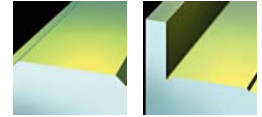


8_0 VA90_16 Face Mills



8000 VA90_16 Unequal Pitch - Assembled Body & Cartridge

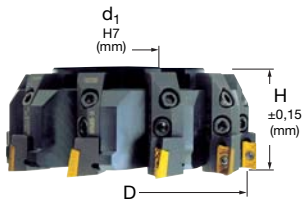
EDP #	Part Number	Dimensions (mm)					No. of Inserts	EDP#	Cartridge	Spares		
		D	H	d ₁	a	EDP#				EDP#	EDP#	
021817	8000VA90-100R 16	106	68	32	16	6	015390	80VA90R-16	015262	D4010T	015240	T15
021819	8000VA90-125R 16	131	63	40	16	8	015390	80VA90R-16	015262	D4010T	015240	T15
021821	8000VA90-160R 16	166	63	40	16	10	015390	80VA90R-16	015262	D4010T	015240	T15
021823	8000VA90-200R 16	206	63	60	16	12	015390	80VA90R-16	015262	D4010T	015240	T15
021825	8000VA90-250R 16	256	63	60	16	16	015390	80VA90R-16	015262	D4010T	015240	T15
021827	8000VA90-315R 16	321	80	60	16	20	015390	80VA90R-16	015262	D4010T	015240	T15
021829	8000VA90-400R 16	406	80	60	16	24	015390	80VA90R-16	015262	D4010T	015240	T15

8010 VA90_16 Equal Pitch - Assembled Body & Cartridge

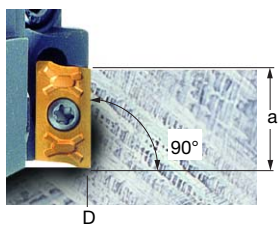
EDP #	Part Number	D	H	d ₁	a	No. of Inserts	EDP#	Cartridge	EDP#	EDP#	EDP#	
021929	8010VA90-100R 16	106	68	32	16	6	015390	80VA90R-16	015262	D4010T	015240	T15
021931	8010VA90-125R 16	131	63	40	16	8	015390	80VA90R-16	015262	D4010T	015240	T15
021933	8010VA90-160R 16	166	63	40	16	10	015390	80VA90R-16	015262	D4010T	015240	T15
021935	8010VA90-200R 16	206	63	60	16	12	015390	80VA90R-16	015262	D4010T	015240	T15

8_0 VA90_16 Cartridge Spares

EDP #	Cartridge Part Number	EDP#
015390	80VA90R-16	015255 7065



Cutter Body & Cartridge



Depth of Cut (a)

8_0 VA90_16 Technical Advice

Milling Cutter Order Example: **8000VA90-315R16**
 Milling Insert Order Example: **APHT1604PDTR-42 PFZ**
 For complete cutting conditions refer to page: **264**

When using inserts with a radius larger than 2 mm, the cartridge has to be modified.



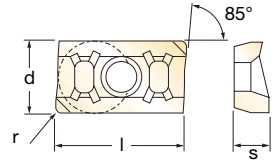
AP_16 Recommended Cutting Conditions

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	0,14 - 0,40	8,0 - 16,0	220 - 260	0,12 - 0,35	3,0 - 8,0	220 - 300	0,15 - 0,45	0,2 - 3,0
◆ Alloyed Steels	70 - 110	0,14 - 0,35	8,0 - 16,0	100 - 150	0,12 - 0,30	3,0 - 8,0	100 - 195	0,15 - 0,40	0,2 - 3,0
◆ Stainless Steels	-	-	-	140 - 180	0,12 - 0,25	3,0 - 8,0	180 - 230	0,15 - 0,28	0,2 - 3,0
◆ PH Stainless	-	-	-	70 - 85	0,10 - 0,20	3,0 - 8,0	80 - 100	0,10 - 0,20	0,2 - 3,0
◆ Cast Irons	140 - 280	0,14 - 0,28	8,0 - 16,0	180 - 300	0,12 - 0,25	3,0 - 8,0	200 - 350	0,18 - 0,30	0,2 - 3,0
◆ Aluminium & Alloys	275 - 450	0,06 - 0,25	8,0 - 16,0	400 - 750	0,04 - 0,20	3,0 - 8,0	700 - 1000	0,08 - 0,30	0,2 - 3,0
◆ High Temp. Alloys	-	-	-	35 - 50	0,10 - 0,20	3,0 - 8,0	45 - 60	0,10 - 0,20	0,2 - 3,0
◆ Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,04 - 0,08	1,5 - 3,5	50 - 100	0,06 - 0,10	0,2 - 1,5

