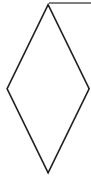


STAR GUIDE™ for Milling Inserts



Introducing the Stellram Star Guide which will enable you to select your inserts in 3 easy steps. Simply follow the appropriate star point based on the selected material.

1st Choice



Star point will indicate the recommended insert for each material. Stellram's Star Guide enables you to find the right insert for your machining requirements.

- 1 Select Material.
- 2 Follow colour-coded star point to insert section for your application (roughing, semi-finishing or finishing).
- 3 Follow colour-coded star point to cutting conditions for your application .

Application

- Roughing
- Semi-Finishing
- Finishing

Inserts for 7745 VOD 06

EDP#	Part Number	Grade	Application & Material			Dimensions (mm)					
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min	
026591	OJET 06 05APEN-44	MP91M				16,0	6,0	5,55	Facet	0,04	
026598	OJET 06 05APEN-44	SP4036				16,0	6,0	5,55	Facet	0,04	
026592	OJET 06 05APEN-44	X500				16,0	6,0	5,55	Facet	0,04	
026588	OJET 06 05APFN-441	GH1				16,0	6,0	5,55	Facet	0,02	
026589	ODMT 06 05APEN-41	MP91M				16,0	6,0	5,55	Facet	0,04	
026597	ODMT 06 05APEN-41	SP4036				16,0	6,0	5,55	Facet	0,04	
026590	ODMT 06 05APEN-41	X500				16,0	6,0	5,55	Facet	0,04	
026836	ODMW 06 0512SN	MP91M				16,0	6,0	5,55	1,2	0,27	
026837	ODMW 06 0512SN	SF30				16,0	6,0	5,55	1,2	0,27	
026838	ODMW 06 0512SN	X500				16,0	6,0	5,55	1,2	0,27	
027743	ODMW 06 0512SN	SP6564				16,0	6,0	5,55	1,2	0,27	
026595	ODMW 06 0512TN	MP91M				16,0	6,0	5,55	1,2	0,17	
026599	ODMW 06 0512TN	SP4036				16,0	6,0	5,55	1,2	0,17	
026596	ODMW 06 0512TN	X500				16,0	6,0	5,55	1,2	0,17	

2

OD_04 Recommended Cutting Conditions

Material	Roughing			Semi-Finishing			Finishing		
	Speed V _C (m/min)	Feed f _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed f _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed f _m (mm)	D.O.C. a _p (mm)
Unalloyed Steels	180 - 220	0,30 - 0,70	2,5 - 4,5	220 - 260	0,20 - 0,40	1,0 - 2,0	220 - 300	0,08 - 0,15	0,2 - 1,0
Alloyed Steels	70 - 110	0,27 - 0,50	2,5 - 4,5	100 - 150	0,20 - 0,35	1,0 - 2,0	100 - 195	0,08 - 0,15	0,2 - 1,0
Stainless Steels	120 - 140	0,27 - 0,40	2,5 - 4,5	140 - 180	0,15 - 0,25	1,0 - 2,0	180 - 230	0,05 - 0,15	0,2 - 1,0
PH Stainless	55 - 70	0,15 - 0,30	2,5 - 4,5	70 - 85	0,10 - 0,20	1,0 - 2,0	80 - 100	0,05 - 0,10	0,2 - 1,0
Cast Irons	140 - 280	0,20 - 0,45	2,5 - 4,5	180 - 300	0,15 - 0,30	1,0 - 2,0	200 - 350	0,05 - 0,15	0,2 - 1,0
Aluminium & Alloys	275 - 450	0,20 - 0,35	2,5 - 4,5	400 - 750	0,10 - 0,25	1,0 - 2,0	700 - 1000	0,05 - 0,15	0,2 - 1,0
High Temp. Alloys	25 - 40	0,17 - 0,25	2,5 - 4,5	35 - 50	0,10 - 0,20	1,0 - 2,0	45 - 60	0,05 - 0,10	0,2 - 1,0
Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,06 - 0,12	0,5 - 1,5	50 - 100	0,03 - 0,06	0,2 - 0,5

f_m = average chip thickness

Star Guide Key to Recommended Tools

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















1

39










You now have the right milling cutter, inserts and cutting conditions for your specific application.



8 star points represent each main group of machinable materials. A segment has been given a colour to identify each material group.

Unalloyed Steel		
Alloyed Steel		
Stainless Steel		
PH Stainless		
Cast Irons		
Aluminium & Alloys		
High Temperature Alloys		
Hard Materials (52-56 HRC)		

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	