



APPLICATION SHEET

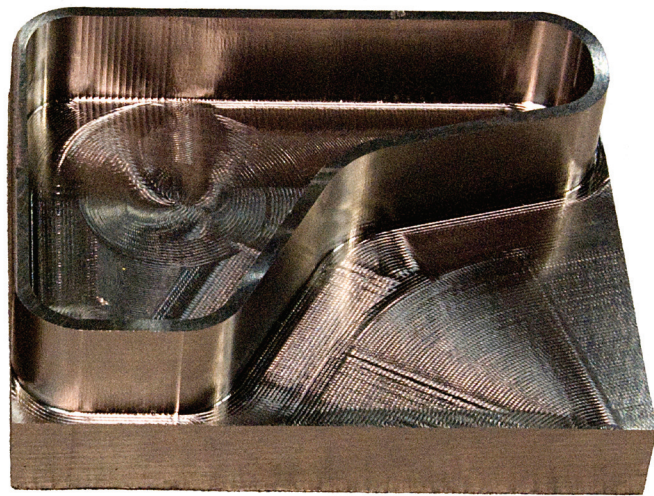
6Al4V Titanium

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	6Al4V Titanium
Coolant	Water-soluble flood
Toolpath	VoluMill™
Endmill Used	Helical Solutions (5-Flute): HEVR-R-50500-R-3
Endmill Dimensions	1/2" x 1/2" x 1.25" x 3" with .030 corner radii
Machine	Milltronics® VM20
Tool Holder	Milling chuck
SFM	500
RPM	3,820
CLPT	.0066
IPM	126
ADOC	1.000
RDOC	.035
Material Entry	Helical at 20 ipm / 3°
MRR	4.41 cu.in./min.
Spindle Load	Less than 10%