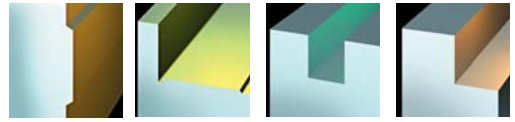






7690 VA 09 Milling Cutter



7690 VA 09 Weldon Shank

EDP #	Part Number	Dimensions (inch)						No. of Inserts	Spares		
		D	L/H	l_2	d_1	a	EDP#		 EDP#	 EDP#	
014869	C7690VA09WA.375R	0.375	2.750	0.800	0.625	0.300	1	015267	F2505TP	018488	T7
014870	C7690VA09WA.500R	0.500	2.900	1.000	0.625	0.300	1	015267	F2505TP	018488	T7
014871	C7690VA09WA.625R	0.625	3.100	1.190	0.625	0.300	2	015268	F2506TP	018488	T7
014872	C7690VA09WA.750R	0.750	3.400	1.370	0.750	0.300	3	015268	F2506TP	018488	T7
014873	C7690VA09WA1.00R	1.000	3.900	1.600	1.000	0.300	4	015268	F2506TP	018488	T7
014874	C7690VA09WA1.25R	1.250	3.900	1.600	1.000	0.300	5	015268	F2506TP	018488	T7

7690 VA 09 Shell Mill Fixation

EDP #	Part Number	D	L/H	l_2	d_1	a	No. of Inserts	EDP#	 EDP#	 EDP#
014866	C7690VA09-A1.50R	1.5	1.26	-	0.5	0.3	6	015268	F2506TP	018488
014867	C7690VA09-A2.00R	2	1.57	-	0.75	0.3	7	015268	F2506TP	018488
014868	C7690VA09-A2.50R	2.5	1.57	-	0.75	0.3	8	015268	F2506TP	018488



Weldon Shank



Shell Mill Fixation

7690 VA 09 Technical Advice

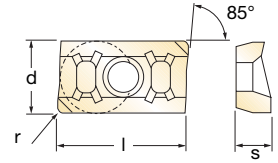
Milling Cutter Order Example: **C7690VA09WA1.00R**
 Milling Insert Order Example: **ADET0903PDFR-441 GH1**
 For complete cutting conditions refer to page: **208**



Depth of Cut (a)



Inserts for 7690 VA 09



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024914	ADET0903PDER-44	MP91M			◆◆	0.250	0.362	0.125	Facet	0.0016
024915	ADET0903PDER-44	PFZ		◆◆	◆◆◆	0.250	0.362	0.125	Facet	0.0016
024916	ADET0903PDFR-441	GH1	◆	◆	◆	0.250	0.362	0.125	Facet	0.0012
017286	ADKT0903PDER-43	MP91M	◆◆			0.250	0.362	0.138	Facet	0.0020
024917	ADKT0903PDER-43	PFZ				0.250	0.362	0.138	Facet	0.0020
015150	ADKT0903PDER-43	X500				0.250	0.362	0.138	Facet	0.0020
027715	ADKT0903PDER-43	SP6564	◆	◆◆		0.250	0.362	0.138	Facet	0.0020
024138	ADKT090310ER-43	X500				0.250	0.362	0.138	0.039	0.0020
024912	ADET090310SR-42	MP91M		◆◆		0.250	0.362	0.125	0.039	0.0039
024913	ADET090310SR-42	X500				0.250	0.362	0.125	0.039	0.0039



AD_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	600 - 720	0.006 - 0.009	0.18 - 0.31	730 - 850	0.005 - 0.010	0.08 - 0.18	730 - 980	0.003 - 0.006	0.01 - 0.08
◆ Alloyed Steels	230 - 360	0.005 - 0.008	0.18 - 0.31	330 - 490	0.004 - 0.007	0.08 - 0.18	330 - 630	0.003 - 0.006	0.01 - 0.08
◆ Stainless Steels	-	-	-	460 - 590	0.003 - 0.005	0.08 - 0.18	600 - 750	0.002 - 0.006	0.01 - 0.08
◆ PH Stainless	-	-	-	230 - 270	0.002 - 0.004	0.08 - 0.18	270 - 320	0.002 - 0.004	0.01 - 0.08
◆ Cast Irons	460 - 910	0.004 - 0.006	0.18 - 0.31	600 - 980	0.004 - 0.005	0.08 - 0.18	660 - 1140	0.002 - 0.006	0.01 - 0.08
◆ Aluminum & Alloys	910 - 1470	0.002 - 0.007	0.18 - 0.31	1320 - 2460	0.002 - 0.006	0.08 - 0.18	2300 - 3280	0.002 - 0.006	0.01 - 0.08
◆ High Temp. Alloys	-	-	-	120 - 160	0.002 - 0.004	0.08 - 0.18	150 - 190	0.002 - 0.004	0.01 - 0.08
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

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