



7690 VT 16 Milling Cutter



7690 VT 16 R8 Shank

EDP #	Part Number	Dimensions (mm)					No. of Inserts	Spares			
		D	L	Shank	a _{max.}	EDP#		 EDP#	 EDP#	T15	
014398	7690VT 16 R8050R	50	35	R8	12	2	015263	D4012T	015240	T15	
023056	7690VT 16 R8063R	63	35	R8	12	2	015263	D4012T	015240	T15	
023057	7690VT 16 R8080R	80	35	R8	12	2	015263	D4012T	015240	T15	

R8 shank is only for Bridgeport Style spindles.



R8 Shank

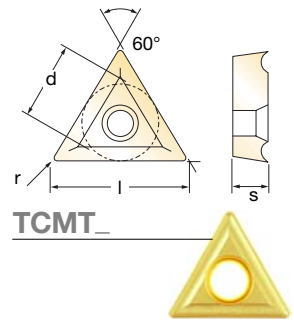


Depth of Cut (a)

7690 VT 16 Technical Advice

Milling Cutter Order Example: **7690VT16R8050R**
 Milling Insert Order Example: **TCMT16T308E MP91M**
 For complete cutting conditions refer to page: **264**

Inserts for 7690 VT 16



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024139	TCMT 16 T308E	MP91M	♦	♦		9,52	16,5	3,97	0,8	0,05
023388	TCMT 16 T308E	PFZ	♦♦	♦♦		9,52	16,5	3,97	0,8	0,05
017743	TCMT 16 T308E	SF30				9,52	16,5	3,97	0,8	0,05
014852	TCMT 16 T308E	X44				9,52	16,5	3,97	0,8	0,07
024140	TCMT 16 T308E	X500				9,52	16,5	3,97	0,8	0,05

TC_16 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)
♦ Unalloyed Steels	180 - 220	0,1 - 0,25	3,0 - 12,0	220 - 260	0,1 - 0,25	1,0 - 3,0	-	-	-
♦ Alloyed Steels	70 - 110	0,1 - 0,20	3,0 - 12,0	100 - 150	0,1 - 0,20	1,0 - 3,0	-	-	-
♦ Stainless Steels	-	-	-	-	-	-	-	-	-
♦ PH Stainless	-	-	-	-	-	-	-	-	-
♦ Cast Irons	140 - 280	0,1 - 0,20	3,0 - 12,0	180 - 300	0,1 - 0,20	1,0 - 3,0	-	-	-
♦ Aluminium & 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	S ♦	High Temp. Alloys
	P ♦	Alloyed Steels	M ♦	PH Stainless	N ♦	Aluminium & Alloys	H ♦	Hard Materials