h_m = average chip thickness



Inserts for 8_0 VA90_16



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017621	APEX 16 04PDER-701	PFZ				9,52	16,66	4,76	Facet	0,02
017623	APEX 16 04PDR-701	SFZ				9,52	16,66	4,76	Facet	0,02
014066	APEX 16 04PDR-701	GH1				9,52	16,66	4,76	Facet	0,02
017291	APFW 16 04PDER	MP91M				9,52	16,66	4,76	Facet	0,04
017627	APFW 16 04PDTR	X44				9,52	16,66	4,76	Facet	0,1
017628	APFW 16 04PDTR	GH1				9,52	16,66	4,76	Facet	0,1
018030	APFW 16 04PDTR	CN35				9,52	16,66	4,76	Facet	0,1
017626	APFW 16 04PDTR	SF30				9,52	16,66	4,76	Facet	0,1
017629	APFW 16 04PDTR	SFZ		◆	◆	9,52	16,66	4,76	Facet	0,1
017633	APHT 16 04PDER	SFZ				9,52	16,66	4,76	Facet	0,05
015154	APHT 16 04PDR	GH1	◆	◆	◆	9,52	16,66	4,76	Facet	0,02
017293	APHT 16 04PDTR-42	MP91M				9,52	16,66	4,76	Facet	0,1
017634	APHT 16 04PDTR-42	PFZ				9,52	16,66	4,76	Facet	0,1
015155	APHT 16 04PDTR-42	X500				9,52	16,66	4,76	Facet	0,1
027718	APHT 16 04PDTR-42	SP6564				9,52	16,66	4,76	Facet	0,1
011649	APKT 16 04PDER-3M	MP91M				9,52	16,66	4,76	Facet	0,1
017294	APKT 16 04PDER-43	MP91M	◆			9,52	16,66	4,76	Facet	0,08
014067	APKT 16 04PDER-43	PFZ				9,52	16,66	4,76	Facet	0,08
015156	APKT 16 04PDER-43	X500				9,52	16,66	4,76	Facet	0,08
027720	APKT 16 04PDER-43	SP6564	◆◆			9,52	16,66	4,76	Facet	0,08
023115	APKT 16 04PDER-45	X500		◆◆	◆◆	9,52	16,66	4,76	Facet	0,06
023114	APKT 16 04PDER-45	MP91M		◆◆	◆◆	9,52	16,66	4,76	Facet	0,06
027721	APKT 16 04PDER-45	SP6564	◆◆	◆◆	◆◆	9,52	16,66	4,76	Facet	0,06
023102	APET 16 0402TR-42	PFZ				9,52	16,66	4,76	0,2	0,1
023103	APET 16 0408TR-42	PFZ				9,52	16,66	4,76	0,8	0,1
023104	APET 16 0410TR-42	PFZ				9,52	16,66	4,76	1,0	0,1
023105	APET 16 0415TR-42	PFZ				9,52	16,66	4,76	1,5	0,1
023106	APET 16 0420TR-42	PFZ				9,52	16,66	4,76	2,0	0,1
017618	APET 16 0425TR-42	MP91M				9,52	16,66	4,76	2,5	0,1
017619	APET 16 0425TR-42	X500				9,52	16,66	4,76	2,5	0,1
023107	APET 16 0430TR-42	PFZ				9,52	16,66	4,76	3,0	0,1
017290	APET 16 0440TR-42	MP91M				9,52	16,66	4,76	4,0	0,1
024921	APET 16 0440TR-42	PFZ				9,52	16,66	4,76	4,0	0,1
017620	APET 16 0440TR-42	X500				9,52	16,66	4,76	4,0	0,1
025804	APET 16 0460TR-42	PFZ				9,52	16,66	4,76	6,0	0,1
017636	APHW 16 0440TR	X44				9,52	16,66	4,76	4,0	0,1
011488	APKT 16 0408E-2C	MP91M				9,52	16,66	4,76	0,8	0,10
010796	APKT 16 0408E-2C	PFZ				9,52	16,66	4,76	0,8	0,10
017228	APMT 16 0412E-2C	MP91M				9,52	16,66	4,76	1,2	0,1
013944	APMT 16 0416E-2C	MP91M				9,52	16,66	4,76	1,6	0,1
013945	APMT 16 0424E-2C	MP91M				9,52	16,66	4,76	2,4	0,1
013946	APMT 16 0432E-2C	MP91M				9,52	16,66	4,76	3,2	0,1
017229	APMT 16 0440E-2C	MP91M				9,52	16,66	4,76	4,0	0,1
017230	APMT 16 0448E-2C	MP91M				9,52	16,66	4,76	4,8	0,1
013947	APMT 16 0464E-2C	MP91M				9,52	16,66	4,76	6,4	0,1



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	