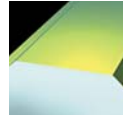




# 8\_0 VT60\_22 Face Mills



## 8000 VT60\_22 Unequal Pitch - Assembled Body & Cartridge

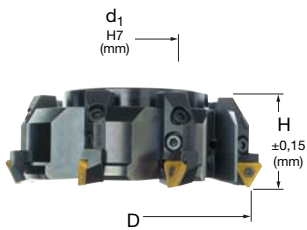
EDP #	Part Number	Dimensions (mm)					No. of Inserts	EDP#	Cartridge	Spares		
		D	H	d <sub>1</sub>	a	EDP#				 EDP#	 EDP#	
021907	8000VT60-100R 22	100	68	32	14	6	015394	80VT60R-22	015266	D5013T	015241	T20
021908	8000VT60-125R 22	125	63	40	14	8	015394	80VT60R-22	015266	D5013T	015241	T20
021909	8000VT60-160R 22	160	63	40	14	10	015394	80VT60R-22	015266	D5013T	015241	T20
021910	8000VT60-200R 22	200	63	60	14	12	015394	80VT60R-22	015266	D5013T	015241	T20
021911	8000VT60-250R 22	250	63	60	14	16	015394	80VT60R-22	015266	D5013T	015241	T20
021912	8000VT60-315R 22	315	80	60	14	20	015394	80VT60R-22	015266	D5013T	015241	T20
021913	8000VT60-400R 22	400	80	60	14	24	015394	80VT60R-22	015266	D5013T	015241	T20

## 8100 VT60\_22 Unequal Pitch - Assembled Body & Cartridge

022030	8100VT60-125R 22	125	63	40	14	6	015394	80VT60R-22	015266	D5013T	015241	T20
022031	8100VT60-160R 22	160	63	40	14	8	015394	80VT60R-22	015266	D5013T	015241	T20
022032	8100VT60-200R 22	200	63	60	14	10	015394	80VT60R-22	015266	D5013T	015241	T20
022033	8100VT60-250R 22	250	63	60	14	10	015394	80VT60R-22	015266	D5013T	015241	T20
022034	8100VT60-315R 22	315	80	60	14	12	015394	80VT60R-22	015266	D5013T	015241	T20
022035	8100VT60-400R 22	400	80	60	14	14	015394	80VT60R-22	015266	D5013T	015241	T20

## 8\_0 VT60\_22 Cartridge Spares

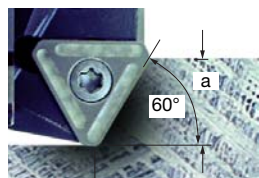
EDP #	Cartridge Part Number	EDP#	
015394	80VT60R- 22	015255	7065



Cutter Body & Cartridge

## 8\_0 VT60\_22 Technical Advice

Milling Cutter Order Example: **8100VT60-400R22**  
 Milling Insert Order Example: **TNHT2204DDTR PFZ**  
 For complete cutting conditions refer to page: **264**

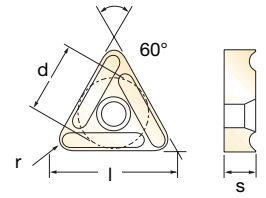


Depth of Cut (a)

Feedrate compensation: For 60° cutting, divide the  $h_m$  value by the sine of the approach angle (the sine of 60° = 0,866)

$$\text{ie: } \frac{h_m}{0,866} \quad \text{or} \quad \frac{0,15}{0,866} = 0,173 \text{ mm programmed feed rate}$$

## Inserts for 8\_0 VT60\_ 22



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	$h_m$ min
017284	TNCT 22 04DDTR	GH1	▼	▼▼	▼▼▼	12,7	22,0	4,76	Facet	0,15
017285	TNCT 22 04DDTR	SF30	▼	▼▼	▼▼▼	12,7	22,0	4,76	Facet	0,15

TNCT 22\_



024084	TNHT 22 04DDTR	PFZ	◆◆	◆◆◆	◆◆◆◆	12,7	22,0	4,76	Facet	0,15
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TNHT 22\_



## TN\_22 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 Steel	180 - 220	0,35 - 0,60	9,0 - 14,0	220 - 260	0,30 - 0,55	3,0 - 9,0	220 - 300	0,25 - 0,50	0,5 - 3,0
◆ Alloyed Steel	70 - 110	0,30 - 0,50	9,0 - 14,0	100 - 150	0,25 - 0,45	3,0 - 9,0	100 - 195	0,20 - 0,40	0,5 - 3,0
◆ Stainless Steel	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,28 - 0,48	9,0 - 14,0	180 - 300	0,25 - 0,45	3,0 - 9,0	200 - 350	0,20 - 0,40	0,5 - 3,0
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ Hard Steel (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