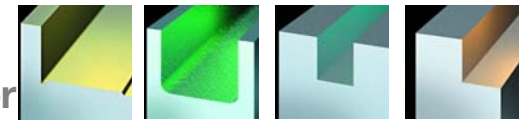
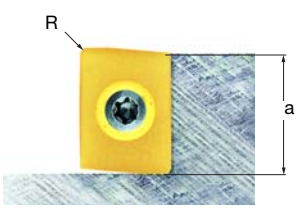
7690 VAF 09 Milling Cutter



7690 VAF 09 Shell Mill Fixation

EDP #	Part Number	Dimensions (inch) D	H	d_1	a	No. of Inserts	Spares EDP#		EDP#	
015411	**C7690VAF09-A1.25R**	1.250	1.100	0.500	0.330	5	015268	F2506TP	018488	T7
015412	**C7690VAF09-A1.50R**	1.500	1.250	0.500	0.330	6	015268	F2506TP	018488	T7
015413	**C7690VAF09-A2.00R**	2.000	1.570	0.750	0.330	7	015268	F2506TP	018488	T7
015414	**C7690VAF09-A2.50R**	2.500	1.570	0.750	0.330	8	015268	F2506TP	018488	T7
015415	**C7690VAF09-A3.00R**	3.000	1.960	1.000	0.330	10	015268	F2506TP	018488	T7

Shell Mill Fixation



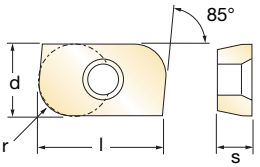
Depth of Cut (a)

7690 VAF 09 Technical Advice

Milling Cutter Order Example: **C7690VAF09-A1.50R**
Milling Insert Order Example: **AOHW0903PFTR-J PFZ**
For complete cutting conditions refer to page: **208**

When using inserts with a radius larger than 0.063 in., the cutter body has to be modified.

Inserts for 7690 VAF 09



AOHW 09_ -J

EDP#	Part Number	Grade	Application & Material ▼ Roughing	▼▼ Semi-Finishing	▼▼▼ Finishing	Dimensions (inch) d	l	s	r	h_m min
015205	AOHW0903PFFR-J	SFZ				0.272	0.362	0.125	Facet	0.0012
023097	AOHW0903PFTR-J	PFZ				0.272	0.362	0.125	Facet	0.0039
015206	AOHW0903PFTR-J	X500		◆◆	◆◆	0.272	0.362	0.125	Facet	0.0039
017289	AOHW0903PFTR-J	MP91M				0.272	0.362	0.125	Facet	0.0039
027717	AOHW0903PFTR-J	SP6564		◆	◆	0.272	0.362	0.125	Facet	0.0039

AOHW 09_ -J

024918	AOHW090302ER-J	PFZ				0.272	0.362	0.125	0.008	0.0016
023084	AOHW090302ER-J	SFZ				0.272	0.362	0.125	0.008	0.0016
025813	AOHW090302FR-J	SP4036				0.272	0.362	0.125	0.008	0.0016
017287	AOHW090304ER-J	MP91M				0.272	0.362	0.125	0.016	0.0016
023086	AOHW090304ER-J	PFZ				0.272	0.362	0.125	0.016	0.0016
017617	AOHW090304ER-J	SFZ				0.272	0.362	0.125	0.016	0.0016
017288	AOHW090308ER-J	MP91M				0.272	0.362	0.125	0.031	0.0016
023087	AOHW090308ER-J	PFZ				0.272	0.362	0.125	0.031	0.0016
024919	AOHW090310ER-J	PFZ				0.272	0.362	0.125	0.039	0.0016
023088	AOHW090312ER-J	PFZ				0.272	0.362	0.125	0.047	0.0016
024111	AOHW090315ER-J	PFZ				0.272	0.362	0.125	0.059	0.0016
023091	AOHW090316ER-J	PFZ				0.272	0.362	0.125	0.063	0.0016
023093	AOHW090320ER-J	PFZ				0.272	0.362	0.125	0.079	0.0016
023094	AOHW090324ER-J	PFZ				0.272	0.362	0.125	0.094	0.0016
023095	AOHW090330ER-J	PFZ				0.272	0.362	0.125	0.118	0.0016

AO_09 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	▼▼ Semi-Finishing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	▼▼▼ Finishing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)
Unalloyed Steels	-	-	-	-	-	-	-	-	-
Alloyed Steels	-	-	-	-	-	-	-	-	-
Stainless Steels	-	-	-	460 - 590	0.004 - 0.006	0.10 - 0.24	600 - 750	0.005 - 0.007	0.01 - 0.10
PH Stainless	-	-	-	230 - 270	0.004 - 0.006	0.10 - 0.24	270 - 320	0.004 - 0.006	0.01 - 0.10
Cast Irons	-	-	-	-	-	-	-	-	-
Aluminum & Alloys	-	-	-	-	-	-	-	-	-
High Temp. Alloys	-	-	-	120 - 160	0.004 - 0.006	0.10 - 0.24	150 - 190	0.004 - 0.006	0.01 - 0.10
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 Aluminum & Alloys	H Hard Materials

STELLRAM®