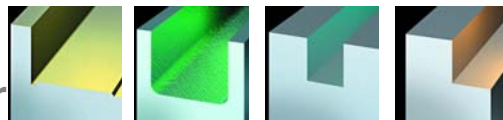




# 7690 VAF 09 Milling Cutter

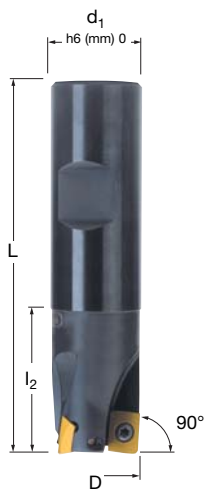


## 7690 VAF 09 Weldon Shank

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L/H	$l_2$	$d_1$	$a_{max.}$	EDP#			EDP#		
015236	<b>7690VAF 09 WA016R</b>	16	75	27	16	8,5	2	015268	F2506TP	018488	T7	
021715	<b>7690VAF 09 WA020R</b>	20	82	32	20	8,5	3	015268	F2506TP	018488	T7	
021716	<b>7690VAF 09 WA025R</b>	25	96	40	25	8,5	4	015268	F2506TP	018488	T7	
015237	<b>7690VAF 09 WA032R</b>	32	100	40	32	8,5	5	015268	F2506TP	018488	T7	

## 7690 VAF 09 Shell Mill Fixation

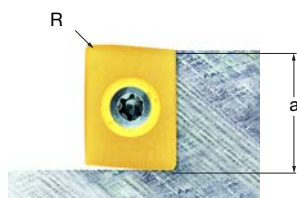
EDP #	Part Number	D	L/H	$l_2$	$d_1$	$a_{max.}$	No. of Inserts	EDP#	F2506TP	018488	T7
021710	<b>7690VAF 09 -A032R</b>	32	28	-	13	8,5	5	015268	F2506TP	018488	T7
021711	<b>7690VAF 09 -A040R</b>	40	32	-	16	8,5	6	015268	F2506TP	018488	T7
021712	<b>7690VAF 09 -A050R</b>	50	40	-	22	8,5	7	015268	F2506TP	018488	T7
021713	<b>7690VAF 09 -A063R</b>	63	40	-	22	8,5	8	015268	F2506TP	018488	T7
021714	<b>7690VAF 09 -A080R</b>	80	50	-	27	8,5	10	015268	F2506TP	018488	T7



Weldon Shank



Shell Mill Fixation



Depth of Cut (a)

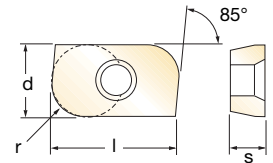


## 7690 VAF 09 Technical Advice

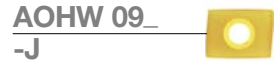
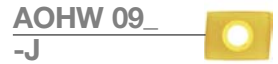
Milling Cutter Order Example: **7690VAF09WA020R**  
 Milling Insert Order Example: **AOHW0903PFTR-J PFZ**  
 For complete cutting conditions refer to page: **264**

When using inserts with a radius larger than 1,6 mm, the cutter body has to be modified.

## Inserts for 7690 VAF 09



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
015205	AOHW 09 03PFFR-J	SFZ				6,9	9,2	3,18	Facet	0,03
023097	AOHW 09 03PFTR-J	PFZ				6,9	9,2	3,18	Facet	0,10
015206	AOHW 09 03PFTR-J	X500		◆◆	◆◆	6,9	9,2	3,18	Facet	0,10
017289	AOHW 09 03PFTR-J	MP91M				6,9	9,2	3,18	Facet	0,10
027717	AOHW 09 03PFTR-J	SP6564		◆	◆	6,9	9,2	3,18	Facet	0,10
024918	AOHW 09 0302ER-J	PFZ				6,9	9,2	3,18	0,2	0,04
023084	AOHW 09 0302ER-J	SFZ				6,9	9,2	3,18	0,2	0,04
025813	AOHW 09 0302FR-J	SP4036				6,9	9,2	3,18	0,2	0,04
017287	AOHW 09 0304ER-J	MP91M				6,9	9,2	3,18	0,4	0,04
023086	AOHW 09 0304ER-J	PFZ				6,9	9,2	3,18	0,4	0,04
017617	AOHW 09 0304ER-J	SFZ				6,9	9,2	3,18	0,4	0,04
017288	AOHW 09 0308ER-J	MP91M				6,9	9,2	3,18	0,8	0,04
023087	AOHW 09 0308ER-J	PFZ				6,9	9,2	3,18	0,8	0,04
024919	AOHW 09 0310ER-J	PFZ				6,9	9,2	3,18	1,0	0,04
023088	AOHW 09 0312ER-J	PFZ				6,9	9,2	3,18	1,2	0,04
024111	AOHW 09 0315ER-J	PFZ				6,9	9,2	3,18	1,5	0,04
023091	AOHW 09 0316ER-J	PFZ				6,9	9,2	3,18	1,6	0,04
023093	AOHW 09 0320ER-J	PFZ				6,9	9,2	3,18	2,0	0,04
023094	AOHW 09 0324ER-J	PFZ				6,9	9,2	3,18	2,4	0,04
023095	AOHW 09 0330ER-J	PFZ				6,9	9,2	3,18	3,0	0,04



## AO\_09 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)
◆ Unalloyed Steels	-	-	-	-	-	-	-	-	-
◆ Alloyed Steels	-	-	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,10 - 0,15	2,5 - 6,0	180 - 230	0,12 - 0,18	0,2 - 2,5
◆ PH Stainless	-	-	-	70 - 85	0,10 - 0,14	2,5 - 6,0	80 - 100	0,10 - 0,15	0,2 - 2,5
◆ Cast Irons	-	-	-	-	-	-	-	-	-
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	35 - 50	0,10 - 0,14	2,5 - 6,0	45 - 60	0,10 - 0,15	0,2 - 2,5
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h<sub>m</sub> = average chip thickness

### Star Guide Key to Recommended Tools

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