3730 CHAMFER MILL - IMPERIAL

FULLERTON®

SPEEDS / FEEDS

3730 Series Chamfer Mill is designed for for deburring and chamfering in small grooves and holes.

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.

	Wood	Composites	Plastics	High Si Aluminum (>10%) (2.0)	Low Si Aluminum (<10%) (3.0)	Brass & Copper	Graphite
SFM (ft/min)	500-800	300-600	500-800	500-800	1100-1500	400-600	500-800
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)
Radial Width	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD
1/8”	.0018	.0035	.0018	.0011	.0012	.0011	.0020
1/4”	.0033	.0065	.0033	.0032	.0034	.0015	.0040
3/8”	.0043	.0085	.0043	.0050	.0048	.0021	.0060
1/2”	.0053	.0105	.0053	.0065	.0063	.0028	.0080
3/4”	.0073	.0145	.0073	.0090	.0085	.0035	.0100
1”	.0093	.0185	.0093	.0110	.0114	.0040	.0150

	Cast Iron	Hardened Steels > 48 RC (.75)	Steels	Stainless Steels	Super Alloys (Nickel based, Inconel)	Titanium
SFM (ft/min)	250-400	80-130	230-350	130-280	80-120	120-200
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)
Radial Width	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD
1/8”	.0012	.0009	.0008	.0008	.0004	.0004
1/4”	.0015	.0016	.0014	.0014	.0010	.0007
3/8”	.0022	.0022	.0022	.0022	.0015	.0011
1/2”	.0030	.0025	.0025	.0023	.0020	.0014
3/4”	.0035	.0030	.0028	.0025	.0025	.0018
1”	.0045	.0035	.0035	.0027	.0030	.0025

IPT (in/tooth)

3730 CHAMFER MILL - METRIC

FULLERTON®

SPEEDS / FEEDS

3730 Series Chamfer Mill is designed for for deburring and chamfering in small grooves and holes.

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 SMM 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.

	Wood	Composites	Plastics	High Si Aluminum (>10%) (2.0)	Low Si Aluminum (<10%) (3.0)	Brass & Copper	Graphite
SMM (m/min)	152--243	91-182	152-243	152-243	335-457	121-182	152-243
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)
Radial Width	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD
3	.0445	.0889	.0445	.0279	.0305	.0279	.0508
6	.0826	.1651	.0826	.0812	.0864	.0381	.1016
10	.1080	.2159	.1080	.1270	.1219	.0533	.1524
12	.1334	.2667	.1334	.1651	.1600	.0711	.2032
20	.1842	.3683	.1842	.2286	.2159	.0889	.2540
25	.2350	.4699	.2350	.2794	.2896	.1016	.3810

	Cast Iron	Hardened Steels > 48 RC (.75)	Steels	Stainless Steels	Super Alloys (Nickel based, Inconel)	Titanium
SMM (m/min)	76-121	24-40	70-107	40-85	24-36	36-60
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)
Radial Width	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD	(.05-.08)xD
3	.0305	.0229	.0203	.0203	.0102	.0102
6	.0381	.0406	.0356	.0356	.0254	.0178
10	.0559	.0559	.0559	.0559	.0381	.0279
12	.0762	.0635	.0635	.0584	.0508	.0356
20	.0889	.0762	.0711	.0635	.0635	.0457
25	.1143	.0889	.0889	.0686	.0762	.0635

MMPT (mm/tooth)