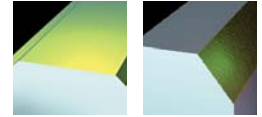
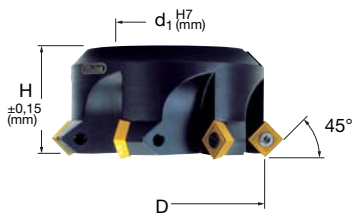


7745 VS 12 Milling Cutter



7745 VS 12 Shell Mill Fixation

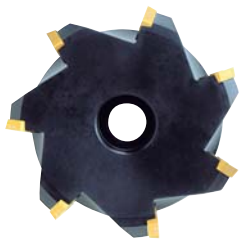
EDP #	Part Number	Dimensions (mm)				No. of Inserts	Spares			
		D	H	d ₁	a _{max.}		EDP#	EDP#	EDP#	
021765	7745VS 12 -A040R	40	32	16	7	4	015266	D5013T	015241	T20
021766	7745VS 12 -A050R	50	40	22	7	4	015266	D5013T	015241	T20
021767	7745VS 12 -A063R	63	40	22	7	5	015266	D5013T	015241	T20
021768	7745VS 12 -A080R	80	50	27	7	6	015266	D5013T	015241	T20
021769	7745VS 12 -A100R	100	50	32	7	7	015266	D5013T	015241	T20
021770	7745VS 12 -A125R	125	63	40	7	8	015266	D5013T	015241	T20



7745 VS 12 Technical Advice



Milling Cutter Order Example: **7745VS12-A050R**
 Milling Insert Order Example: **SCMT12M512EN -41 MP91M**
 For complete cutting conditions refer to page: **264**



Shell Mill Fixation

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

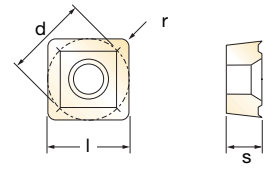
$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$



Depth of Cut (a)



Inserts for 7745 VS 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017312	SCCT 12 M5ACER	MP91M	▼	▼	▼	12,7	12,7	5,0	Facet	0,03
025811	SCCT 12 M5ACTR	SP4036		◆	◆◆◆◆	12,7	12,7	5,0	Facet	0,15
017695	SCCT 12 M5ACTR	GH1			◆◆◆◆	12,7	12,7	5,0	Facet	0,15
017693	SCCT 12 M5ACTR	SF30				12,7	12,7	5,0	Facet	0,15
017696	SCCT 12 M5ACTR	SFZ				12,7	12,7	5,0	Facet	0,15
017694	SCCT 12 M5ACTR	X44				12,7	12,7	5,0	Facet	0,15
017697	SCHT 12 M5ACTN	PFZ		◆◆		12,7	12,7	5,0	Facet	0,15
017698	SCHT 12 M5ACTN	X500		◆		12,7	12,7	5,0	Facet	0,15
015144	SCKT 12 M5ACSN-41	X500	◆			12,7	12,7	5,0	Facet	0,12
017314	SCKT 12 M5ACSN-41	MP91M	◆◆			12,7	12,7	5,0	Facet	0,12
017699	SCKT 12 M5ACSN-41	PFZ	◆◆			12,7	12,7	5,0	Facet	0,12
024083	SCKT 12 M5ACSN-41	SF30	◆◆			12,7	12,7	5,0	Facet	0,12
017706	SCMT 12 M508E	SF30				12,7	12,7	5,0	0,8	0,15
024944	SCMT 12 M508E	X44				12,7	12,7	5,0	0,8	0,15
017707	SCMT 12 M512E	SF30				12,7	12,7	5,0	1,2	0,15
017709	SCMT 12 M512T	GH1				12,7	12,7	5,0	1,2	0,15
017316	SCMT 12 M512T	MP91M				12,7	12,7	5,0	1,2	0,15
015227	SCMT 12 M512T	PFZ				12,7	12,7	5,0	1,2	0,15
017708	SCMT 12 M512T	SF30				12,7	12,7	5,0	1,2	0,15
017710	SCMT 12 M512T	SFZ				12,7	12,7	5,0	1,2	0,15
015228	SCMT 12 M512T	X44				12,7	12,7	5,0	1,2	0,15
024129	SCMT 12 M512T	X500				12,7	12,7	5,0	1,2	0,12
017317	SCMT 12 M512EN-41	MP91M				12,7	12,7	5,0	1,2	0,05
024108	SCMT 12 M512EN-41	PFZ				12,7	12,7	5,0	1,2	0,05
015226	SCMT 12 M512EN-41	X500				12,7	12,7	5,0	1,2	0,05
027732	SCMT 12 M512EN-41	SP6564				12,7	12,7	5,0	1,2	0,05



SC_12 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	180 - 220	0,20 - 0,60	3,5 - 7,0	220 - 260	0,20 - 0,45	1,0 - 3,5	220 - 300	0,15 - 0,28	0,2 - 1,0
◆ Alloyed Steels	70 - 110	0,20 - 0,45	3,5 - 7,0	100 - 150	0,20 - 0,40	1,0 - 3,5	100 - 195	0,15 - 0,28	0,2 - 1,0
◆ Stainless Steels	120 - 140	0,20 - 0,35	3,5 - 7,0	140 - 180	0,15 - 0,30	1,0 - 3,5	180 - 230	0,15 - 0,28	0,2 - 1,0
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,15 - 0,40	3,5 - 7,0	180 - 300	0,15 - 0,30	1,0 - 3,5	200 - 350	0,15 - 0,28	0,2 - 1,0
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,06 - 0,12	1,0 - 2,5	50 - 100	0,04 - 0,08	0,2 - 1,0

h_m = average chip thickness

Star Guide Key to Recommended Tools

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