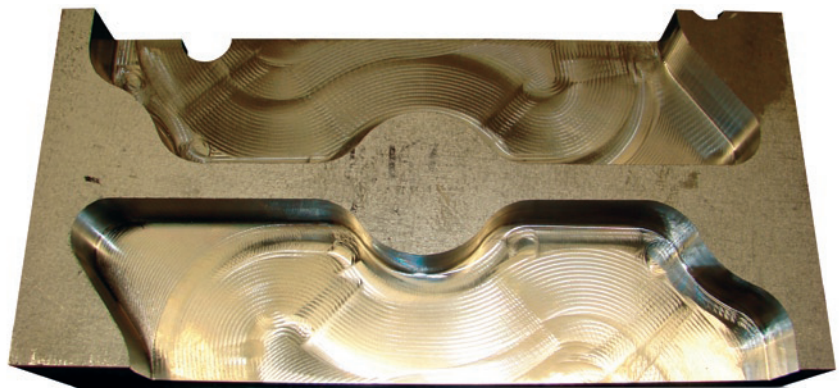




APPLICATION SHEET

304 Stainless Steel (110 ipm)



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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. |