

AlumaMill



3835 Series AlumaMill End Mill is designed for aggressive material removal rates in non-ferrous materials.

	High Si Aluminum (>10%) (800-1500) SFM (ft/min)					Low Si Aluminum (<10%) (1500-2500) SFM (ft/min)					Composites (400-900) 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	.0020	.0020	.0030	.0020	.0010	.0020	.0010	.0030	.0010	.0015	.0020	.0015	.0020	.0015
1/4"	.0020	.0030	.0030	.0040	.0030	.0015	.0020	.0020	.0035	.0020	.0020	.0025	.0020	.0025	.0020
3/8"	.0030	.0040	.0040	.0050	.0040	.0035	.0040	.0045	.0055	.0045	.0025	.0030	.0025	.0030	.0025
1/2"	.0040	.0060	.0050	.0065	.0050	.0050	.0050	.0055	.0065	.0055	.0035	.0040	.0040	.0045	.0040
3/4"	.0070	.0080	.0065	.0075	.0065	.0060	.0085	.0080	.0090	.0080	.0050	.0055	.0055	.0070	.0055
1"	.0080	.0100	.0075	.0085	.0075	.0080	.0100	.0110	.0110	.0110	.0060	.0065	.0060	.0075	.0060

IPT (in/tooth)

	Plastics Recommended in Unique Situations					Brass & Copper (600-900) 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"	-	-	-	-	-	.0015	.0020	.0015	.0020	.0015
1/4"	-	-	-	-	-	.0020	.0025	.0020	.0025	.0020
3/8"	-	-	-	-	-	.0025	.0030	.0025	.0030	.0025
1/2"	-	-	-	-	-	.0035	.0040	.0040	.0045	.0040
3/4"	-	-	-	-	-	.0050	.0055	.0055	.0070	.0055
1"	-	-	-	-	-	.0060	.0065	.0060	.0075	.0060

IPT (in/tooth)

Not Recommended for Graphite, Cast Iron, Hardened Steels > 48RC, Steels, Stainless Steels, Super Alloys (Nickel based, Inconel), or Titanium.
Plastics 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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	High Si Aluminum (>10%) (243-457) SMM (m/min)					Low Si Aluminum (<10%) (762) SMM (m/min)					Composites (121-274) 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	.0508	.0508	.0762	.0508	.0254	.0508	.0254	.0762	.0254	.0381	.0508	.0381	.0508	.0381
6	.0508	.0762	.0762	.1016	.0762	.0381	.0508	.0508	.0889	.0508	.0508	.0635	.0508	.0635	.0508
10	.0762	.1016	.1016	.1270	.1016	.0889	.1016	.1143	.1397	.1143	.0635	.0762	.0635	.0762	.0635
12	.1016	.1524	.1270	.1651	.1270	.1270	.1270	.1397	.1651	.1397	.0889	.1016	.1016	.1143	.1016
20	.1778	.2032	.1651	.1905	.1651	.1524	.2159	.2032	.2286	.2032	.1270	.1397	.1397	.1778	.1397
25	.2032	.2540	.1905	.2159	.1905	.2032	.2540	.2794	.2794	.2794	.1524	.1651	.1524	.1905	.1524

IPT (in/tooth)

	Plastics Recommended in Unique Situations					Brass & Copper (182-274) 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	-	-	-	-	-	.0381	.0508	.0381	.0508	.0381
6	-	-	-	-	-	.0508	.0635	.0508	.0635	.0508
10	-	-	-	-	-	.0635	.0762	.0635	.0762	.0635
12	-	-	-	-	-	.0889	.1016	.1016	.1143	.1016
20	-	-	-	-	-	.1270	.1397	.1397	.1778	.1397
25	-	-	-	-	-	.1524	.1651	.1524	.1905	.1524

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Plastics Recommended in Unique Situations.

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