

# MATRX

## 5500 Series - MATRX EM-1 End Mills

5500 Series EM-1 End Mills allow for high shear and low cutting forces that provide a clean edge without fibers.

Flute Diameter	Carbon, Carbon Graphite, Unfilled Plastics		Composites		Fiber Reinforced Plastics		Green Ceramics, Green Carbide	
	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR
1/8"	1000-3200	.0003-.0006	700-2800	.0002-.0005	1000-2800	.0004-.0008	800-1600	.0002-.0005
3/16"	1000-2800	.0004-.0008	700-2800	.0003-.0007	1000-2800	.0005-.001	800-1600	.0002-.0005
1/4"	1000-2800	.0008-.0013	700-2800	.0007-.0012	1000-2800	.0008-.002	800-1600	.0004-.0007
5/16"	1000-2800	.0010-.0017	700-2800	.001-.0015	1000-2800	.0025-.004	800-1600	.0008-.0014
3/8"	1000-2800	.0010-.0025	700-2800	.0015-.0025	1000-3200	.003-.0055	800-1600	.0008-.0018
1/2"	1000-2800	.0015-.004	700-2800	.002-.004	1000-3200	.005-.007	800-1600	.001-.0025

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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