



APPLICATION SHEET

6061-T6 Aluminum

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	6061-T6 Aluminum
Coolant	Water-soluble flood
Toolpath	VoluMill™
Endmill Used	Helical Solutions (3-Flute) HAL-C-SR-30500-R-0 (edp#29390)
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	1,560
RPM	12,000
CLPT	.0277
IPM	1,000
ADOC	.500
RDOC	.200
Ramping	Helical ramping to .500 depth at 300 ipm / 3° / 12k
MRR	100 cu.in./min.
Tool Life	Undetermined—after 5 parts tool still looked new
Spindle Load	Less than 10%