



3215 Series 2-Flute End Mill is offered in an extensive variety of configurations.

	Low Si Aluminum (<10%) (1100-1500) SFM (ft/min)					Brass & Copper (400-600) SFM (ft/min)					Cast Iron (250-400) 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"	.0039	.0051	.0039	.0051	.0039	.0004	.0006	.0004	.0006	.0004	.0004	.0008	.0004	.0008	.0004
1/4"	.0042	.0059	.0042	.0059	.0042	.0008	.0012	.0008	.0012	.0008	.0008	.0020	.0008	.0020	.0008
3/8"	.0046	.0068	.0046	.0068	.0046	.0020	.0025	.0020	.0025	.0020	.0018	.0036	.0018	.0036	.0018
1/2"	.0050	.0077	.0050	.0077	.0050	.0033	.0036	.0033	.0036	.0033	.0025	.0049	.0025	.0049	.0025
3/4"	.0055	.0088	.0055	.0088	.0055	.0045	.0049	.0045	.0049	.0045	.0033	.0060	.0033	.0060	.0033
1"	.0059	.0098	.0059	.0098	.0059	.0059	.0062	.0059	.0062	.0059	.0039	.0071	.0039	.0071	.0039

IPT (in/tooth)

	Steels (200-500) SFM (ft/min)					Stainless Steels (130-260) SFM (ft/min)					Super Alloys (Nickel Based, Inconel) (25-115) 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"	.0004	.0006	.0004	.0006	.0004	.0002	.0004	.0002	.0004	.0002	.0002	.0004	.0002	.0004	.0002
1/4"	.0012	.0017	.0012	.0018	.0012	.0006	.0008	.0006	.0008	.0006	.0004	.0008	.0004	.0008	.0004
3/8"	.0022	.0030	.0022	.0030	.0022	.0010	.0012	.0010	.0012	.0010	.0006	.0011	.0006	.0011	.0006
1/2"	.0030	.0045	.0030	.0045	.0030	.0014	.0018	.0014	.0018	.0014	.0008	.0015	.0008	.0015	.0008
3/4"	.0039	.0060	.0039	.0060	.0039	.0017	.0024	.0017	.0024	.0017	.0010	.0018	.0010	.0018	.0010
1"	.0047	.0071	.0047	.0071	.0047	.0020	.0031	.0020	.0031	.0020	.0012	.0020	.0012	.0020	.0012

IPT (in/tooth)

	Titanium (35-330) SMM (ft/min)				
	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	Full	Full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
1/8"	.0002	.0004	.0002	.0004	.0002
1/4"	.0006	.0010	.0006	.0010	.0006
3/8"	.0010	.0016	.0010	.0016	.0010
1/2"	.0014	.0022	.0014	.0022	.0014
3/4"	.0017	.0026	.0017	.0026	.0017
1"	.0020	.0031	.0020	.0031	.0020

IPT (in/tooth)

Not Recommended for High Si Aluminum (>10%), Composites, Plastics, Graphite, or Hardened Steels > 48RC.

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



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	Low Si Aluminum (<10%) (335-457) SMM (m/min)					Brass & Copper (121-182) SMM (m/min)					Cast Iron (76-121)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	.0991	.1295	.0991	.1295	.0991	.0102	.0152	.0102	.0152	.0102	.0102	.0203	.0102	.0203	.0102
6	.1067	.1499	.1067	.1499	.1067	.0203	.0305	.0203	.0305	.0203	.0203	.0508	.0203	.0508	.0203
10	.1168	.1727	.1168	.1727	.1168	.0508	.0635	.0508	.0635	.0508	.0457	.0914	.0457	.0914	.0457
12	.1270	.1956	.1270	.1956	.1270	.0838	.0914	.0838	.0914	.0838	.0635	.1245	.0635	.1245	.0635
20	.1397	.2235	.1397	.2235	.1397	.1143	.1245	.1143	.1245	.1143	.0838	.1524	.0838	.1524	.0838
25	.1499	.2489	.1499	.2489	.1499	.1499	.1575	.1499	.1575	.1499	.0991	.1803	.0991	.1803	.0991

IPT (in/tooth)

	Steels (60-152) SMM (m/min)					Stainless Steels (39-79) SMM (m/min)					Super Alloys (Nickel Based, Inconel) (7-35) 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	.0152	.0102	.0152	.0102	.0051	.0102	.0051	.0102	.0051	.0051	.0102	.0051	.0102	.0051
6	.0305	.0432	.0305	.0457	.0305	.0152	.0203	.0152	.0203	.0152	.0102	.0203	.0102	.0203	.0102
10	.0559	.0762	.0559	.0762	.0559	.0254	.0305	.0254	.0305	.0254	.0152	.0279	.0152	.0279	.0152
12	.0762	.1143	.0762	.1143	.0762	.0356	.0457	.0356	.0457	.0356	.0203	.0381	.0203	.0381	.0203
20	.0991	.1524	.0991	.1524	.0991	.0432	.0610	.0432	.0610	.0432	.0254	.0457	.0254	.0457	.0254
25	.1194	.1803	.1194	.1803	.1194	.0508	.0787	.0508	.0787	.0508	.0305	.0508	.0305	.0508	.0305

IPT (in/tooth)

	Titanium (10-100) SMM (m/min)				
	Slotting	Plunge	Rough	Finish	Pocket
Axial Depth	< (1xD)	< (1xD)	1.5xD	1xD	< (1xD)
Radial Width	Full	Full	(.3-.5)xD	(.010-.015)	(.3-.5)xD
3	.0051	.0102	.0051	.0102	.0051
6	.0152	.0254	.0152	.0254	.0152
10	.0254	.0406	.0254	.0406	.0254
12	.0356	.0559	.0356	.0559	.0356
20	.0432	.0660	.0432	.0660	.0432
25	.0508	.0787	.0508	.0787	.0508

IPT (in/tooth)

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