TiMILL 3116/6 FLUTE

22
Ti
Titanium
47.867

INDUSTRY EXCLUSIVE TITANIUM DESIGN.

SQUARE

CORNER RADIUS

CENTER CUTTING

FCI3
COATING

SD
STB
TOOL LENGTH

6

CONSISTENT CUTTING EDGES that resist fatigue and micro-chipping.

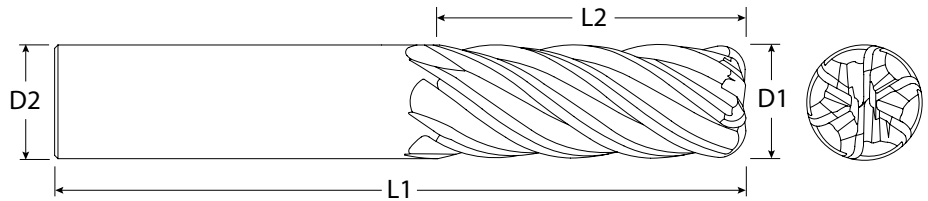
CUTTING EDGES PERFORM at higher speeds with longer times in-cut for added value.

PRODUCES IMPROVED SURFACE FINISHES, higher quality parts, and stable cutting permitting more aggressive feeds and speeds.

INCREASED CORE FOR STRENGTH AND STABILITY in-cut. Maximum edge strength and high flute count make it a durable and long-lasting tool.

UNSURPASSED PERFORMANCE in High Efficiency Milling (HEM)

CENTER CUTTING



CUTTER TOLERANCE
+.000"/-.002
+0.000MM/-0.050MM
h6 shank tolerance

D1	L2	D2	L1	SQ	.010 R	.020 R	.030 R	.060 R	.120 R
1/4	3/8	1/4	2½			29100			
	3/4	1/4	2½	29000		29101	29102	29103	
3/8	1/2	3/8	2½			29104	29105	29106	29107
	1.0	3/8	3.0	29001	29108	29109	29110	29111	
1/2	5/8	1/2	2½				29112	29113	
	1.0	1/2	3.0	29002		29114	29115	29116	29117
	1¼	1/2	4.0				29118	29119	29120
5/8	3/4	5/8	3.0				29133		
	1⅝	5/8	3½	29003			29121	29122	29123
3/4	1.0	3/4	4.0				29124	29125	29126
	1⅝	3/4	4.0	29004			29127	29128	29129
1.0	2.0	1.0	4½	29005			29130	29131	29132

FULLERTON TOOL COMPANY

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SPEEDS / FEEDS

	TITANIUM				
	Slotting	Plunge/Ramp	Rough/Profile	HEM	Finish
SFM (ft/min)	200	200	300	325	325
Axial Depth	< (1xD)	full	< (2xD)	< (2xD)	< (2xD)
Radial Width	full	full	(.25-.3)xD	(.1-.25)xD	(.05-.08)xD
1/4”	.0008	.0010	.0008	.0008	.0010
3/8”	.0010	.0015	.0010	.0010	.0015
1/2”	.0015	.0020	.0015	.0015	.0020
3/4”	.0020	.0025	.0020	.0020	.0025
1”	.0032	.0035	.0032	.0032	.0035

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.
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.

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