

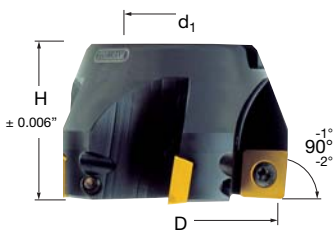


7790 VSE 12 Milling Cutter



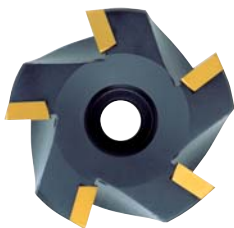
7790 VSE 12 Shell Mill Fixation

EDP #	Part Number	Dimensions (inch)				No. of Inserts	Spares			
		D	H	d ₁	a		EDP#		EDP#	
014928	C7790VSE12-A2.50Z05R	2.500	1.570	0.750	0.400	5	015270	F4011T	015241	T20
014929	C7790VSE12-A3.00Z06R	3.000	1.970	1.000	0.400	6	015270	F4011T	015241	T20
014930	C7790VSE12-A4.00Z08R	4.000	1.970	1.250	0.400	8	015270	F4011T	015241	T20
014931	C7790VSE12-A5.00Z09R	5.000	2.480	1.500	0.400	9	015270	F4011T	015241	T20



7790 VSE 12 Technical Advice

Milling Cutter Order Example: **C7790VSE12-A4.00Z08R**
 Milling Insert Order Example: **SDEW120412TN X500**
 For complete cutting conditions refer to page: 208



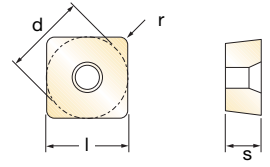
Shell Mill Fixation



Depth of Cut (a)



Inserts for 7790 VSE 12



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
018206	SDEW120412TN	X500				0.500	0.500	0.187	0.047	0.0059
017326	SDMT120412EN-41	MP91M		◆◆		0.500	0.500	0.187	0.047	0.0020
015135	SDMT120412EN-41	PFZ				0.500	0.500	0.187	0.047	0.0020
014411	SDMT120412EN-41	X500		◆		0.500	0.500	0.187	0.047	0.0020
027737	SDMT120412EN-41	SP6564		◆◆		0.500	0.500	0.187	0.047	0.0020
017328	SDMW120412TN	MP91M	◆◆			0.500	0.500	0.187	0.047	0.0059
015136	SDMW120412TN	PFZ	◆			0.500	0.500	0.187	0.047	0.0059
015233	SDMW120412TN	X500				0.500	0.500	0.187	0.047	0.0047

SDEW 12_



SDMT 12_ -41



SDMW 12_



SD_12 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 - 0.012	0.20 - 0.39	730 - 850	0.005 - 0.009	0.06 - 0.20	-	-	-
◆ Alloyed Steels	230 - 360	0.006 - 0.010	0.20 - 0.39	330 - 490	0.004 - 0.009	0.06 - 0.20	-	-	-
◆ Stainless Steels	-	-	-	460 - 590	0.004 - 0.006	0.06 - 0.20	-	-	-
◆ PH Stainless	-	-	-	230 - 270	0.003 - 0.006	0.06 - 0.20	-	-	-
◆ Cast Irons	460 - 910	0.006 - 0.010	0.20 - 0.39	600 - 980	0.004 - 0.008	0.06 - 0.20	-	-	-
◆ Aluminum & Alloys	-	-	-	-	-	-	-	-	-
◆ 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