

Discount-Tools.com

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CARBIDE ROUGHER SPEEDS AND FEEDS FULLERTON TOOL SERIES 3975 AND 3995

MATERIAL HARDNESS	UP TO 22 Rc		23-30 Rc		31-41 Rc		42-50 Rc		51-60 Rc	
MATERIAL TO MACHINE	MEDIUM CARBON STEEL BRONZE		P-20 MOLD STEEL		TITANIUM PURE		HASTELLOY X		TITANIUM ALLOY	
	BRONZE		A2 STEEL		D2 TOOL STEEL		INCONEL		ANNEALED INCONEL	
	SOFT CAST IRON		MEDIUM CARBON ANNEALED		STAINLESS 300 SERIES		HIGH TENSILE STEELS		WASPALLOY	
	COPPER		01 STEEL		STAINLESS 17-4 PH ANNEALED		TOOL STEELS 42-50 Rc		RENE 41 & 43	
			ANNEALED AND ALLOY STEEL		FREE MACHINING STAINLESS		HARD CAST IRON			
					ANNEALED MONEL 4340					
DIAMETER OF TOOL	SPEED 400 SFM	FEED	SPEED 300 SFM	FEED	SPEED 200 SFM	FEED	SPEED 125 SFM	FEED	SPEED 100 SFM	FEED
	RPM	IN/MIN	RPM	IN/MIN	RPM	IN/MIN	RPM	IN/MIN	RPM	IN/MIN
1/4"	6112	37	4584	23	3056	12	1910	6	1528	2
5/16"	4889	37	3667	23	2445	12	1528	6	1222	2
3/8"	4074	37	3056	23	2037	12	1273	6	1019	2
1/2"	3056	37	2292	23	1528	12	955	6	764	2
5/8"	2445	37	1833	23	1222	12	764	6	611	2
3/4"	2037	37	1528	23	1019	12	637	6	509	2
1"	1528	37	1146	23	764	12	477	6	382	2

Start machining at 50% of the suggested feed rates and slowly increase to the suggested feed rates. As rigidity and other variables may affect tool performance and life. Above feed rates are for axial depth of cut equal to diameter of cut in slotting operation. For greater axial depth decrease feed rates. For profiling increase feed.