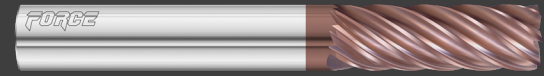


# 3600 FORCE - IMPERIAL



3600 Series Force End Mill designed for optimal performance in high spindle speed and feed rates.

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

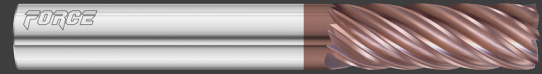
**FULLERTON®**  
**SPEEDS / FEEDS**

	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
SFM (ft/min)				525	525				170	170				800	800
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"				.0005	.0007				.0006	.0007				.0007	.0009
1/4"				.0010	.0012				.0012	.0014				.0015	.0018
3/8"				.0020	.0020				.0018	.0020				.0020	.0022
1/2"				.0025	.0028				.0020	.0022				.0022	.0024
3/4"				.0030	.0035				.0024	.0026				.0026	.0028
1"				.0035	.0045				.0025	.0027				.0028	.0030
	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
SFM (ft/min)				500	500				170	170				500	500
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/8"				.0007	.0010				.0004	.0008				.0004	.0010
1/4"				.0015	.0015				.0008	.0010				.0008	.0018
3/8"				.0024	.0026				.0013	.0020				.0012	.0025
1/2"				.0026	.0028				.0019	.0025				.0016	.0035
3/4"				.0028	.0032				.0025	.0040				.0020	.0045
1"				.0030	.0035				.0027	.0045				.0028	.0050

IPT (in/tooth)

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# 3600 FORCE - METRIC



3600 Series Force End Mill designed for optimal performance in high spindle speed and feed rates.

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**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)				160	160				51	51				243	243
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	-	-		.0127	.0178	-	-		.0152	.0178	-	-		.0178	.0229
6	-	-		.0254	.0305	-	-		.0305	.0356	-	-		.0381	.0457
10	-	-		.0508	.0508	-	-		.0457	.0508	-	-		.0508	.0559
12	-	-		.0635	.0711	-	-		.0508	.0559	-	-		.0559	.0610
20	-	-		.0762	.0889	-	-		.0610	.0660	-	-		.0660	.0711
25	-	-		.0889	.1143	-	-		.0635	.0686	-	-		.0711	.0762
	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)				152	152				51	51				152	152
Axial Depth	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)	< (1xD)	full	< (2xD)	full	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
3	-	-		.0178	.0254	-	-		.0102	.0203	-	-		.0102	.0254
6	-	-		.0381	.0381	-	-		.0203	.0254	-	-		.0203	.0457
10	-	-		.0610	.0660	-	-		.0330	.0508	-	-		.0305	.0635
12	-	-		.0660	.0711	-	-		.0483	.0635	-	-		.0406	.0889
20	-	-		.0711	.0813	-	-		.0635	.1016	-	-		.0508	.1143
25	-	-		.0762	.0889	-	-		.0686	.1143	-	-		.0711	.1270

MMPT (mm/tooth)

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