



## APPLICATION SHEET

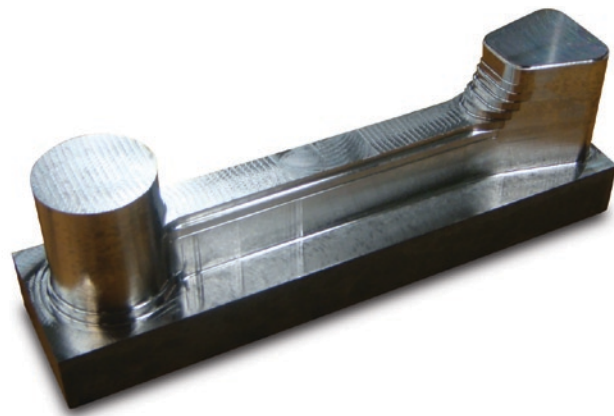
# 17-4ph Stainless Steel

### 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

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