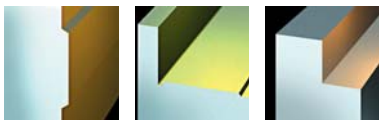
7790 VSE 09 Milling Cutter

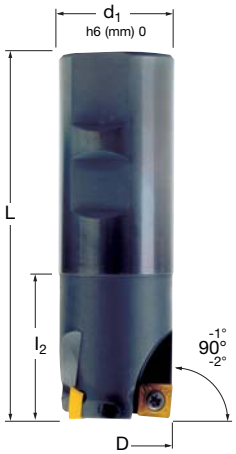


7790 VSE 09 Weldon Shank

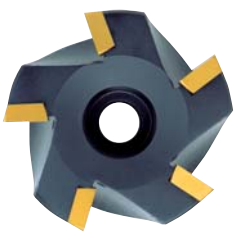
EDP #	Part Number	Dimensions (mm) D	L/H	l_2	d_1	a max.	No. of Inserts	Spares EDP#		EDP#	
021809	**7790VSE 09 WA025Z02R**	25	96	40	25	8	2	015269	F3508T	015240	T15
021810	**7790VSE 09 WA032Z03R**	32	100	40	32	8	3	015269	F3508T	015240	T15
021811	**7790VSE 09 WA040Z04R**	40	110	49	32	8	4	015269	F3508T	015240	T15

7790 VSE 09 Shell Mill Fixation

023070	**7790VSE 09 -A040Z04R**	40	32	-	16	8	4	015269	F3508T	015240	T15
021804	**7790VSE 09 -A050Z05R**	50	40	-	22	8	5	015269	F3508T	015240	T15
021805	**7790VSE 09 -A063Z05R**	63	40	-	22	8	5	015269	F3508T	015240	T15
021806	**7790VSE 09 -A080Z06R**	80	50	-	27	8	6	015269	F3508T	015240	T15
021807	**7790VSE 09 -A100Z08R**	100	50	-	32	8	8	015269	F3508T	015240	T15
021808	**7790VSE 09 -A125Z09R**	125	63	-	40	8	9	015269	F3508T	015240	T15



Weldon Shank



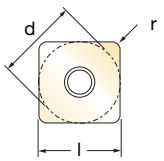
Shell Mill Fixation

7790 VSE 09 Technical Advice

Milling Cutter Order Example: **7790VSE09-A050Z05R**
Milling Insert Order Example: **SDMT09T308EN-41 PFZ**
For complete cutting conditions refer to page: **264**

Depth of Cut (a)

Inserts for 7790 VSE 09



SDET 09_

EDP#	Part Number	Grade	Application & Material ▼ Roughing	▼▼ Semi-Finishing	▼▼▼ Finishing	Dimensions (mm) d	l	s	r	h_m min
017319	**SDET 09 T308EN**	**MP91M**				9,52	9,52	3,97	0,8	0,03
017724	**SDET 09 T308EN**	**PFZ**				9,52	9,52	3,97	0,8	0,03
017725	**SDET 09 T308FN**	**GH1**	♦	♦		9,52	9,52	3,97	0,8	0,02

SDMT 09_ -41

017325	**SDMT 09 T308EN-41**	**MP91M**		♦♦		9,52	9,52	3,97	0,8	0,04
023362	**SDMT 09 T308EN-41**	**PFZ**				9,52	9,52	3,97	0,8	0,04
014410	**SDMT 09 T308EN-41**	**X500**		♦		9,52	9,52	3,97	0,8	0,04
027736	**SDMT 09 T308EN-41**	**SP6564**		♦♦		9,52	9,52	3,97	0,8	0,04

SDMW 09_

017327	**SDMW 09 T308TN**	**MP91M**	♦♦			9,52	9,52	3,97	0,8	0,15
027742	**SDMW 09 T308TN**	**SP6564**	♦			9,52	9,52	3,97	0,8	0,15
023363	**SDMW 09 T308TN**	**PFZ**				9,52	9,52	3,97	0,8	0,15
015232	**SDMW 09 T308TN**	**X500**				9,52	9,52	3,97	0,8	0,12

SD_09 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼ Semi-Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼▼ Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)
♦ Unalloyed Steels	180 - 220	0,15 - 0,25	4,0 - 8,0	220 - 260	0,10 - 0,22	1,0 - 4,0	-	-	-
♦ Alloyed Steels	70 - 110	0,15 - 0,22	4,0 - 8,0	100 - 150	0,10 - 0,20	1,0 - 4,0	-	-	-
♦ Stainless Steels	-	-	-	140 - 180	0,08 - 0,14	1,0 - 4,0	-	-	-
♦ PH Stainless	-	-	-	70 - 85	0,08 - 0,12	1,0 - 4,0	-	-	-
♦ Cast Irons	140 - 280	0,15 - 0,20	4,0 - 8,0	180 - 300	0,10 - 0,18	1,0 - 4,0	-	-	-
♦ Aluminium & Alloys	150 - 400	0,10 - 0,22	3,0 - 7,0	200 - 500	0,08 - 0,18	1,0 - 3,0	-	-	-
♦ 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	S ♦ High Temp. Alloys
P ♦ Alloyed Steels	M ♦ PH Stainless	N ♦ Aluminium & Alloys	H ♦ Hard Materials

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