



APPLICATION SHEET

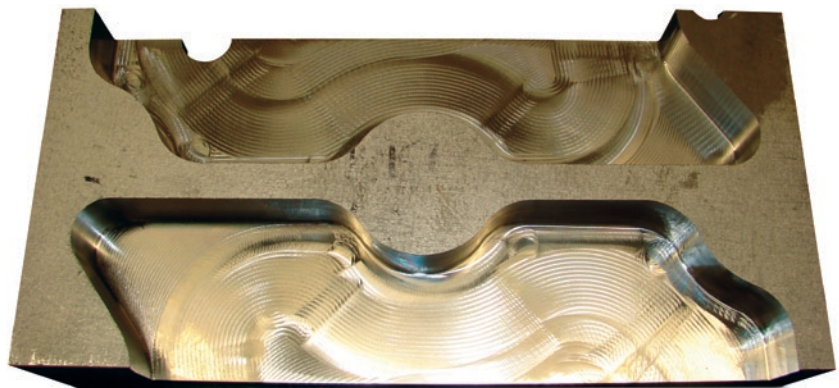
304 Stainless Steel (110 ipm)

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	304 Stainless Steel
Coolant	Dry with air blast
Toolpath	VoluMill™
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® EC400 Direct Drive HMC 12k/1000 ipm
Tool Holder	Milling chuck
SFM	1,144
RPM	8,800
CLPT	.0018
IPM	110
ADOC	.500
RDOC	.0625
Ramping	None—part was produced with side entry
MRR	3.43 cu.in./min.