



FULLERTON[®]

S P E E D S / F E E D S

Three 30° RH Spiral Flutes | 130° High Performance Point

	Imperial (in)							Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
High Si Aluminum >10%	RPM	12,224	6,112	4,075	3,056	2,037	1,528	12,936	6,468	3,881	3,234	2,042	1,552
	IPM	49	40	41	31	33	31	1242	1009	1035	776	828	776
	SFM	400	400	400	400	400	400	122	122	122	122	122	122
	IPR	.004	.007	.010	.010	.016	.020	0.10	0.16	0.27	0.24	0.41	0.50
Low Si Aluminum <10%	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	76	61	64	48	51	48	1940	1552	1617	1213	1294	1213
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.005	.008	.013	.013	.020	.025	0.12	0.19	0.33	0.30	0.51	0.63
Plastics	RPM	12,224	6,112	4,075	3,056	2,037	1,528	12,936	6,468	3,881	3,234	2,042	1,552
	IPM	49	40	41	31	33	31	1242	1009	1035	776	828	776
	SFM	400	400	400	400	400	400	122	122	122	122	122	122
	IPR	.004	.007	.010	.010	.016	.020	0.10	0.16	0.27	0.24	0.41	0.50
Brass & Copper	RPM	16,808	8,404	5,603	4,202	2,801	2,101	17,787	8,893	5,336	4,447	2,808	2,134
	IPM	67	55	56	53	45	42	1708	1387	1423	1334	1138	1067
	SFM	550	550	550	550	550	550	168	168	168	168	168	168
	IPR	.004	.007	.010	.013	.016	.020	0.10	0.16	0.27	0.30	0.41	0.50
Graphite	RPM	7,640	3,820	2,547	1,910	1,273	955	8,085	4,042	2,425	2,021	1,277	970
	IPM	31	25	25	19	20	19	776	631	647	485	517	485
	SFM	250	250	250	250	250	250	76	76	76	76	76	76
	IPR	.004	.007	.010	.010	.016	.020	0.10	0.16	0.27	0.24	0.41	0.50
Titanium	RPM	3,056	1,528	1,019	764	509	382	3,234	1,617	970	808	511	388
	IPM	8	6	5	5	3	3	194	155	129	126	84	68
	SFM	100	100	100	100	100	100	30	30	30	30	30	30
	IPR	.003	.004	.005	.007	.007	.007	0.06	0.10	0.13	0.16	0.16	0.18

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