

Flute Grinding Carbide End Mills

Application	5/8" 4 Flute 30 degree Helix End Mills		
Machine Type	Walter CNC Tool Grinder (Power Machine)		
Wheel Type	1A1TR5.00" x 5/8" x 1 1/4" ASD 230/270 R100 BPF M-2 x = 3/8		
Grinding Parameters			
<u>Tool Info</u>		<u>Machine info</u>	
Diameter	0.625"	Coolant Type	Synthetic Oil
Length of Cut	3.100"	Grinding wheel Vs Wheel speed	3,300 SFM (16.5 ms)
Helix	30 degree	Feed rate	3.5 IPM
No. of flutes	4 flutes	Depth of cut	0.125 inches
No. of passes	2/Flute	Motor Load	8 – 14 % amps
		Cycle time for completed Part	14' 45"
		Note: 14 '45" includes 2 pass fluting, OD, end, and gashing	
Frequency use of dressing stick		Every 10 work pieces	
Frequency of truing. 1 time at set up		Per 200 pc lot size	