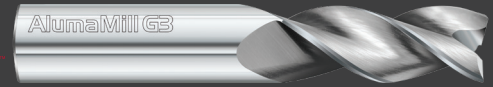


3833 ALUMAMILL G3 - IMPERIAL **AlumaMill G3**



3833 Series AlumaMill G3 End Mill generates superior wall finishes.

Not Recommended for Graphite, Cast Iron, Hardened Steels > 48RC, Steels, Stainless Steels, Super Alloys (Nickel based, Inconel), or Titanium. Plastics Recommended in Unique Situations.

FULLERTON®
SPEEDS / FEEDS

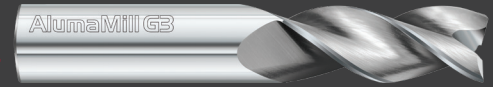
	High Si Aluminum (>10%)					Low Si Aluminum (<10%)				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	800	800	800	800	800	1,500	1,500	2,000	2,500	2,500
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0010	.0020	.0010	.0010	.0030	.0010	.0020	.0010	.0010	.0030
1/4"	.0015	.0020	.0020	.0020	.0035	.0015	.0020	.0020	.0020	.0035
3/8"	.0035	.0040	.0045	.0045	.0055	.0035	.0040	.0045	.0045	.0055
1/2"	.0050	.0050	.0055	.0055	.0065	.0050	.0050	.0055	.0055	.0065
3/4"	.0060	.0085	.0080	.0080	.0090	.0060	.0085	.0080	.0080	.0090
1"	.0080	.0100	.0100	.0100	.0110	.0080	.0100	.0100	.0100	.0110
	Plastics Recommended in Unique Situations					Brass & Copper				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	1,000	1,000	1,200	1,400	1,400	800	800	800	800	800
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0030	.0035	.0030	.0030	.0035	.0030	.0035	.0020	.0020	.0025
1/4"	.0060	.0065	.0060	.0060	.0065	.0040	.0045	.0030	.0030	.0035
3/8"	.0080	.0085	.0080	.0080	.0085	.0050	.0055	.0040	.0040	.0045
1/2"	.0100	.0105	.0100	.0100	.0105	.0060	.0065	.0045	.0045	.0055
3/4"	.0140	.0145	.0140	.0140	.0145	.0080	.0085	.0060	.0060	.0075
1"	.0180	.0185	.0180	.0180	.0185	.0100	.0110	.0070	.0070	.0085

IPT (in/tooth)

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3833 ALUMAMILL G3 - METRIC

AlumaMill G3



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FULLERTON®
SPEEDS / FEEDS

	High Si Aluminum (>10%)					Low Si Aluminum (<10%)				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	243	243	243	243	243	1500	1500	2000	2500	2500
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	.0254	.0508	.0254	.0254	.0762	.0254	.0508	.0254	.0254	.0762
6	.0381	.0508	.0508	.0508	.0889	.0381	.0508	.0508	.0508	.0889
10	.0889	.1016	.1143	.1143	.1397	.0889	.1016	.1143	.1143	.1397
12	.1270	.1270	.1397	.1397	.1651	.1270	.1270	.1397	.1397	.1651
20	.1524	.2159	.2032	.2032	.2286	.1524	.2159	.2032	.2032	.2286
25	.2032	.2540	.2540	.2540	.2794	.2032	.2540	.2540	.2540	.2794
	Plastics Recommended in Unique Situations					Brass & Copper				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	304	304	365	426	426	243	243	243	243	243
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	.0762	.0889	.0762	.0762	.0889	.0762	.0889	.0508	.0508	.0635
6	.1524	.1651	.1524	.1524	.1651	.1016	.1143	.0762	.0762	.0889
10	.2032	.2159	.2032	.2032	.2159	.1270	.1397	.1016	.1016	.1143
12	.2540	.2667	.2540	.2540	.2667	.1524	.1651	.1143	.1143	.1397
20	.3556	.3683	.3556	.3556	.3683	.2032	.2159	.1524	.1524	.1905
25	.4572	.4699	.4572	.4572	.4699	.2540	.2794	.1778	.1778	.2159