



APPLICATION SHEET

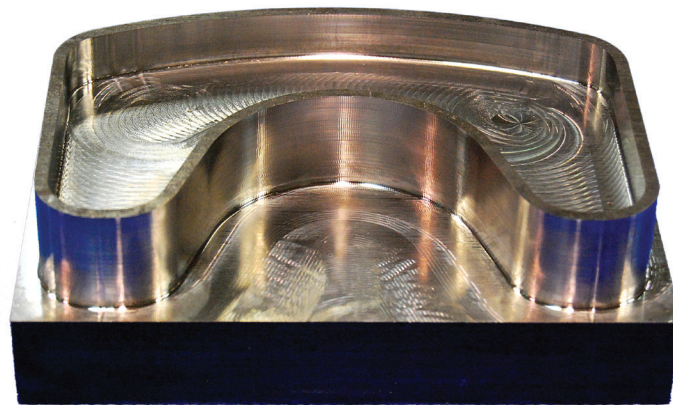
4140 Steel

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



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	4140 Steel
Coolant	Dry with no air
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® VM22
Tool Holder	Milling chuck
SFM	1,300
RPM	10,000
CLPT	.0050
IPM	250
ADOC	1.000
RDOC	.030
Material Entry	Helical at 50 ipm / 5°
MRR	7.50 cu.in./min.
Spindle Load	Less than 10%