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ALUMA MILL APPLICATION SHEET FULLERTON TOOL SERIES 3815 AND SERIES 3825 Aluminum Applications

Chipload Chart		
Dia.	Min.	Max.
1/8"	0.001	0.0015
3/16"	0.0015	0.0025
1/4"	0.002	0.003
5/16"	0.0025	0.004
3/8"	0.003	0.0045
1/2"	0.004	0.006
5/8"	0.005	0.01
3/4"	0.006	0.015
1"	0.007	0.018

Dia.	RPM		FEED (IPM)	
	MIN	MAX	MIN	MAX
1/8"	MAX	MAX	15	100
3/16"	9169	MAX	28	125
1/4"	6876	MAX	28	130
5/16"	5500	19558	28	156
3/8"	4584	16299	28	147
1/2"	3438	12224	28	147
5/8"	2750	9779	28	196
3/4"	2292	8149	28	244
1"	1719	6112	24	220

SURFACE SPEED IN ALUMINUM CAN BE AS LOW AS 450 SFM AND AS HIGH AS 1600 SFM.
FOR MOST APPLICATIONS START AT APPROXIMATELY 1000 SFM AND MID RANGE IN
THE CHIPLOAD CHART

For Lighter Radial Width of Cut - Use Higher Range of Surface Speeds.

For Greater Radial Width of Cut - Use Lower Range of Surface Speeds

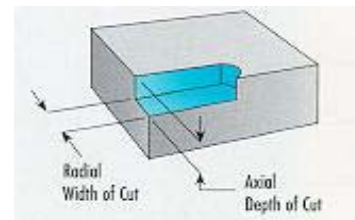
For Slotting Application - Start at approx. 500 SFM

Axial Depth of Cut - Recommendations are for Axial Depth of Cut less than 1.5 x Dia.

**Note: Series 3815 tools are furnished with a 45° chamfer for increased edge strength.
If a true 90° corner is required use the Series 3825.**

**The Aluma Mill is a rougher finisher tool designed for very high
speed machining in Aluminum and other non-ferrous materials.**

**This tool is suitable for peripheral, slotting, ramp and plunging
operations.**



Questions? Contact Steve Daxer at Discount-Tools.com (email: sales@discount-tools.com).