

Hogger



3975 Series Hogger End Mill is designed as a rougher for high volume material removal.

	Hi Si Aluminum (>10%) (200-600) SFM (ft/min)					Low Si Aluminum (<10%) (300-800) SFM (ft/min)					Cast Iron (400-600) 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"	.0004	.0001	.0004	-	.0004	.0004	.0001	.0004	-	.0004	.0008	-	-	-	-
1/4"	.0006	.0002	.0006	-	.0006	.0006	.0002	.0006	-	.0006	.0015	-	-	-	-
3/8"	.0008	.0004	.0008	-	.0008	.0008	.0004	.0008	-	.0008	.0023	-	-	-	-
1/2"	.0010	.0006	.0010	-	.0010	.0010	.0006	.0010	-	.0010	.0030	-	-	-	-
3/4"	.0012	.0008	.0012	-	.0012	.0012	.0008	.0012	-	.0012	.0045	-	-	-	-
1"	.0015	.0010	.0015	-	.0015	.0015	.0010	.0015	-	.0015	.0061	-	-	-	-

IPT (in/tooth)

	Steels (100-300) SFM (ft/min)					Super Alloys (Nickel based, Inconel) (100-250) SFM (ft/min)					Titanium (100-250) 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"	.0004	.0001	.0004	-	.0004	.0002	-	-	-	-	.0002	-	-	-	-
1/4"	.0006	.0002	.0006	-	.0006	.0003	-	-	-	-	.0003	-	-	-	-
3/8"	.0008	.0004	.0008	-	.0008	.0005	-	-	-	-	.0005	-	-	-	-
1/2"	.0010	.0006	.0010	-	.0010	.0007	-	-	-	-	.0007	-	-	-	-
3/4"	.0012	.0008	.0012	-	.0012	.0010	-	-	-	-	.0010	-	-	-	-
1"	.0015	.0010	.0015	-	.0015	.0013	-	-	-	-	.0013	-	-	-	-

IPT (in/tooth)

**Not Recommended for Composites, Plastics, Brass & Copper, Graphite,
Hardened Steels > 48 RC, or Stainless Steels.**

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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3975 Series Hogger End Mill is designed as a rougher for high volume material removal.

	Hi Si Aluminum (>10%) (60-182) SMM (m/min)					Low Si Aluminum (<10%) (91-243) SMM (m/min)					Cast Iron (121-182)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	.0102	.0025	.0102	-	.0102	.0102	.0025	.0102	-	.0102	.0203	-	-	-	-
6	.0152	.0051	.0152	-	.0152	.0152	.0051	.0152	-	.0152	.0381	-	-	-	-
10	.0203	.0102	.0203	-	.0203	.0203	.0102	.0203	-	.0203	.0584	-	-	-	-
12	.0254	.0152	.0254	-	.0254	.0254	.0152	.0254	-	.0254	.0762	-	-	-	-
20	.0305	.0203	.0305	-	.0305	.0305	.0203	.0305	-	.0305	.1143	-	-	-	-
25	.0381	.0254	.0381	-	.0381	.0381	.0254	.0381	-	.0381	.1549	-	-	-	-

IPT (in/tooth)

	Steels (30-91) SMM (m/min)					Super Alloys (Nickel based, Inconel) (30-76) SMM (m/min)					Titanium (30-76) 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	.0025	.0102	-	.0102	.0051	-	-	-	-	.0051	-	-	-	-
6	.0152	.0051	.0152	-	.0152	.0076	-	-	-	-	.0076	-	-	-	-
10	.0203	.0102	.0203	-	.0203	.0127	-	-	-	-	.0127	-	-	-	-
12	.0254	.0152	.0254	-	.0254	.0178	-	-	-	-	.0178	-	-	-	-
20	.0305	.0203	.0305	-	.0305	.0254	-	-	-	-	.0254	-	-	-	-
25	.0381	.0254	.0381	-	.0381	.0330	-	-	-	-	.0330	-	-	-	-

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Start with conservative speeds and feeds while analyzing the rigidity of the process.
Then cautiously progress incrementally to achieve optimum performance.

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