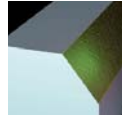


7745 VT 16 Chamfering Cutter



7745 VT 16 Weldon Shank

EDP #	Part Number	Dimensions (mm)							No. of Inserts	Spares		
		D	L	l ₁	d ₁	d ₂	a _{max.}	EDP#		EDP#	EDP#	
023067	7745VT 16 WA030R	30	100	32	20	12	11,3	2	015260	D4008T	015240	T15



Weldon Shank



7745 VT 16 Technical Advice

Milling Cutter Order Example: **7745VT16WA030R**
 Milling Insert Order Example: **TCMT16T308E PFZ**
 For complete cutting conditions refer to page: **264**

Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0,707)

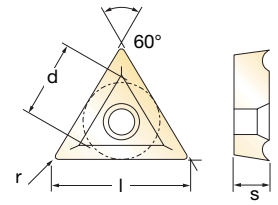
$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$



Depth of Cut (a)



Inserts for 7745 VT 16



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
023382	TCEW 16 T304F	GH1		◆		9,52	16,5	3,97	0,4	0,02

TCEW 16_



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
014399	TCMT 16 T308T	PFZ				9,52	16,5	3,97	0,8	0,15
017745	TCMT 16 T308T	SF30				9,52	16,5	3,97	0,8	0,15
017746	TCMT 16 T308T	X44				9,52	16,5	3,97	0,8	0,15
025801	TCMT 16 T308T	SFZ				9,52	16,5	3,97	0,8	0,15

TCMT 16_



023393	TCMW 16 T308E	GH1				9,52	16,5	3,97	0,8	0,15
--------	---------------	-----	--	--	--	------	------	------	-----	------

TCMW 16_



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	-	-	-	220 - 260	0,05 - 0,20	1,0 - 11,0	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,05 - 0,15	1,0 - 11,0	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,05 - 0,15	1,0 - 11,0	-	-	-
◆ PH Stainless	-	-	-	70 - 85	0,05 - 0,10	1,0 - 11,0	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,05 - 0,15	1,0 - 11,0	-	-	-
◆ Aluminium & Alloys	-	-	-	400 - 750	0,05 - 0,20	1,0 - 11,0	-	-	-
◆ 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