”	.0060	.0065	.0055	.0070	.0055	.0060	.0070	.0060	.0070	.0060	.0100	.0105	.0100	.0105	.0100
3/4”	.0080	.0090	.0075	.0090	.0075	.0080	.0095	.0080	.0095	.0080	.0140	.0145	.0140	.0145	.0140
1”	.0100	.0110	.0095	.0110	.0095	.0100	.0110	.0100	.0110	.0100	.0180	.0185	.0180	.0185	.0180

IPT (in/tooth)

	Plastics (1000-1400) SFM (ft/min)					Brass & Copper (1000-1400) 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”	.0030	.0035	.0030	.0035	.0030	.0030	.0035	.0030	.0035	.0030
1/4”	.0060	.0065	.0060	.0065	.0060	.0060	.0065	.0060	.0065	.0060
3/8”	.0080	.0085	.0080	.0085	.0080	.0080	.0085	.0080	.0085	.0080
1/2”	.0100	.0105	.0100	.0105	.0100	.0100	.0105	.0100	.0105	.0100
3/4”	.0140	.0145	.0140	.0145	.0140	.0140	.0145	.0140	.0145	.0140
1”	.0180	.0185	.0180	.0185	.0180	.0180	.0185	.0180	.0185	.0180

IPT (in/tooth)

Not Recommended for Graphite, Cast Iron, Hardened Steels > 48RC, Steels, Stainless Steels, Super Alloys (Nickel based, Inconel), or Titanium.

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
3825 AlumaMill End Mill

AlumaMill™

3825 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

	High Si Aluminum (>10%) (243-304) SMM (m/min)					Low Si Aluminum (<10%) (396-762) SMM (m/min)					Composites (121-243) 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	.0254	.0279	.0254	.0279	.0254	.0254	.0305	.0254	.0305	.0254	.0762	.0889	.0762	.0889	.0762
6	.0762	.0813	.0635	.0889	.0635	.0762	.0838	.0762	.0838	.0762	.1524	.1651	.1524	.1651	.1524
10	.1143	.1270	.0889	.1270	.0889	.1143	.1270	.1143	.1270	.1143	.2032	.2159	.2032	.2159	.2032
12	.1524	.1651	.1397	.1778	.1397	.1524	.1778	.1524	.1778	.1524	.2540	.2667	.2540	.2667	.2540
20	.2032	.2286	.1905	.2286	.1905	.2032	.2413	.2032	.2413	.2032	.3556	.3683	.3556	.3683	.3556
25	.2540	.2794	.2413	.2794	.2413	.2540	.2794	.2540	.2794	.2540	.4572	.4699	.4572	.4699	.4572

IPT (in/tooth)

	Plastics (304-426) SMM (m/min)					Brass & Copper (304-426)) 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	.0762	.0889	.0762	.0889	.0762	.0762	.0889	.0762	.0889	.0762
6	.1524	.1651	.1524	.1651	.1524	.1524	.1651	.1524	.1651	.1524
10	.2032	.2159	.2032	.2159	.2032	.2032	.2159	.2032	.2159	.2032
12	.2540	.2667	.2540	.2667	.2540	.2540	.2667	.2540	.2667	.2540
20	.3556	.3683	.3556	.3683	.3556	.3556	.3683	.3556	.3683	.3556
25	.4572	.4699	.4572	.4699	.4572	.4572	.4699	.4572	.4699	.4572

IPT (in/tooth)

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If a coating is applied to the tools, the SMM can be increased by approximately 25%.
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