



APPLICATION SHEET

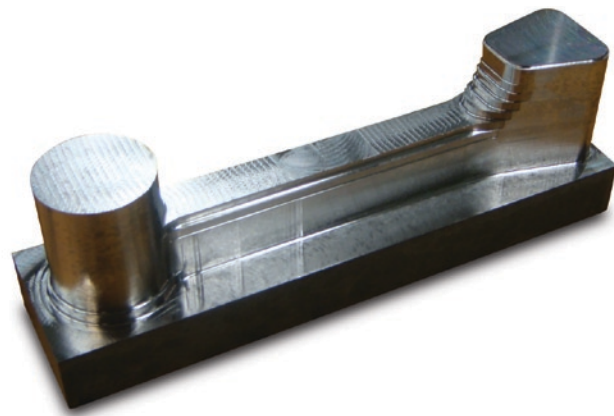
17-4ph Stainless Steel

THE TOOL

Helical

Helical Solutions LLC

29 Sanford Drive
Gorham, Maine 04038
Phone 1.866.543.5422
Fax 1.866.350.5968
www.1helical.com



THE TOOLPATH

POWERED BY

VoluMill™

Celeritive Technologies, Inc.

28248 N. Tatum Blvd. B-1, Suite 148
Cave Creek, Arizona 85331
Phone 1.888.253.6701
Fax 1.888.253.6701
www.volumill.com

APPLICATION PARAMETERS

Material	17-4ph (32 Rc.)
Coolant	Dry with no air
Toolpath	VoluMill™ (3-Axis)
Endmill Used	Helical Solutions (5-Flute Variable Pitch) HEVR-SR-30500-R-3 (edp#34272)
Endmill Dimensions	1/2" x 1/2" x 1" x 3" with .030 corner radii
Machine	HAAS® Super VF3 40 Taper
Tool Holder	ER32
SFM	780
RPM	6,000
CLPT	.0026
IPM	80
ADOC	.500
RDOC	.0625
Ramping	Outside entry method
MRR	2.50 cu.in./min.
Tool Life	After 7 parts, tool still looked great
Spindle Load	Less than 20%