## **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 analyizing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

	Cast Iron						Hard	ened 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	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508)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		-
		2	itainless Steel	s			Super Allo	ys (Nickel Bas	ed, 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)
<b>Radial Width</b>	full	full	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508)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	-	-

### 800.248.8315 | fullertontool.com

# **3975 HOGGER - METRIC**



**3975 Series Hogger End Mill is designed as a rougher for high volume material removal.** Not Recommended for Composites, Plastic, 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.

s a starting point. Ste															
	Cast Iron						Hard	ened 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	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508)xD	full	full	(.253)xD	(.125)xD	(.0508
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	-	-
25	.1270	- 2	.1270 Stainless Steels	- S	•	.0762	- Super Alloy	.0762 /s (Nickel Base	- ed, Inconel)	•	.0381	•	.0381 Titanium		•
25	.1270 Slotting	- Plunge/ Ramp	_	- s HEM	- Finish	.0762 Slotting	- Super Alloy Plunge/ Ramp	_	- ed, Inconel) HEM	- Finish	.0381 Slotting	- Plunge/ Ramp	_	- Hem	- Finisl
25 SMM (m/min)			Stainless Steels		- Finish -		Plunge/	vs (Nickel Base		- Finish		- Plunge/ Ramp -	Titanium	- HEM -	- Finis
	Slotting	Plunge/ Ramp	Stainless Steel: Rough/ Profile		- Finish - < (2xD)	Slotting	Plunge/ Ramp	rs (Nickel Base Rough/ Profile		- Finish - < (2xD)	Slotting	- Plunge/ Ramp - full	Titanium Rough/ Profile	- < (2xD)	- < (2xI
SMM (m/min)	Slotting 30-76	Plunge/ Ramp -	Stainless Steel: Rough/ Profile 30-76	HEM -	•	Slotting 22-30	Plunge/ Ramp -	rs (Nickel Base Rough/ Profile 22–30	HEM -	-	Slotting 22-30	- Ramp	Titanium Rough/ Profile 22-30	- < (2xD)	- < (2x
SMM (m/min) Axial Depth	Slotting 30-76 < (1xD)	Plunge/ Ramp - full	Stainless Steel: Rough/ Profile 30-76 < (2xD)	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD)	Plunge/ Ramp - full	rs (Nickel Base Rough/ Profile 22-30 < (2xD)	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD)	Ramp - full	Titanium Rough/ Profile 22-30 < (2xD)	- < (2xD)	•
SMM (m/min) Axial Depth Radial Width	Slotting 30-76 < (1xD) full	Plunge/ Ramp - full	Stainless Steel: Profile 30-76 < (2xD) (.253)xD	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full	Plunge/ Ramp - full	rs (Nickel Base Rough/ Profile 22-30 < (2xD) (.253)xD	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full	Ramp - full	Titanium Rough/ Profile 22-30 < (2xD) (.253)xD	- < (2xD)	- < (2x
SMM (m/min) Axial Depth Radial Width 3	Slotting 30-76 < (1xD) full .0102	Plunge/ Ramp - full full -	Stainless Steels Rough/ Profile 30-76 < (2xD) (.253)xD .0102	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051	Plunge/ Ramp - full	rs (Nickel Base Rough/ Profile 22-30 < (2xD) (.253)xD .0051	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051	Ramp - full	Titanium Rough/ Profile 22-30 < (2xD) (.253)xD .0051	- < (2xD)	- < (2x
SMM (m/min) Axial Depth Radial Width 3 6	Slotting 30-76 < (1xD) full .0102 .0152	Plunge/ Ramp - full full -	Stainless Steel: Profile 30-76 < (2xD) (.253)xD .0102 .0152	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051 .0076	Plunge/ Ramp - full	rs (Nickel Base Rough/ Profile 22-30 < (2xD) (.253)xD .0051 .0076	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051 .0076	Ramp - full	Titanium Rough/ Profile 22-30 < (2xD) (.253)xD .0051 .0076	- < (2xD)	- < (2x
SMM (m/min) Axial Depth Radial Width 3 6 10	Slotting 30-76 < (1xD) full .0102 .0152 .0203	Plunge/ Ramp - full full - -	Stainless Steel: Profile 30-76 < (2xD) (.253)XD .0102 .0152 .0203	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051 .0076 .0127	Plunge/ Ramp - full	rs (Nickel Base Profile 22-30 < (2xD) (.253)xD .0051 .0076 .0127	HEM - < (2xD)	- < (2xD)	Slotting 22-30 < (1xD) full .0051 .0076 .0127	Ramp - full	Titanium Rough/ Profile 22-30 < (2xD) (.253)xD .0051 .0076 .0127	- < (2xD)	- < (2x

### 800.248.8315 | **fullertontool**.com