



3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and titanium.

	High Si Aluminum (>10%) Recommended in Unique Situations					Hardened Steels > 48 RC (120-170) SFM (ft/min)					Steels (200-800) SFM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
1/8"	-	-	-	-	-	.0006	.0007	.0006	.0007	.0006	.0007	.0009	.0007	.0009	.0007
1/4"	-	-	-	-	-	.0012	.0014	.0012	.0014	.0012	.0015	.0018	.0015	.0018	.0015
3/8"	-	-	-	-	-	.0018	.0020	.0018	.0020	.0018	.0020	.0022	.0020	.0022	.0020
1/2"	-	-	-	-	-	.0020	.0022	.0020	.0022	.0020	.0022	.0024	.0022	.0024	.0022
3/4"	-	-	-	-	-	.0024	.0026	.0024	.0026	.0024	.0026	.0028	.0026	.0028	.0026
1"	-	-	-	-	-	.0025	.0027	.0025	.0027	.0025	.0028	.0030	.0028	.0030	.0028

	Stainless Steels (220-500) SFM (ft/min)					Super Alloys (Nickel Based, Inconel) (20-170) SMM (ft/min)					Titanium (60-500) SMM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
1/8"	.0004	.0007	.0007	.0010	.0007	.0004	.0005	.0004	.0008	.0004	.0004	.0005	.0004	.0010	.0004
1/4"	.0010	.0010	.0013	.0015	.0015	.0008	.0010	.0008	.0010	.0008	.0008	.0010	.0008	.0018	.0008
3/8"	.0013	.0012	.0020	.0026	.0024	.0013	.0015	.0013	.0020	.0013	.0012	.0015	.0012	.0025	.0012
1/2"	.0015	.0013	.0022	.0028	.0026	.0019	.0020	.0019	.0025	.0019	.0016	.0018	.0016	.0035	.0016
3/4"	.0018	.0015	.0030	.0032	.0028	.0025	.0028	.0025	.0040	.0025	.0020	.0022	.0020	.0045	.0020
1"	.0020	.0016	.0035	.0035	.0030	.0027	.0030	.0027	.0045	.0027	.0028	.0030	.0028	.0050	.0028

# NORMEK

Snickarvägen 1F, 132 38 Saltsjö-Boo, 08-188210, normek@normek.se, www.normek.se

Not Recommended for Low Si Aluminum (<10%), Composites, Plastics, Brass & Copper, Graphite, or Cast Iron.

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.

Contact Engineering at 800.248.8315 or [engineering@fullertontool.com](mailto:engineering@fullertontool.com)



3500 Series Fury End Mill dominates in stainless steels, high temp alloys, and titanium.

	High Si Aluminum (>10%) Recommended in Unique Situations					Hardened Steels > 48 RC (39-51) SMM (m/min)					Steels (91-182) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	-	-	-	-	-	.0152	.0178	.0152	.0178	.0152	.0178	.0229	.0178	.0229	.0178
6	-	-	-	-	-	.0305	.0356	.0305	.0356	.0305	.0381	.0457	.0381	.0457	.0381
10	-	-	-	-	-	.0457	.0508	.0457	.0508	.0457	.0508	.0559	.0508	.0559	.0508
12	-	-	-	-	-	.0508	.0559	.0508	.0559	.0508	.0559	.0610	.0559	.0610	.0559
20	-	-	-	-	-	.0610	.0660	.0610	.0660	.0610	.0660	.0711	.0660	.0711	.0660
25	-	-	-	-	-	.0635	.0686	.0635	.0686	.0635	.0711	.0762	.0711	.0762	.0711

	Stainless Steels (76-91) SMM (m/min)					Super Alloys (Nickel Based, Inconel) (30-36) SMM (m/min)					Titanium (36-45) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD	full	full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	.0102	.0178	.0178	.0254	.0178	.0102	.0127	.0102	.0203	.0102	.0102	.0127	.0102	.0254	.0102
6	.0254	.0254	.0330	.0381	.0381	.0203	.0254	.0203	.0254	.0203	.0203	.0254	.0203	.0457	.0203
10	.0330	.0305	.0508	.0660	.0610	.0330	.0381	.0330	.0508	.0330	.0305	.0381	.0305	.0635	.0305
12	.0381	.0330	.0559	.0711	.0660	.0483	.0508	.0483	.0635	.0483	.0406	.0457	.0406	.0889	.0406
20	.0457	.0381	.0762	.0813	.0711	.0635	.0711	.0635	.1016	.0635	.0508	.0559	.0508	.1143	.0508
25	.0508	.0406	.0889	.0889	.0762	.0686	.0762	.0686	.1143	.0686	.0711	.0762	.0711	.1270	.0711

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