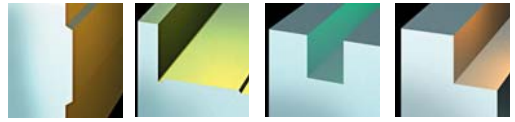


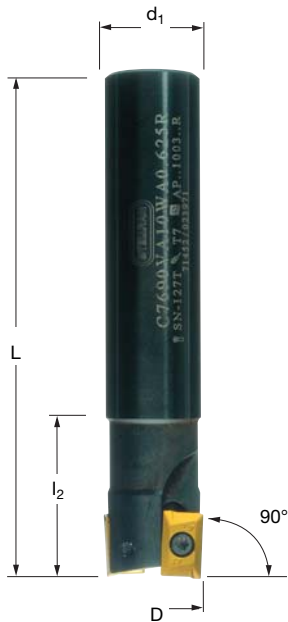


7690 VA 10 Milling Cutter

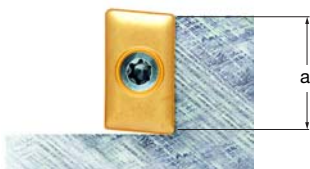


7690 VA 10 Weldon Shank

EDP #	Part Number	Dimensions (inch)						No. of Inserts	Spares		
		D	L/H	l_2	d_1	a	EDP#		 EDP#	 EDP#	
023970	C7690VA10WA.500R	0.500	3.25	1.03	0.625	0.39	1	012769	SN127T	018488	T7
023971	C7690VA10WA.625R	0.625	3.25	1.03	0.625	0.39	2	012769	SN127T	018488	T7
023972	C7690VA10WA.750R	0.750	3.38	1.03	0.750	0.39	3	012769	SN127T	018488	T7
023973	C7690VA10WA1.00R	1.000	3.38	1.03	0.750	0.39	3	012769	SN127T	018488	T7



Weldon Shank



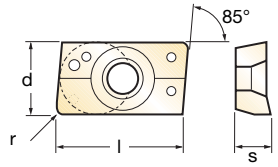
Depth of Cut (a)



7690 VA 10 Technical Advice

Milling Cutter Order Example: **C7690VA10WA.750R**
 Milling Insert Order Example: **APKT1003PDRB-3M MP91M**
 For complete cutting conditions refer to page: **208**

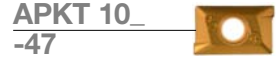
Inserts for 7690 VA 10



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
011676	APKT1003PDRB-3M	MP91M	◆◆◆	◆◆◆	◆	0.265	0.415	0.125	Facet	0.0020
017861	APKT1003PDRJ-3M	GH1	◆	◆	◆	0.265	0.415	0.125	Facet	0.0020



026579	APKT1003PDER-47	MP91M		◆	◆◆◆	0.263	0.413	0.137	Facet	0.0020
026580	APKT1003PDER-47	X500		◆◆	◆◆◆	0.263	0.413	0.137	Facet	0.0020



AP_10 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)	Speed V _C (feet/min)	Feed h _m (inch)	D.O.C. a _p (inch)
◆ Unalloyed Steels	600 - 720	0.006 - 0.009	0.18 - 0.31	730 - 850	0.005 - 0.01	0.08 - 0.18	730 - 980	0.003 - 0.006	0.01 - 0.08
◆ Alloyed Steels	230 - 360	0.005 - 0.008	0.18 - 0.31	330 - 490	0.004 - 0.007	0.08 - 0.18	330 - 630	0.003 - 0.006	0.01 - 0.08
◆ Stainless Steels	-	-	-	460 - 590	0.003 - 0.005	0.08 - 0.18	600 - 750	0.002 - 0.006	0.01 - 0.08
◆ PH Stainless	-	-	-	230 - 270	0.002 - 0.004	0.08 - 0.18	270 - 320	0.002 - 0.004	0.01 - 0.08
◆ Cast Irons	460 - 910	0.004 - 0.006	0.18 - 0.31	600 - 980	0.004 - 0.005	0.08 - 0.18	660 - 1140	0.002 - 0.006	0.01 - 0.08
◆ Aluminum & Alloys	910 - 1470	0.002 - 0.007	0.18 - 0.31	1320 - 2460	0.002 - 0.006	0.08 - 0.18	2300 - 3280	0.002 - 0.006	0.01 - 0.08
◆ High Temp. Alloys	-	-	-	120 - 160	0.002 - 0.004	0.08 - 0.18	150 - 190	0.002 - 0.004	0.01 - 0.08
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations								
	◆	Unalloyed Steels	◆	Stainless Steels	◆	Cast Irons	◆	High Temp. Alloys
	◆	Alloyed Steels	◆	PH Stainless	◆	Aluminum & Alloys	◆	Hard Materials