

7790 VSE 09 Milling Cutter

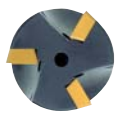
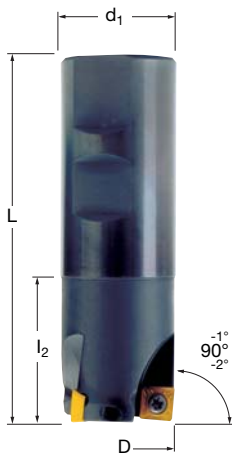


7790 VSE 09 Weldon Shank

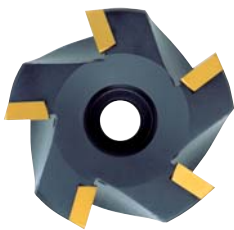
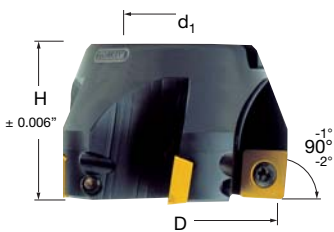
EDP #	Part Number	Dimensions (inch)					No. of Inserts	Spares			
		D	L/H	l_2	d_1	$a_{max.}$		EDP#	EDP#	EDP#	
014925	C7790VSE09WA1.00Z02R	1.000	3.900	1.600	1.000	0.300	2	015269	F3508T	015240	T15
014926	C7790VSE09WA1.25Z03R	1.250	3.900	1.600	1.250	0.300	3	015269	F3508T	015240	T15
014927	C7790VSE09WA1.50Z04R	1.500	4.330	2.000	1.250	0.300	4	015269	F3508T	015240	T15

7790 VSE 09 Shell Mill Fixation

015439	C7790VSE09-A1.50Z04R	1.500	1.260	-	0.500	0.300	4	015269	F3508T	015240	T15
014924	C7790VSE09-A2.00Z05R	2.000	1.570	-	0.750	0.300	5	015269	F3508T	015240	T15
015440	C7790VSE09-A2.50Z05R	2.500	1.570	-	0.750	0.300	5	015269	F3508T	015240	T15
015441	C7790VSE09-A3.00Z06R	3.000	1.970	-	1.000	0.300	6	015269	F3508T	015240	T15
015442	C7790VSE09-A4.00Z08R	4.000	1.970	-	1.250	0.300	8	015269	F3508T	015240	T15
015443	C7790VSE09-A5.00Z09R	5.000	2.480	-	1.500	0.300	9	015269	F3508T	015240	T15



Weldon Shank



Shell Mill Fixation



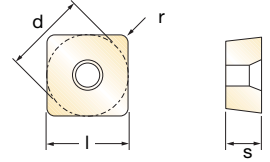
Depth of Cut (a)

7790 VSE 09 Technical Advice

Milling Cutter Order Example: **C7790VSE09-A1.50Z04R**
 Milling Insert Order Example: **SDMT09T308EN-41 PFZ**
 For complete cutting conditions refer to page: 208



Inserts for 7790 VSE 09



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017319	SDET09T308EN	MP91M				0.375	0.375	0.156	0.031	0.0012
017724	SDET09T308EN	PFZ				0.375	0.375	0.156	0.031	0.0012
017725	SDET09T308FN	GH1	◆	◆		0.375	0.375	0.156	0.031	0.0008
017325	SDMT09T308EN-41	MP91M		◆◆		0.375	0.375	0.156	0.031	0.0016
023362	SDMT09T308EN-41	PFZ				0.375	0.375	0.156	0.031	0.0016
014410	SDMT09T308EN-41	X500		◆◆		0.375	0.375	0.156	0.031	0.0016
027736	SDMT09T308EN-41	SP6564		◆◆		0.375	0.375	0.156	0.031	0.0016
017327	SDMW09T308TN	MP91M	◆◆			0.375	0.375	0.156	0.031	0.0059
027742	SDMW09T308TN	SP6564	◆			0.375	0.375	0.156	0.031	0.0059
023363	SDMW09T308TN	PFZ				0.375	0.375	0.156	0.031	0.0059
015232	SDMW09T308TN	X500				0.375	0.375	0.156	0.031	0.0047



SD_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 - 0.010	0.16 - 0.31	730 - 850	0.004 - 0.009	0.04 - 0.16	-	-	-
◆ Alloyed Steels	230 - 360	0.006 - 0.009	0.16 - 0.31	330 - 490	0.004 - 0.008	0.04 - 0.16	-	-	-
◆ Stainless Steels	-	-	-	460 - 590	0.003 - 0.006	0.04 - 0.16	-	-	-
◆ PH Stainless	-	-	-	230 - 270	0.003 - 0.005	0.04 - 0.16	-	-	-
◆ Cast Irons	460 - 910	0.006 - 0.008	0.16 - 0.31	600 - 980	0.004 - 0.007	0.04 - 0.16	-	-	-
◆ Aluminum & Alloys	500 - 1310	0.004 - 0.009	0.12 - 0.28	660 - 1640	0.003 - 0.007	0.04 - 0.12	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ 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
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials