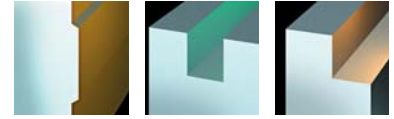


7690 VAZ 35 Milling Cutter



Weldon Shank



Shell Mill Fixation



DIN 69871 Vee Flange



Depth of Cut (a)

7690 VAZ 35 Weldon Shank

EDP #	Part Number	Dimensions (mm)							No. of Inserts	Spares		
		D	L/H	I ₂	I ₃	d ₁	a _{max.}	EDP#		EDP#	EDP#	
017983	7690VAZ 35 WA040R070	40	125	-	65	40	33	4	015262	D4010T	015240	T15

7690 VAZ 35 Shell Mill Fixation

021717	7690VAZ 35 -A063R060	63	60	-	-	27	33	6	015262	D4010T	015240	T15
021718	7690VAZ 35 -A080R060	80	60	-	-	32	33	8	015262	D4010T	015240	T15

7690 VAZ 35 DIN 69871 Shank

021719	7690VAZ 35 GA040R070	40	157,5	70	89,1	G40	33	4	015262	D4010T	015240	T15
021720	7690VAZ 35 GA050R070	50	190,8	70	90,4	G50	33	5	015262	D4010T	015240	T15



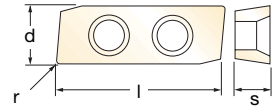
7690 VAZ 35 Technical Advice

Milling Cutter Order Example: **7690VAZ35WA040R070**

Milling Insert Order Example: **AOCX3504PZER-N701 SFZ**

For complete cutting conditions refer to page: **264**

Inserts for 7690 VAZ 35



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
015204	AOCW 35 04PZTR-N	PFZ		◆◆◆		11,86	35,8	4,76	Facet	0,10

AOCW 35_-N



015152	AOCX 35 04PZFR-N701	SFZ		◆◆◆	◆◆◆◆◆	11,86	35,8	4,76	Facet	0,02
015151	AOCX 35 04PZER-N702	SFZ		◆◆◆◆◆	◆◆◆◆◆	11,86	35,8	4,76	Facet	0,04

AOCX 35_-N701 & -N702



AO_35 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed h _m (mm)	W.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	W.O.C. a _e (mm)	Speed V _C (m/min)	Feed h _m (mm)	W.O.C. a _e (mm)
◆ Unalloyed Steels	-	-	-	220 - 260	0,10 - 0,20	3,0 - 25,0	220 - 300	0,05 - 0,12	0,15 - 3,0
◆ Alloyed Steels	-	-	-	100 - 150	0,10 - 0,18	3,0 - 25,0	100 - 195	0,05 - 0,10	0,15 - 3,0
◆ Stainless Steels	-	-	-	140 - 180	0,08 - 0,12	3,0 - 25,0	180 - 230	0,04 - 0,10	0,15 - 3,0
◆ PH Stainless	-	-	-	70 - 85	0,05 - 0,10	3,0 - 25,0	80 - 100	0,05 - 0,08	0,15 - 3,0
◆ Cast Irons	-	-	-	180 - 300	0,10 - 0,15	3,0 - 25,0	200 - 350	0,05 - 0,08	0,15 - 3,0
◆ Aluminium & Alloys	-	-	-	400 - 750	0,05 - 0,15	3,0 - 25,0	700 - 1000	0,05 - 0,10	0,15 - 3,0
◆ High Temp. Alloys	-	-	-	35 - 50	0,05 - 0,10	3,0 - 25,0	45 - 60	0,05 - 0,08	0,15 - 3,0
◆ 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