

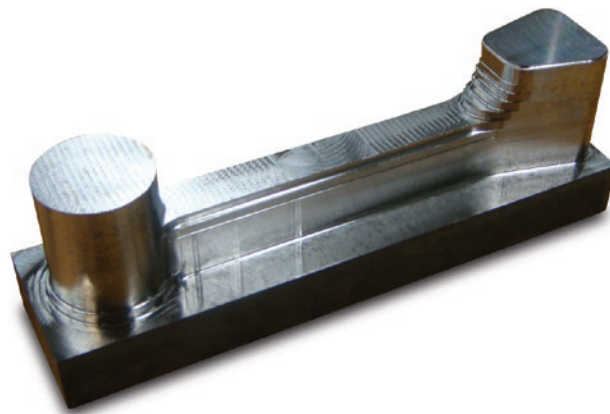


APPLICATION SHEET

# 17-4ph Stainless Steel

THE TOOL

**Helical** 



POWERED BY  
**VoluMill™**

Swoosh Technologies  
1422 Elbridge Payne,  
Suite 230  
Chesterfield, MO 63017  
Local (314) 549-8110  
Toll Free (888) 318-5104  
[www.swooshtech.com](http://www.swooshtech.com)

APPLICATION PARAMETERS

Material	17-4ph (32 Rc.)
Coolant	Dry with no air
Toolpath	VoluMill™ (3-Axis)
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® Super VF3 40 Taper
Tool Holder	ER32
SFM	780
RPM	6,000
CLPT	.0026
IPM	80
ADOC	.500
RDOC	.0625
Ramping	Outside entry method
MRR	2.50 cu.in./min.
Tool Life	After 7 parts, tool still looked great
Spindle Load	Less than 20%

For more information and to take advantage of the 15-day free trial offer visit the Swoosh Technologies website at [www.swooshtech.com](http://www.swooshtech.com)