



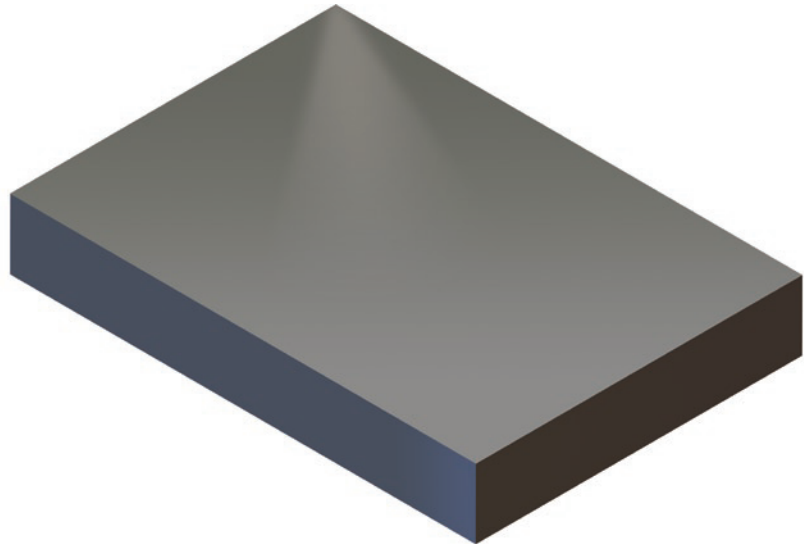
## SPEED / FEED DATA SHEET

## Steel 1018

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## GETTING THE BEST PERFORMANCE

Getting the best performance from VoluMill™ toolpaths requires using more aggressive machining parameters than you may be used to. This data sheet provides some examples of parameters used for milling 1018 steel. This data is from tests performed by Celeritive Technologies, Inc., independent research facilities, and existing customers using VoluMill on a daily basis in their shops. No two machining environments are exactly alike, so you may need to adjust your parameters accordingly, but these numbers have worked well for others.



MACHINE	TOOL	TOOL DIAM.	DOC	STEPOVER	SPINDLE SPEED	PROGRAMMED FEEDRATE*
HAAS ° VF0	Sandvik Coro Mill ° 490 3 Insert	1.000	0.150	0.300	4,583 RPM	110 IPM
HAAS ° VF2 SS	Sandvik Coro Mill 490 3 Insert	1.000	0.150	0.300	4,583 RPM	154 IPM
HAAS ° VF4 SS	DATA FLUTE CNC™ SS DH-C-405004 Flute	0.500	0.500	0.125	3,500 RPM	75 IPM
HAAS VF4 SS	DATA FLUTE CNC SS DH-C-405004 Flute	0.500	0.250	0.125	5,000 RPM	110 IPM
HAAS VF4 SS	DATA FLUTE CNC SS DH-C-405004 Flute	0.500	0.038	0.500	9,000 RPM	275 IPM

\* VoluMill™ dynamically and automatically adjusts feed rates and/or axial depths of cut to manage the material removal rate. All feedrate adjustments are based on the programmed feedrate.