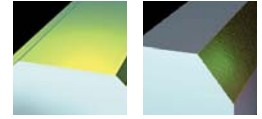


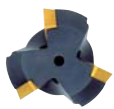
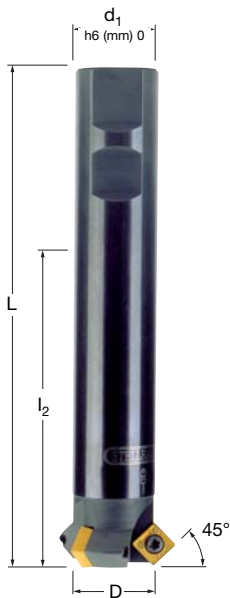


7745 VS 09 Milling Cutter



7745 VS 09 Weldon Shank

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares		
		D	L	l_2	d_1	$a_{max.}$	EDP#		 EDP#	 EDP#	
021762	7745VS 09 WA016R085	16	135	85	16	5	2	015262	D4010T	015240	T15
021763	7745VS 09 WA020R085	20	135	85	20	5	2	015262	D4010T	015240	T15
021764	7745VS 09 WA025R095	25	150	95	25	5	3	015262	D4010T	015240	T15



Weldon Shank



Depth of Cut (a)



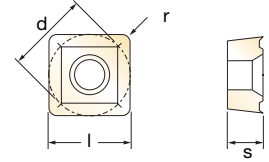
7745 VS 09 Technical Advice

Milling Cutter Order Example: **7745VS09WA016R085**
 Milling Insert Order Example: **SCMT09T308EN -41 MP91M**
 For complete cutting conditions refer to page: **264**

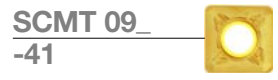
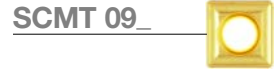
Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0,707)

$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$

Inserts for 7745 VS 09



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017703	SCMT 09 T308E	SF30				9,52	9,52	3,97	0,8	0,15
018188	SCMT 09 T308E	SFZ				9,52	9,52	3,97	0,8	0,15
024062	SCMT 09 T308E	X44				9,52	9,52	3,97	0,8	0,15
025852	SCMT 09 T304T	SF30				9,52	9,52	3,97	0,4	0,15
015225	SCMT 09 T308T	PFZ				9,52	9,52	3,97	0,8	0,15
017704	SCMT 09 T308T	SF30				9,52	9,52	3,97	0,8	0,15
017705	SCMT 09 T308T	SFZ				9,52	9,52	3,97	0,8	0,15
015224	SCMT 09 T308T	X44				9,52	9,52	3,97	0,8	0,15
017315	SCMT 09 T308EN-41	MP91M		◆	◆	9,52	9,52	3,97	0,8	0,04
024107	SCMT 09 T308EN-41	PFZ				9,52	9,52	3,97	0,8	0,04
015147	SCMT 09 T308EN-41	X500		◆	◆	9,52	9,52	3,97	0,8	0,04
027731	SCMT 09 T308EN-41	SP6564		◆	◆	9,52	9,52	3,97	0,8	0,04
018198	SCMW 09 T304E	GHI				9,52	9,52	3,97	0,4	0,03
018199	SCMW 09 T308E	GHI				9,52	9,52	3,97	0,8	0,03



SC_09 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)
◆ Unalloyed Steels	-	-	-	220 - 260	0,05 - 0,15	1,0 - 5,0	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,05 - 0,12	1,0 - 5,0	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,05 - 0,12	1,0 - 5,0	-	-	-
◆ PH Stainless	-	-	-	70 - 85	0,05 - 0,08	1,0 - 5,0	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,05 - 0,12	1,0 - 5,0	-	-	-
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	35 - 50	0,05 - 0,08	1,0 - 5,0	-	-	-
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations								
	◆	Unalloyed Steels	◆	Stainless Steels	◆	Cast Irons	◆	High Temp. Alloys
	◆	Alloyed Steels	◆	PH Stainless	◆	Aluminium & Alloys	◆	Hard Materials