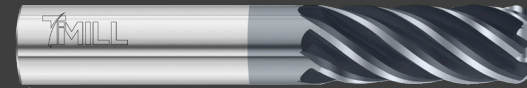


3116 TiMILL - IMPERIAL



3116 Series TiMill designed to excel in titanium.

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

FULLERTON®
SPEEDS / FEEDS

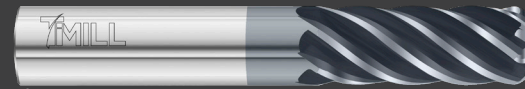
	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SFM (ft/min)			300	325	325
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"			.0003	.0003	.0004
1/4"			.0008	.0008	.0010
3/8"			.0010	.0010	.0015
1/2"			.0015	.0015	.0020
3/4"			.0020	.0020	.0025
1"			.0032	.0032	.0035

Examples: Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al, (with the exception of β Ti)

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SFM (ft/min)			400	400	400
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"			.0003	.0003	.0004
1/4"			.0008	.0008	.0010
3/8"			.0010	.0010	.0015
1/2"			.0015	.0015	.0020
3/4"			.0020	.0020	.0025
1"			.0032	.0032	.0035

Examples: Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12

3116 TiMILL - METRIC



3116 Series TiMill designed to excel in titanium.

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

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SPEEDS / FEEDS

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SMM (ft/min)			90	100	100
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3			.0076	.0076	.0102
6			.0203	.0203	.0254
10			.0254	.0254	.0381
12			.0381	.0381	.0508
20			.0508	.0508	.0635
25			.0813	.0813	.0889

Examples: Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al, (with the exception of β Ti)

	Titanium				
	Slotting	Plunge Ramp	Rough Profile	HEM	Finish
SMM (ft/min)			125	125	125
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3			.0076	.0076	.0102
6			.0203	.0203	.0254
10			.0254	.0254	.0381
12			.0381	.0381	.0508
20			.0508	.0508	.0635
25			.0813	.0813	.0889

Examples: Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12