

# 3975 HOGGER - IMPERIAL

# Hogger



**3975 Series Hogger End Mill is designed as a rougher for high volume material removal.**

*Not Recommended for Composites, Plastics, Brass & Copper, Graphite, Hardened Steels > 48 RC, or Stainless Steels.*

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.

	Cast Iron					Hardened Steels > 48 RC					Steels				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	400-600	-	400-600	-	-	125-150	-	125-150	-	-	200-300	-	200-300	-	-
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (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	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0008	-	.0008	-	-	.0007	-	.0007	-	-	.0004	-	.0004	-	-
1/4"	.0015	-	.0015	-	-	.0010	-	.0010	-	-	.0006	-	.0006	-	-
3/8"	.0023	-	.0023	-	-	.0015	-	.0015	-	-	.0008	-	.0008	-	-
1/2"	.0030	-	.0030	-	-	.0020	-	.0020	-	-	.0010	-	.0010	-	-
3/4"	.0045	-	.0045	-	-	.0025	-	.0025	-	-	.0012	-	.0012	-	-
1"	.0050	-	.0050	-	-	.0030	-	.0030	-	-	.0015	-	.0015	-	-
	Stainless Steels					Super Alloys (Nickel Based, Inconel)					Titanium				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	100-250	-	100-250	-	-	75-100	-	75-100	-	-	75-100	-	75-100	-	-
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (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	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"	.0004	-	.0004	-	-	.0002	-	.0002	-	-	.0002	-	.0002	-	-
1/4"	.0006	-	.0006	-	-	.0003	-	.0003	-	-	.0003	-	.0003	-	-
3/8"	.0008	-	.0008	-	-	.0005	-	.0005	-	-	.0005	-	.0005	-	-
1/2"	.0010	-	.0010	-	-	.0007	-	.0007	-	-	.0007	-	.0007	-	-
3/4"	.0012	-	.0012	-	-	.0010	-	.0010	-	-	.0010	-	.0010	-	-
1"	.0015	-	.0015	-	-	.0013	-	.0013	-	-	.0013	-	.0013	-	-

**FULLERTON<sup>®</sup>**  
**SPEEDS / FEEDS**

IPT (in/tooth)

800.248.8315 | [fullertontool.com](http://fullertontool.com)

# 3975 HOGGER - METRIC

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**FULLERTON®**  
**SPEEDS / FEEDS**

	Cast Iron					Hardened Steels > 48 RC					Steels				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	121-182	-	121-182	-	-	38-45	-	38-45	-	-	60-91	-	60-91	-	-
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (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	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	.0203	-	.0203	-	-	.0178	-	.0178	-	-	.0102	-	.0102	-	-
6	.0381	-	.0381	-	-	.0254	-	.0254	-	-	.0152	-	.0152	-	-
10	.0584	-	.0584	-	-	.0381	-	.0381	-	-	.0203	-	.0203	-	-
12	.0762	-	.0762	-	-	.0508	-	.0508	-	-	.0254	-	.0254	-	-
20	.1143	-	.1143	-	-	.0635	-	.0635	-	-	.0305	-	.0305	-	-
25	.1270	-	.1270	-	-	.0762	-	.0762	-	-	.0381	-	.0381	-	-
	Stainless Steels					Super Alloys (Nickel Based, Inconel)					Titanium				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SMM (m/min)	30-76	-	30-76	-	-	22-30	-	22-30	-	-	22-30	-	22-30	-	-
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)	< (1xD)	full	< (2xD)	< (2xD)	< (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	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	.0102	-	.0102	-	-	.0051	-	.0051	-	-	.0051	-	.0051	-	-
6	.0152	-	.0152	-	-	.0076	-	.0076	-	-	.0076	-	.0076	-	-
10	.0203	-	.0203	-	-	.0127	-	.0127	-	-	.0127	-	.0127	-	-
12	.0254	-	.0254	-	-	.0178	-	.0178	-	-	.0178	-	.0178	-	-
20	.0305	-	.0305	-	-	.0254	-	.0254	-	-	.0254	-	.0254	-	-
25	.0381	-	.0381	-	-	.0330	-	.0330	-	-	.0330	-	.0330	-	-