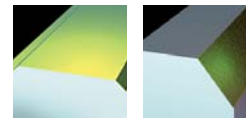
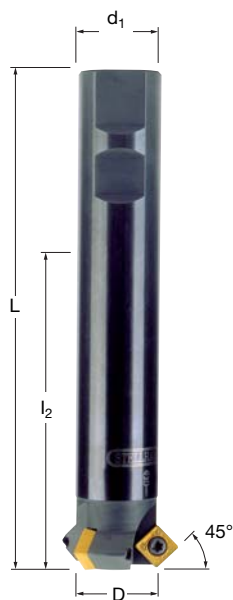


7745 VS 09 Milling Cutter



7745 VS 09 Weldon Shank

EDP #	Part Number	Dimensions (inch)						No. of Inserts	Spares		
		D	L	l_2	d_1	a	EDP#		EDP#	EDP#	
015422	C7745VS09WA.625R3.30	0.625	5.300	3.300	0.625	0.200	2	015262	D4010T	015240	T15
015423	C7745VS09WA.750R3.30	0.750	5.300	3.300	0.750	0.200	2	015262	D4010T	015240	T15
015424	C7745VS09WA1.00R3.70	1.000	6.000	3.700	1.00	0.200	3	015262	D4010T	015240	T15



Weldon Shank



7745 VS 09 Technical Advice

Milling Cutter Order Example: **C7745VS09WA.750R3.30**
 Milling Insert Order Example: **SCMT09T308EN -41 MP91M**
 For complete cutting conditions refer to page: **208**

Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0.707)

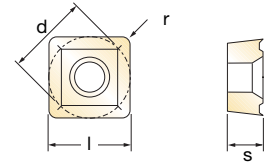
$$\text{ie: } \frac{h_m}{0.707} \quad \text{or} \quad \frac{0.004''}{0.707} = 0.0056 \text{ in. programmed feed rate}$$



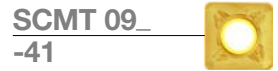
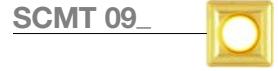
Depth of Cut (a)



Inserts for 7745 VS 09



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017703	SCMT09T308E	SF30				0.375	0.375	0.156	0.031	0.0059
018188	SCMT09T308E	SFZ				0.375	0.375	0.156	0.031	0.0059
024062	SCMT09T308E	X44				0.375	0.375	0.156	0.031	0.0059
025852	SCMT09T304T	SF30				0.375	0.375	0.156	0.016	0.0059
015225	SCMT09T308T	PFZ				0.375	0.375	0.156	0.031	0.0059
017704	SCMT09T308T	SF30				0.375	0.375	0.156	0.031	0.0059
017705	SCMT09T308T	SFZ				0.375	0.375	0.156	0.031	0.0059
015224	SCMT09T308T	X44				0.375	0.375	0.156	0.031	0.0059
017315	SCMT09T308EN-41	MP91M		◆	◆	0.375	0.375	0.156	0.031	0.0016
024107	SCMT09T308EN-41	PFZ				0.375	0.375	0.156	0.031	0.0016
015147	SCMT09T308EN-41	X500		◆	◆	0.375	0.375	0.156	0.031	0.0016
027731	SCMT09T308EN-41	SP6564		◆	◆	0.375	0.375	0.156	0.031	0.0016
018198	SCMW09T304E	GH1				0.375	0.375	0.156	0.016	0.0012
018199	SCMW09T308E	GH1				0.375	0.375	0.156	0.031	0.0012



SC_09 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)
◆ Unalloyed Steels	-	-	-	730 - 850	0.002 - 0.006	0.04 - 0.20	-	-	-
◆ Alloyed Steels	-	-	-	330 - 490	0.002 - 0.005	0.04 - 0.20	-	-	-
◆ Stainless Steels	-	-	-	460 - 590	0.002 - 0.005	0.04 - 0.20	-	-	-
◆ PH Stainless	-	-	-	230 - 270	0.002 - 0.003	0.04 - 0.20	-	-	-
◆ Cast Irons	-	-	-	600 - 980	0.002 - 0.005	0.04 - 0.20	-	-	-
◆ Aluminum & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	120 - 160	0.002 - 0.003	0.04 - 0.20	-	-	-
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations						
	P	Unalloyed Steels	M	Stainless Steels	K	Cast Irons
	P	Alloyed Steels	M	PH Stainless	N	Aluminum & Alloys
					S	High Temp. Alloys
					H	Hard Materials