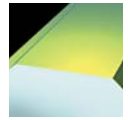


8_0 VOD45_06 Face Mills



8000 VOD45_06 Unequal Pitch - Assembled Body & Cartridge

EDP #	Part Number	Dimensions (inch)						No. of Inserts	EDP#	Cartridge	Spares			
		D	H	d ₁	a	a ₁	EDP#				EDP#	EDP#	EDP#	
026655	A8000VOD45-100R-06	3.94	2.68	1.25	0.173	0.445	6	026587	80VOD45R-06	015270	F4011T	015241	T20	
026656	A8000VOD45-125R-06	4.92	2.48	1.50	0.173	0.445	8	026587	80VOD45R-06	015270	F4011T	015241	T20	
026657	A8000VOD45-160R-06	6.30	2.48	1.50	0.173	0.445	10	026587	80VOD45R-06	015270	F4011T	015241	T20	
026658	A8000VOD45-200R-06	7.87	2.48	2.50	0.173	0.445	12	026587	80VOD45R-06	015270	F4011T	015241	T20	
026659	A8000VOD45-250R-06	9.84	2.48	2.50	0.173	0.445	16	026587	80VOD45R-06	015270	F4011T	015241	T20	
026660	A8000VOD45-315R-06	12.40	3.15	2.50	0.173	0.445	20	026587	80VOD45R-06	015270	F4011T	015241	T20	
026661	A8000VOD45-400R-06	15.75	3.15	2.50	0.173	0.445	24	026587	80VOD45R-06	015270	F4011T	015241	T20	

8010 VOD45_06 Equal Pitch - Assembled Body & Cartridge

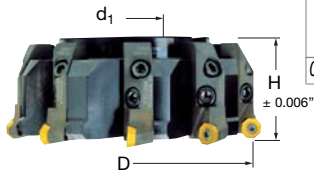
026662	A8010VOD45-100R-06	3.94	2.68	1.25	0.173	0.445	6	026587	80VOD45R-06	015270	F4011T	015241	T20
026663	A8010VOD45-125R-06	4.92	2.48	1.50	0.173	0.445	8	026587	80VOD45R-06	015270	F4011T	015241	T20
026664	A8010VOD45-160R-06	6.30	2.48	1.50	0.173	0.445	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026665	A8010VOD45-200R-06	7.87	2.48	2.50	0.173	0.445	12	026587	80VOD45R-06	015270	F4011T	015241	T20

8100 VOD45_06 Unequal Pitch - Assembled Body & Cartridge

026666	A8100VOD45-125R-06	4.92	2.48	1.50	0.173	0.445	6	026587	80VOD45R-06	015270	F4011T	015241	T20
026667	A8100VOD45-160R-06	6.30	2.48	1.50	0.173	0.445	8	026587	80VOD45R-06	015270	F4011T	015241	T20
026668	A8100VOD45-200R-06	7.87	2.48	2.50	0.173	0.445	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026669	A8100VOD45-250R-06	9.84	2.48	2.50	0.173	0.445	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026670	A8100VOD45-315R-06	12.40	3.15	2.50	0.173	0.445	12	026587	80VOD45R-06	015270	F4011T	015241	T20
026671	A8100VOD45-400R-06	15.75	3.15	2.50	0.173	0.445	14	026587	80VOD45R-06	015270	F4011T	015241	T20

8_0 VOD45_06 Cartridge Spares

EDP #	Cartridge Part Number	EDP#	EDP#
026587	80VOD45R-06	015255	7065



Cutter Body & Cartridge

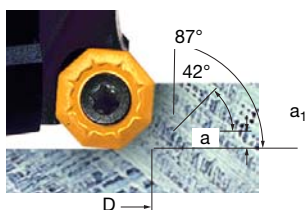
8_0 VOD45_06 Technical Advice

Milling Cutter Order Example: **A8000VOD45-400R-06**
 Milling Insert Order Example: **ODMT0605APEN-41 MP91M**
 For complete cutting conditions refer to page: **208**



Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0.707)

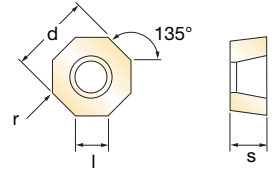
$$\text{ie: } \frac{h_m}{0.707} \quad \text{or} \quad \frac{0.004''}{0.707} = 0.0056 \text{ in. programmed feed rate}$$



Depth of Cut (a)



Inserts for 8_0 VOD45_06



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
026591	OJET0605APEN-44	MP91M			◆◆	0.630	0.630	0.219	Facet	0.0016
026598	OJET0605APEN-44	SP4036			◆◆◆	0.630	0.630	0.219	Facet	0.0016
026592	OJET0605APEN-44	X500			◆◆	0.630	0.630	0.219	Facet	0.0016
026588	OJET0605APFN-441	GH1	◆	◆	◆	0.630	0.630	0.219	Facet	0.0008
025836	ODMT0605APEN-41	MP91M		◆◆		0.630	0.630	0.219	Facet	0.0016
026837	ODMT0605APEN-41	SP0436		◆◆◆		0.630	0.630	0.219	Facet	0.0016
026590	ODMT0605APEN-41	X500	◆	◆◆		0.630	0.630	0.219	Facet	0.0016
025836	ODMW060512SN	MP91M	◆			0.630	0.630	0.219	0.047	0.0106
026837	ODMW060512SN	SF30				0.630	0.630	0.219	0.047	0.0106
025838	ODMW060512SN	X500				0.630	0.630	0.219	0.047	0.0106
027743	ODMW060512SN	SP6564	◆◆			0.630	0.630	0.219	0.047	0.0106
026595	ODMW060512TN	MP91M	◆			0.630	0.630	0.219	0.047	0.0067
026599	ODMW060512TN	SP4036		◆		0.630	0.630	0.219	0.047	0.0067
026596	ODMW060512TN	X500	◆			0.630	0.630	0.219	0.047	0.0067



OD_06 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	0.012 - 0.028	0.10 - 0.18	730 - 850	0.008 - 0.016	0.04 - 0.08	730 - 980	0.003 - 0.006	0.01 - 0.04
◆ Alloyed Steels	230 - 360	0.011 - 0.020	0.10 - 0.18	330 - 490	0.008 - 0.014	0.04 - 0.08	330 - 630	0.003 - 0.006	0.01 - 0.04
◆ Stainless Steels	400 - 450	0.011 - 0.016	0.10 - 0.18	460 - 590	0.006 - 0.010	0.04 - 0.08	600 - 750	0.002 - 0.006	0.01 - 0.04
◆ PH Stainless	190 - 220	0.006 - 0.012	0.10 - 0.18	230 - 270	0.004 - 0.008	0.04 - 0.08	270 - 320	0.002 - 0.004	0.01 - 0.04
◆ Cast Irons	460 - 910	0.008 - 0.018	0.10 - 0.18	600 - 980	0.006 - 0.012	0.04 - 0.08	660 - 1140	0.002 - 0.006	0.01 - 0.04
◆ Aluminum & Alloys	910 - 1470	0.008 - 0.014	0.10 - 0.18	1320 - 2460	0.004 - 0.010	0.04 - 0.08	2300 - 3280	0.002 - 0.006	0.01 - 0.04
◆ High Temp. Alloys	90 - 130	0.007 - 0.010	0.10 - 0.18	120 - 160	0.004 - 0.008	0.04 - 0.08	150 - 190	0.002 - 0.004	0.01 - 0.04
◆ Hard Steels (52-56 HRC)	-	-	-	170 - 270	0.002 - 0.005	0.02 - 0.06	170 - 320	0.001 - 0.002	0.01 - 0.02

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	Aluminum & Alloys
				◆ S	High Temp. Alloys	
				◆ H	Hard Materials	