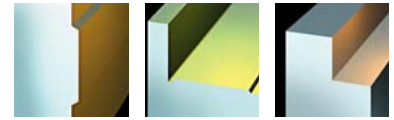




7690 VT 16 Milling Cutter



7690 VT 16 R8 Shank

EDP #	Part Number	Dimensions (inch)				No. of Inserts	Spares			
		D	L	Shank	a _{max.}		EDP#	 D4012T	EDP#	 T15
014398	7690VT 16 R8050R	1.969	1.378	R8	0.472	2	015263	D4012T	015240	T15
023056	7690VT 16 R8063R	2.480	1.378	R8	0.472	2	015263	D4012T	015240	T15
023057	7690VT 16 R8080R	3.150	1.378	R8	0.472	2	015263	D4012T	015240	T15

R8 shank is only for Bridgeport Style spindles.



R8 Shank

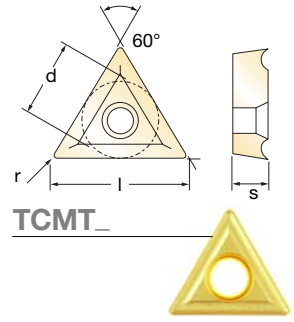


Depth of Cut (a)

7690 VT 16 Technical Advice

Milling Cutter Order Example: **7690VT16R8050R**
 Milling Insert Order Example: **TCMT16T308E MP91M**
 For complete cutting conditions refer to page: **208**

Inserts for 7690 VT 16



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
024139	TCMT16T308E	MP91M	◆	◆		0.375	0.650	0.156	0.032	0.0020
023388	TCMT16T308E	PFZ	◆◆	◆◆		0.375	0.650	0.156	0.032	0.0020
017743	TCMT16T308E	SF30				0.375	0.650	0.156	0.032	0.0020
014852	TCMT16T308E	X44				0.375	0.650	0.156	0.032	0.0028
024140	TCMT16T308E	X500				0.375	0.650	0.156	0.032	0.0020

TC_16 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	0.004 - 0.010	0.12 - 0.55	730 - 850	0.004 - 0.010	0.04 - 0.12	-	-	-
◆ Alloyed Steels	230 - 360	0.004 - 0.008	0.12 - 0.55	330 - 490	0.004 - 0.008	0.04 - 0.12	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	460 - 910	0.004 - 0.008	0.12 - 0.55	600 - 980	0.004 - 0.008	0.04 - 0.12	-	-	-
◆ 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