3400 HARMON-I-CUT - IMPERIAL

3400 Series Harmon-i-cut End Mill is designed to maximize tool life and optimize metal removal rates.

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

FULLERTON® SPEEDS / FEEDS

	Cast Iron					Hardened Steels > 48RC					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)	250	250	250	525	525	100	100	150	300	300	200	200	300	600	600
Axial Depth	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (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"	.0005	.0007	.0005	.0005	.0007	.0002	.0006	.0002	.0002	.0006	.0002	.0007	.0002	.0002	.0007
1/4"	.0010	.0012	.0010	.0010	.0012	.0008	.0012	.0008	.0008	.0012	.0010	.0014	.0010	.0010	.0014
3/8"	.0020	.0020	.0020	.0020	.0020	.0012	.0018	.0012	.0012	.0018	.0020	.0021	.0020	.0020	.0021
1/2"	.0025	.0028	.0025	.0025	.0028	.0020	.0025	.0020	.0020	.0025	.0025	.0028	.0025	.0025	.0028
3/4"	.0030	.0035	.0030	.0030	.0035	.0025	.0035	.0025	.0025	.0035	.0030	.0035	.0030	.0030	.0035
1"	.0035	.0045	.0035	.0035	.0045	.0035	.0040	.0035	.0035	.0040	.0035	.0040	.0035	.0035	.0040

	Stainless Steels					Super Alloys (Nickell based, 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)	200	200	250	300	300	75	75	75	125	125	100	100	125	200	200
Axial Depth	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (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"	.0002	.0007	.0002	.0002	.0007	.0002	.0003	.0002	.0002	.0003	.0002	.0004	.0002	.0002	.0004
1/4"	.0008	.0014	.0008	.0008	.0014	.0010	.0010	.0010	.0010	.0010	.0012	.0015	.0012	.0012	.0015
3/8"	.0019	.0021	.0019	.0019	.0021	.0013	.0015	.0013	.0013	.0015	.0020	.0025	.0020	.0020	.0025
1/2"	.0025	.0028	.0025	.0025	.0028	.0016	.0020	.0016	.0016	.0020	.0025	.0035	.0025	.0025	.0035
3/4"	.0029	.0035	.0029	.0029	.0035	.0022	.0025	.0022	.0022	.0025	.0032	.0045	.0032	.0032	.0045
1"	.0033	.0040	.0033	.0033	.0040	.0024	.0030	.0024	.0024	.0030	.0040	.0050	.0040	.0040	.0050

IPT (in/tooth)

3400 HARMON-I-CUT - METRIC

3400 Series Harmon-i-cut End Mill is designed to maximize tool life and optimize metal removal rates.

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

FULLERTON® SPEEDS / FEEDS

	Cast Iron					Hardened 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)	76	76	76	160	160	30	30	45	91	91	60	60	91	182	182
Axial Depth	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (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	.0127	.0178	.0127	.0127	.0178	.0051	.0152	.0051	.0051	.0152	.0051	.0178	.0051	.0051	.0178
6	.0254	.0305	.0254	.0254	.0305	.0203	.0305	.0203	.0203	.0305	.0254	.0356	.0254	.0254	.0356
10	.0508	.0508	.0508	.0508	.0508	.0305	.0457	.0305	.0305	.0457	.0508	.0533	.0508	.0508	.0533
12	.0635	.0711	.0635	.0635	.0711	.0508	.0635	.0508	.0508	.0635	.0635	.0711	.0635	.0635	.0711
20	.0762	.0889	.0762	.0762	.0889	.0635	.0889	.0635	.0635	.0889	.0762	.0889	.0762	.0762	.0889
25	.0889	.1143	.0889	.0889	.1143	.0889	.1016	.0889	.0889	.1016	.0889	.1016	.0889	.0889	.1016

	Stainless Steels					Super Alloys (Nickel based, Inconel)					Titanium				
	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish	Slotting	Plunge/ Ramp	Rough/ Profile	HEM	Finish
SMM (m/min)	60	60	76	91	91	22	22	22	38	38	30	30	38	60	60
Axial Depth	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (1xD)	< (1xD)	< (1xD)	1.5xD	full	< (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	.0051	.0178	.0051	.0051	.0178	.0051	.0076	.0051	.0051	.0076	.0051	.0102	.0051	.0051	.0102
6	.0203	.0356	.0203	.0203	.0356	.0254	.0254	.0254	.0254	.0254	.0305	.0381	.0305	.0305	.0381
10	.0483	.0533	.0483	.0483	.0533	.0330	.0381	.0330	.0330	.0381	.0508	.0635	.0508	.0508	.0635
12	.0635	.0711	.0635	.0635	.0711	.0406	.0508	.0406	.0406	.0508	.0635	.0889	.0635	.0635	.0889
20	.0737	.0889	.0737	.0737	.0889	.0559	.0635	.0559	.0559	.0635	.0813	.1143	.0813	.0813	.1143

MMPT (mm/tooth)