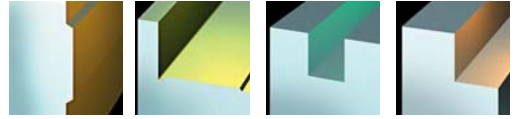


7690 VA 09 Milling Cutter



7690 VA 09 Weldon Shank

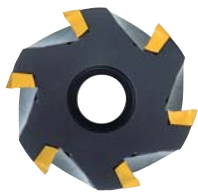
EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares		
		D	L/H	l_2	d_1	$a_{max.}$	EDP#		EDP#	EDP#	
021693	7690VA 09 WA010R	10	68	20	16	8,5	1	015267	F2505TP	018488	T7
021694	7690VA 09 WA012R	12	70	22	16	8,5	1	015267	F2505TP	018488	T7
021695	7690VA 09 WA014R	14	73	25	16	8,5	1	015268	F2506TP	018488	T7
021696	7690VA 09 WA016R	16	75	27	16	8,5	2	015268	F2506TP	018488	T7
021697	7690VA 09 WA018R	18	80	30	20	8,5	2	015268	F2506TP	018488	T7
021698	7690VA 09 WA020R	20	82	32	20	8,5	3	015268	F2506TP	018488	T7
021699	7690VA 09 WA025R	25	96	40	25	8,5	4	015268	F2506TP	018488	T7
023055	7690VA 09 WA032R	32	96	40	25	8,5	5	015268	F2506TP	018488	T7

7690 VA 09 Shell Mill Fixation

EDP #	Part Number	D	L/H	l_2	d_1	$a_{max.}$	No. of Inserts	EDP#	EDP#	EDP#
021690	7690VA 09 -A032R	32	28	-	13	8,5	5	015268	F2506TP	018488
017986	7690VA 09 -A040R	40	32	-	16	8,5	6	015268	F2506TP	018488
021691	7690VA 09 -A050R	50	40	-	22	8,5	7	015268	F2506TP	018488
021692	7690VA 09 -A063R	63	40	-	22	8,5	8	015268	F2506TP	018488



Weldon Shank



Shell Mill Fixation



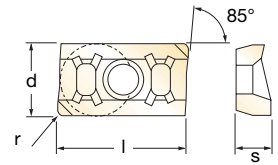
Depth of Cut (a)



7690 VA 09 Technical Advice

Milling Cutter Order Example: **7690VA09WA018R**
 Milling Insert Order Example: **ADET0903PDFR-441 GH1**
 For complete cutting conditions refer to page: **264**

Inserts for 7690 VA 09



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024914	ADET 09 03PDER-44	MP91M			◆◆	6,35	9,2	3,18	Facet	0,04
024915	ADET 09 03PDER-44	PFZ		◆◆	◆◆◆	6,35	9,2	3,18	Facet	0,04
024916	ADET 09 03PDR-441	GH1	◆	◆	◆	6,35	9,2	3,18	Facet	0,03
017286	ADKT 09 03PDER-43	MP91M	◆◆			6,35	9,2	3,5	Facet	0,05
024917	ADKT 09 03PDER-43	PFZ				6,35	9,2	3,5	Facet	0,05
015150	ADKT 09 03PDER-43	X500				6,35	9,2	3,5	Facet	0,05
027715	ADKT 09 03PDER-43	SP6564	◆	◆◆		6,35	9,2	3,5	Facet	0,05
024138	ADKT 09 0310ER-43	X500				6,35	9,2	3,5	1,0	0,05
024912	ADET 09 0310SR-42	MP91M		◆◆		6,35	9,2	3,18	1,0	0,1
024913	ADET 09 0310SR-42	X500				6,35	9,2	3,18	1,0	0,1



AD_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	180 - 220	0,14 - 0,24	4,5 - 8,0	220 - 260	0,12 - 0,26	2,0 - 4,5	220 - 300	0,08 - 0,15	0,2 - 2,0
◆ Alloyed Steels	70 - 110	0,12 - 0,20	4,5 - 8,0	100 - 150	0,10 - 0,18	2,0 - 4,5	100 - 195	0,08 - 0,15	0,2 - 2,0
◆ Stainless Steels	-	-	-	140 - 180	0,08 - 0,12	2,0 - 4,5	180 - 230	0,05 - 0,15	0,2 - 2,0
◆ PH Stainless	-	-	-	70 - 85	0,06 - 0,10	2,0 - 4,5	80 - 100	0,05 - 0,10	0,2 - 2,0
◆ Cast Irons	140 - 280	0,10 - 0,16	4,5 - 8,0	180 - 300	0,10 - 0,12	2,0 - 4,5	200 - 350	0,05 - 0,15	0,2 - 2,0
◆ Aluminium & Alloys	275 - 450	0,05 - 0,18	4,5 - 8,0	400 - 750	0,05 - 0,15	2,0 - 4,5	700 - 1000	0,05 - 0,15	0,2 - 2,0
◆ High Temp. Alloys	-	-	-	35 - 50	0,06 - 0,10	2,0 - 4,5	45 - 60	0,05 - 0,10	0,2 - 2,0
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

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