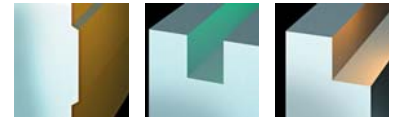




# 7690 VAZ 35 Milling Cutter



## 7690 VAZ 35 Caterpillar Vee Flange

EDP #	Part Number	Dimensions (inch)							No. of Inserts	Spares		
		D	L	$l_2$	$l_3$	$d_1$	a	EDP#		 EDP#	 EDP#	
014882	<b>A7690VAZ35FA040R070</b>	1.570	6.820	2.750	4.130	F40	1.300	4	015262	D4010T	015240	T15



Caterpillar Vee Flange

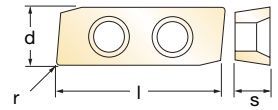


Depth of Cut (a)

## 7690 VAZ 35 Technical Advice

Milling Cutter Order Example: **A7690VAZ35FA040R070**  
 Milling Insert Order Example: **AOCX3504PZER-N702 SFZ**  
 For complete cutting conditions refer to page: **208**

## Inserts for 7690 VAZ 35



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
015204	AOCW3504PZTR-N	PFZ		◆◆◆		0.467	1.409	0.187	Facet	0.0039

**AOCW 35\_-N**



015151	AOCX3504PZER-N702	SFZ		◆◆	◆◆◆◆	0.467	1.409	0.187	Facet	0.0016
015152	AOCX3504PZFR-N701	SFZ		◆◆◆	◆◆◆◆	0.467	1.409	0.187	Facet	0.0008

**AOCX 35\_-N701 & -N702**



## AO\_35 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V <sub>C</sub> (feet/min)	Feed h <sub>m</sub> (inch)	W.O.C. a <sub>p</sub> (inch)	Speed V <sub>C</sub> (feet/min)	Feed h <sub>m</sub> (inch)	W.O.C. a <sub>p</sub> (inch)	Speed V <sub>C</sub> (feet/min)	Feed h <sub>m</sub> (inch)	W.O.C. a <sub>p</sub> (inch)
◆ Unalloyed Steels	-	-	-	730 - 850	0.004 - 0.008	0.12 - 0.98	730 - 980	0.002 - 0.005	0.01 - 0.12
◆ Alloyed Steels	-	-	-	330 - 490	0.004 - 0.007	0.12 - 0.98	330 - 630	0.002 - 0.004	0.01 - 0.12
◆ Stainless Steels	-	-	-	460 - 590	0.003 - 0.005	0.12 - 0.98	600 - 750	0.002 - 0.004	0.01 - 0.12
◆ PH Stainless	-	-	-	230 - 270	0.002 - 0.004	0.12 - 0.98	270 - 320	0.002 - 0.003	0.01 - 0.12
◆ Cast Irons	-	-	-	600 - 980	0.004 - 0.006	0.12 - 0.98	660 - 1140	0.002 - 0.003	0.01 - 0.12
◆ Aluminum & Alloys	-	-	-	1320 - 2460	0.002 - 0.006	0.12 - 0.98	2300 - 3280	0.002 - 0.004	0.01 - 0.12
◆ High Temp. Alloys	-	-	-	120 - 160	0.002 - 0.004	0.12 - 0.98	150 - 190	0.002 - 0.003	0.01 - 0.12
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

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

### Star Guide Key to Recommended Tools

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