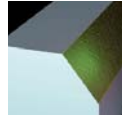


7745 VT 11 Chamfering Cutter



7745 VT 11 Weldon Shank

EDP #	Part Number	Dimensions (mm)							No. of Inserts	Spares		
		D	L	l ₁	d ₁	d ₂	a _{max.}	EDP#		EDP#	EDP#	
023065	7745VT 11 WA016R	16	90	40	16	4	7,7	1	015060	F2505T	015069	T7F



Weldon Shank



7745 VT 11 Technical Advice

Milling Cutter Order Example: **7745VT11WA016R**
 Milling Insert Order Example: **TPMT110204E-M SFZ**
 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)

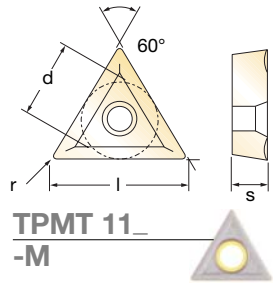
$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$



Depth of Cut (a)



Inserts for 7745 VT 11



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024948	TPMT 11 0204E-M	GH1		◆		6,35	11,0	2,38	0,4	0,03
023503	TPMT 11 0204E-M	SFZ		◆◆◆		6,35	11,0	2,38	0,4	0,03
023504	TPMT 11 0204E-M	X44		◆		6,35	11,0	2,38	0,4	0,03

TP_11 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 - 0,12	1,0 - 7,5	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,05 - 0,10	1,0 - 7,5	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,05 - 0,10	1,0 - 7,5	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,05 - 0,10	1,0 - 7,5	-	-	-
◆ Aluminium & Alloys	-	-	-	400 - 750	0,05 - 0,12	1,0 - 7,5	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ 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	S ◆	High Temp. Alloys
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminium & Alloys	H ◆	Hard Materials