



7745 VT 16 Spot Drill Cutter



7745 VT 16 Weldon Shank		Dimensions (mm)							Spares		
EDP #	Part Number	D	L	l ₁	d ₁	d ₂	a _{max.}	No. of Inserts	EDP#	 EDP#	 EDP#
023066	7745VT 16 WA020R	20	110	50	20	0	11,3	1	015260	D4008T	015240 T15



Weldon Shank



7745 VT 16 Technical Advice

Milling Cutter Order Example: **7745VT16WA020R**
 Milling Insert Order Example: **TCMX16T308E-ZR SFZ**
 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)

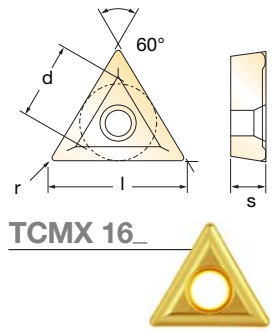
$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$



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
023395	TCMX 16 T308E-ZR	SFZ		◆◆	◆◆◆	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	-	-	-	220 - 260	0,05 - 0,20	0,5 - 3,0	-	-	-
◆ Alloyed Steels	-	-	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,05 - 0,20	0,5 - 3,0	-	-	-
◆ Aluminium & Alloys	-	-	-	400 - 750	0,05 - 0,20	0,5 - 3,0	-	-	-
◆ 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