

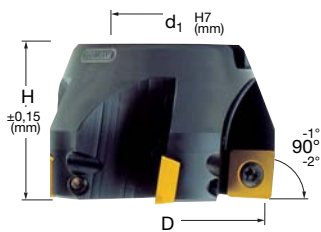


7790 VSE 12 Milling Cutter



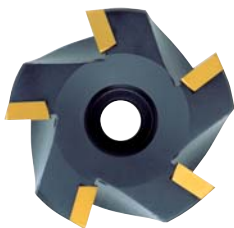
7790 VSE 12 Shell Mill Fixation

EDP #	Part Number	Dimensions (mm)				No. of Inserts	Spares			
		D	H	d ₁	a _{max.}		EDP#	 EDP#	 EDP#	
021812	7790VSE 12 -A063Z05R	63	40	22	10,5	5	015270	F4011T	015241	T20
021813	7790VSE 12 -A080Z06R	80	50	27	10,5	6	015270	F4011T	015241	T20
021814	7790VSE 12 -A100Z08R	100	50	32	10,5	8	015270	F4011T	015241	T20
021815	7790VSE 12 -A125Z09R	125	63	40	10,5	9	015270	F4011T	015241	T20



7790 VSE 12 Technical Advice

Milling Cutter Order Example: **7790VSE12-A100Z08R**
 Milling Insert Order Example: **SDEW120412TN X500**
 For complete cutting conditions refer to page: 264



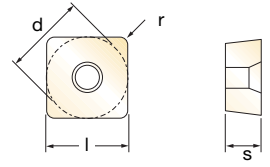
Shell Mill Fixation



Depth of Cut (a)



Inserts for 7790 VSE 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
018206	SDEW 12 0412TN	X500				12,7	12,7	4,76	1,2	0,15
017326	SDMT 12 0412EN-41	MP91M		◆◆		12,7	12,7	4,76	1,2	0,05
015135	SDMT 12 0412EN-41	PFZ				12,7	12,7	4,76	1,2	0,05
014411	SDMT 12 0412EN-41	X500		◆		12,7	12,7	4,76	1,2	0,05
027737	SDMT 12 0412EN-41	SP6564		◆◆		12,7	12,7	4,76	1,2	0,05
017328	SDMW 12 0412TN	MP91M	◆◆			12,7	12,7	4,76	1,2	0,15
015136	SDMW 12 0412TN	PFZ	◆			12,7	12,7	4,76	1,2	0,15
015233	SDMW 12 0412TN	X500				12,7	12,7	4,76	1,2	0,12

SDEW 12_



SDMT 12_
-41



SDMW 12_



SD_12 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	0,15 - 0,30	5,0 - 10,0	220 - 260	0,12 - 0,24	1,5 - 5,0	-	-	-
◆ Alloyed Steels	70 - 110	0,15 - 0,25	5,0 - 10,0	100 - 150	0,10 - 0,22	1,5 - 5,0	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,10 - 0,16	1,5 - 5,0	-	-	-
◆ PH Stainless	-	-	-	70 - 85	0,08 - 0,14	1,5 - 5,0	-	-	-
◆ Cast Irons	140 - 280	0,15 - 0,25	5,0 - 10,0	180 - 300	0,10 - 0,20	1,5 - 5,0	-	-	-
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ 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
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminium & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials