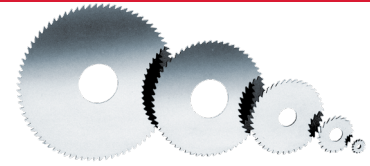


### Size 1/4" to 6" Diameter



SFM (ft/min)		Low Si Aluminum <10% (1200-1500) SFM (ft/min)	High Si Aluminum >10% (750-1000) SFM (ft/min)	Composites (0-0) SFM (ft/min)	Plastics (1500-2000) SFM (ft/min)	Brass & Copper (400-550) SFM (ft/min)	Graphite (0-0) SFM (ft/min)
Diameter	# of Teeth	Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
1/4	12	.0040	-	.0040	.0040	.0040	.0040
5/16	12	.0042	-	.0042	.0042	.0042	.0042
3/8	14	.0045	-	.0045	.0045	.0045	.0045
1/2	14	.0048	-	.0048	.0048	.0048	.0048
5/8	16	.0050	-	.0050	.0050	.0050	.0050
3/4	18	.0052	-	.0052	.0052	.0052	.0052
1	20	.0055	-	.0055	.0055	.0055	.0055
1 1/4	24	.0058	-	.0058	.0058	.0058	.0058
1 1/2	36	.0060	-	.0060	.0060	.0060	.0060
1 3/4	38	.0062	-	.0062	.0062	.0062	.0062
2	40	.0065	-	.0065	.0065	.0065	.0065
2 1/4	44	.0068	-	.0068	.0068	.0068	.0068
2 1/2	48	.0070	-	.0070	.0070	.0070	.0070
2 3/4	60	.0072	-	.0072	.0072	.0072	.0072
3	72	.0075	-	.0075	.0075	.0075	.0075
3 1/2	76	.0078	-	.0078	.0078	.0078	.0078
4	80	.0080	-	.0080	.0080	.0080	.0080
5	100	.0080	-	.0080	.0080	.0080	.0080
6	120	.0080	-	.0080	.0080	.0080	.0080
IPT (in/tooth)							

SFM (ft/min)		Cast Iron (150-350) SFM (ft/min)	Hardened Steel >48 RC (60-140) SFM (ft/min)	Mild Steels <48 RC (150-400) SFM (ft/min)	Stainless Steels (75-175) SFM (ft/min)	Super Alloys (50-150) SFM (ft/min)	Titanium (75-200) SFM (ft/min)
Diameter	# of Teeth	Slotting	Slotting	Slotting	Slotting	Slotting	Slotting
		Rough	Rough	Rough	Rough	Rough	Rough
1/4	12	.0030	.0020	.0020	.0020	.0020	.0020
5/16	12	.0033	.0021	.0021	.0021	.0021	.0021
3/8	14	.0035	.0022	.0022	.0022	.0022	.0022
1/2	14	.0038	.0023	.0023	.0023	.0023	.0023
5/8	16	.0040	.0024	.0024	.0024	.0024	.0024
3/4	18	.0042	.0025	.0025	.0025	.0025	.0025
1	20	.0045	.0026	.0026	.0026	.0026	.0026
1 1/4	24	.0049	.0027	.0027	.0027	.0027	.0027
1 1/2	36	.0050	.0028	.0028	.0028	.0028	.0028
1 3/4	38	.0052	.0029	.0029	.0029	.0029	.0029
2	40	.0055	.0030	.0030	.0030	.0030	.0030
2 1/4	44	.0058	.0033	.0033	.0031	.0031	.0031
2 1/2	48	.0060	.0035	.0035	.0032	.0032	.0032
2 3/4	60	.0062	.0038	.0038	.0033	.0033	.0033
3	72	.0065	.0040	.0040	.0034	.0034	.0034
3 1/2	76	.0068	.0042	.0042	.0035	.0035	.0035
4	80	.0070	.0045	.0045	.0037	.0037	.0037
5	100	.0070	.0048	.0048	.0039	.0039	.0039
6	120	.0070	.0050	.0050	.0040	.0040	.0040
IPT (in/tooth)							

#### Not recommended for High Si Aluminum (>10%)

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.

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