8000 VOD45_ 06 Unequal Pitch - Assembled Body & Cartridge

		Dimensions (mm)						Spares				
EDP #	Part Number	D	H	d_1	a	a_1 max.	No. of Inserts	EDP#	Cartridge	EDP#		EDP#	
026638	**8000VOD45-100R- 06**	100	68	32	4,5	10,0	6	026587	80VOD45R-06	015270	F4011T	015241	T20
026639	**8000VOD45-125R- 06**	125	63	40	4,5	10,0	8	026587	80VOD45R-06	015270	F4011T	015241	T20
026640	**8000VOD45-160R- 06**	160	63	40	4,5	10,0	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026641	**8000VOD45-200R- 06**	200	63	60	4,5	10,0	12	026587	80VOD45R-06	015270	F4011T	015241	T20
026642	**8000VOD45-250R- 06**	250	63	60	4,5	10,0	16	026587	80VOD45R-06	015270	F4011T	015241	T20
026643	**8000VOD45-315R- 06**	315	80	60	4,5	10,0	20	026587	80VOD45R-06	015270	F4011T	015241	T20
026644	**8000VOD45-400R- 06**	400	80	60	4,5	10,0	24	026587	80VOD45R-06	015270	F4011T	015241	T20

8010 VOD45_ 06 Equal Pitch - Assembled Body & Cartridge

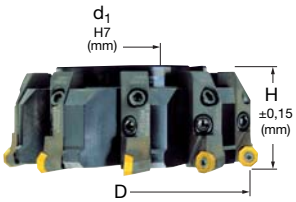
026645	**8010VOD45-100R- 06**	100	68	32	4,5	10,0	6	026587	80VOD45R-06	015270	F4011T	015241	T20
026646	**8010VOD45-125R- 06**	125	63	40	4,5	10,0	8	026587	80VOD45R-06	015270	F4011T	015241	T20
026647	**8010VOD45-160R- 06**	160	63	40	4,5	10,0	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026648	**8010VOD45-200R- 06**	200	63	60	4,5	10,0	12	026587	80VOD45R-06	015270	F4011T	015241	T20

8100 VOD45_ 06 Unequal Pitch - Assembled Body & Cartridge

026649	**8100VOD45-125R- 06**	125	63	40	4,5	10,0	6	026587	80VOD45R-06	015270	F4011T	015241	T20
026650	**8100VOD45-160R- 06**	160	63	40	4,5	10,0	8	026587	80VOD45R-06	015270	F4011T	015241	T20
026651	**8100VOD45-200R- 06**	200	63	60	4,5	10,0	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026652	**8100VOD45-250R- 06**	250	63	60	4,5	10,0	10	026587	80VOD45R-06	015270	F4011T	015241	T20
026653	**8100VOD45-315R- 06**	315	80	60	4,5	10,0	12	026587	80VOD45R-06	015270	F4011T	015241	T20
026654	**8100VOD45-400R- 06**	400	80	60	4,5	10,0	14	026587	80VOD45R-06	015270	F4011T	015241	T20

8_0 VOD45_ 06 Cartridge Spares

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



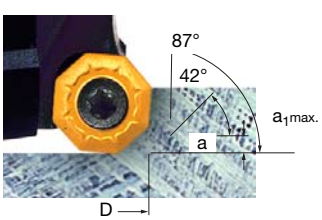
Cutter Body & Cartridge

8_0 VOD45_ 06 Technical Advice

Milling Cutter Order Example: **8000VOD45-400R-06**
Milling Insert Order Example: **ODMT0605APEN-41 MP91M**
For complete cutting conditions refer to page: **264**

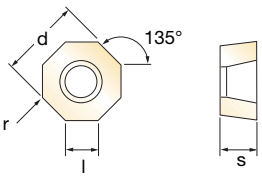
Feedrate compensation: For 45° cutting, divide the h_m value by the sine of the approach angle (the sine of 45° = 0,707)

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



Depth of Cut (a)

Inserts for 8_0 VOD45_ 06



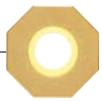
EDP#	Part Number	Grade	Application & Material: Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
026591	ODET 06 05APEN-44	MP91M			◆◆	16,0	6,0	5,55	Facet	0,04
026598	ODET 06 05APEN-44	SP4036			◆◆◆	16,0	6,0	5,55	Facet	0,04
026592	ODET 06 05APEN-44	X500			◆◆	16,0	6,0	5,55	Facet	0,04
026588	ODET 06 05APFN-441	GH1	◆	◆	◆	16,0	6,0	5,55	Facet	0,02
026589	ODMT 06 05APEN-41	MP91M		◆◆		16,0	6,0	5,55	Facet	0,04
026597	ODMT 06 05APEN-41	SP4036		◆◆		16,0	6,0	5,55	Facet	0,04
026590	ODMT 06 05APEN-41	X500	◆	◆◆		16,0	6,0	5,55	Facet	0,04
025836	ODMW 06 0512SN	MP91M	◆			16,0	6,0	5,55	1,2	0,27
025837	ODMW 06 0512SN	SF30				16,0	6,0	5,55	1,2	0,27
025838	ODMW 06 0512SN	X500				16,0	6,0	5,55	1,2	0,27
027743	ODMW 06 0512SN	SP6564	◆◆			16,0	6,0	5,55	1,2	0,27
026595	ODMW 06 0512TN	MP91M	◆			16,0	6,0	5,55	1,2	0,17
026599	ODMW 06 0512TN	SP4036		◆		16,0	6,0	5,55	1,2	0,17
026596	ODMW 06 0512TN	X500	◆			16,0	6,0	5,55	1,2	0,17

ODET 06_ -44

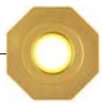
ODET 06_ -441

ODMT 06_ -41

ODMW 06_ -SN



ODMW 06_ -TN



OD_06 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼ Semi-Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼▼ Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)
◆ Unalloyed Steels	180 - 220	0,30 - 0,70	2,5 - 4,5	220 - 260	0,20 - 0,40	1,0 - 2,0	220 - 300	0,08 - 0,15	0,2 - 1,0
◆ Alloyed Steels	70 - 110	0,27 - 0,50	2,5 - 4,5	100 - 150	0,20 - 0,35	1,0 - 2,0	100 - 195	0,08 - 0,15	0,2 - 1,0
◆ Stainless Steels	120 - 140	0,27 - 0,40	2,5 - 4,5	140 - 180	0,15 - 0,25	1,0 - 2,0	180 - 230	0,05 - 0,15	0,2 - 1,0
◆ PH Stainless	55 - 70	0,15 - 0,30	2,5 - 4,5	70 - 85	0,10 - 0,20	1,0 - 2,0	80 - 100	0,05 - 0,10	0,2 - 1,0
◆ Cast Irons	140 - 280	0,20 - 0,45	2,5 - 4,5	180 - 300	0,15 - 0,30	1,0 - 2,0	200 - 350	0,05 - 0,15	0,2 - 1,0
◆ Aluminium & Alloys	275 - 450	0,20 - 0,35	2,5 - 4,5	400 - 750	0,10 - 0,25	1,0 - 2,0	700 - 1000	0,05 - 0,15	0,2 - 1,0
◆ High Temp. Alloys	25 - 40	0,17 - 0,25	2,5 - 4,5	35 - 50	0,10 - 0,20	1,0 - 2,0	45 - 60	0,05 - 0,10	0,2 - 1,0
◆ Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,06 - 0,12	0,5 - 1,5	50 - 100	0,03 - 0,06	0,2 - 0,5

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

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