



3845 Series Falcon End Mill allows for superior part finishes at extraordinary feed rates.

	Cast Iron (390-520) SFM (ft/min)					Hardened Steels > 48RC (150-300) SFM (ft/min)					Steels (490-660) 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"	.0008	.0009	.0008	.0009	.0008	.0006	.0007	.0006	.0007	.0006	.0010	.0009	.0010	.0009	.0010
1/4"	.0016	.0018	.0016	.0018	.0016	.0013	.0014	.0013	.0014	.0013	.0017	.0018	.0017	.0018	.0017
3/8"	.0025	.0027	.0025	.0027	.0025	.0018	.0020	.0018	.0020	.0018	.0023	.0027	.0023	.0027	.0023
1/2"	.0030	.0035	.0030	.0035	.0030	.0024	.0026	.0024	.0026	.0024	.0033	.0035	.0033	.0035	.0033
3/4"	.0035	.0043	.0035	.0043	.0035	.0030	.0033	.0030	.0033	.0030	.0040	.0043	.0040	.0043	.0040
1"	.0040	.0050	.0040	.0050	.0040	.0035	.0039	.0035	.0039	.0035	.0045	.0050	.0045	.0050	.0045

IPT (in/tooth)

	Stainless Steels (260-330) SFM (ft/min)					Super Alloys (Nickel based, Inconel) (160-260) 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"	.0006	.0007	.0006	.0007	.0006	.0005	.0006	.0005	.0006	.0005	.0005	.0006	.0005	.0006	.0005
1/4"	.0010	.0015	.0010	.0015	.0010	.0010	.0012	.0010	.0012	.0010	.0010	.0012	.0010	.0012	.0010
3/8"	.0012	.0023	.0012	.0023	.0012	.0012	.0018	.0012	.0018	.0012	.0012	.0018	.0012	.0018	.0012
1/2"	.0020	.0029	.0020	.0029	.0020	.0018	.0023	.0018	.0023	.0018	.0018	.0023	.0018	.0023	.0018
3/4"	.0030	.0038	.0030	.0038	.0030	.0025	.0030	.0025	.0030	.0025	.0025	.0030	.0025	.0030	.0025
1"	.0040	.0046	.0040	.0046	.0040	.0030	.0036	.0030	.0036	.0030	.0030	.0036	.0030	.0036	.0030

IPT (in/tooth)

**Not Recommended for High Si Aluminum (>10%), Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, or Graphite.**

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](mailto:engineering@fullertontool.com)



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	Cast Iron (118-158) SMM (m/min)					Hardened Steels >48RC (45-91) SMM (m/min)					Steels (149-201) 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	.0203	.0229	.0203	.0229	.0203	.0152	.0178	.0152	.0178	.0152	.0254	.0229	.0254	.0229	.0254
6	.0406	.0457	.0406	.0457	.0406	.0330	.0356	.0330	.0356	.0330	.0432	.0457	.0432	.0457	.0432
10	.0635	.0686	.0635	.0686	.0635	.0457	.0508	.0457	.0508	.0457	.0584	.0686	.0584	.0686	.0584
12	.0762	.0889	.0762	.0889	.0762	.0610	.0660	.0610	.0660	.0610	.0838	.0889	.0838	.0889	.0838
20	.0889	.1092	.0889	.1092	.0889	.0762	.0838	.0762	.0838	.0762	.1016	.1092	.1016	.1092	.1016
25	.1016	.1270	.1016	.1270	.1016	.0889	.0991	.0889	.0991	.0889	.1143	.1270	.1143	.1270	.1143

IPT (in/tooth)

	Stainless Steels (79-100) SMM (m/min)					Super Alloys (Nickel based, Inconel) (48-79) SMM (m/min)					Titanium (48-79) 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	.0152	.0178	.0152	.0178	.0152	.0127	.0152	.0127	.0152	.0127	.0127	.0152	.0127	.0152	.0127
6	.0254	.0381	.0254	.0381	.0254	.0254	.0305	.0254	.0305	.0254	.0254	.0305	.0254	.0305	.0254
10	.0305	.0584	.0305	.0584	.0305	.0305	.0457	.0305	.0457	.0305	.0305	.0457	.0305	.0457	.0305
12	.0508	.0737	.0508	.0737	.0508	.0457	.0584	.0457	.0584	.0457	.0457	.0584	.0457	.0584	.0457
20	.0762	.0965	.0762	.0965	.0762	.0635	.0762	.0635	.0762	.0635	.0635	.0762	.0635	.0762	.0635
25	.1016	.1168	.1016	.1168	.1016	.0762	.0914	.0762	.0914	.0762	.0762	.0914	.0762	.0914	.0762

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