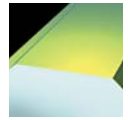


8_0 VR00_16 Face Mills



8000 VR00_16 Unequal Pitch - Assembled Body & Cartridge

EDP #	Part Number	Dimensions (inch)					No. of Inserts	EDP#	Cartridge	Spares		
		D	H	d ₁	a					EDP#	EDP#	EDP#
015303	A8000VR00-100R	3.94	2.68	1.25	0.31	6	014316	80VRP00R-16	015266	D5013T	015241	T20
015304	A8000VR00-125R	4.92	2.48	1.50	0.31	8	014316	80VRP00R-16	015266	D5013T	015241	T20
015305	A8000VR00-160R	6.30	2.48	1.50	0.31	10	014316	80VRP00R-16	015266	D5013T	015241	T20
015306	A8000VR00-200R	7.87	2.48	2.50	0.31	12	014316	80VRP00R-16	015266	D5013T	015241	T20
015307	A8000VR00-250R	9.84	2.48	2.50	0.31	16	014316	80VRP00R-16	015266	D5013T	015241	T20
015308	A8000VR00-315R	12.40	3.15	2.50	0.31	20	014316	80VRP00R-16	015266	D5013T	015241	T20
015309	A8000VR00-400R	15.75	3.15	2.50	0.31	24	014316	80VRP00R-16	015266	D5013T	015241	T20

8010 VR00_16 Equal Pitch - Assembled Body & Cartridge

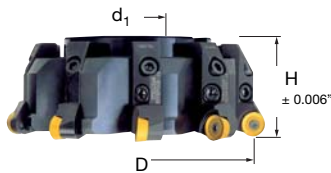
016785	A8100VR00-125R	4.92	2.48	1.50	0.31	6	014316	80VRP00R-16	015266	D5013T	015241	T20
016786	A8100VR00-160R	6.30	2.48	1.50	0.31	8	014316	80VRP00R-16	015266	D5013T	015241	T20
016787	A8100VR00-200R	7.87	2.48	2.50	0.31	10	014316	80VRP00R-16	015266	D5013T	015241	T20
016788	A8100VR00-250R	9.84	2.48	2.50	0.31	10	014316	80VRP00R-16	015266	D5013T	015241	T20

8100 VR00_16 Unequal Pitch - Assembled Body & Cartridge

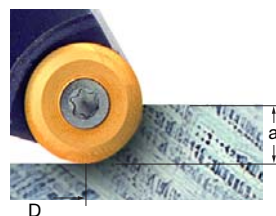
015594	A8100VR00-125R	4.92	2.48	1.50	0.31	6	014316	80VRP00R-16	015266	D5013T	015241	T20
015595	A8100VR00-160R	6.30	2.48	1.50	0.31	8	014316	80VRP00R-16	015266	D5013T	015241	T20
015596	A8100VR00-200R	7.87	2.48	2.50	0.31	10	014316	80VRP00R-16	015266	D5013T	015241	T20
015597	A8100VR00-250R	9.84	2.48	2.50	0.31	10	014316	80VRP00R-16	015266	D5013T	015241	T20
015598	A8100VR00-315R	12.40	3.15	2.50	0.31	12	014316	80VRP00R-16	015266	D5013T	015241	T20
015599	A8100VR00-400R	15.75	3.15	2.50	0.31	14	014316	80VRP00R-16	015266	D5013T	015241	T20

8_0 VR00_16 Cartridge Spares

EDP #	Cartridge Part Number	EDP#	EDP#
014316	80VRP00R-16	015255	7065



Cutter Body & Cartridge



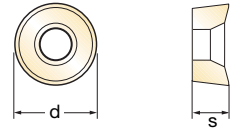
Depth of Cut (a)

8_0 VR00_16 Technical Advice

Milling Cutter Order Example: **A8000VR00-400R**
 Milling Insert Order Example: **RPET1606M0E SFZ**
 For complete cutting conditions refer to page: **208**



Inserts for 8_0 VR00_16



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017683	RPET1606M0E	SF30				0.630	-	0.250	0.315	0.0012
017685	RPET1606M0E	SFZ		◆◆	◆◆◆	0.630	-	0.250	0.315	0.0012
017684	RPET1606M0E	X44				0.630	-	0.250	0.315	0.0012
015131	RPHT1606M0E-421	PFZ			◆◆◆	0.630	-	0.250	0.315	0.0016
024151	RPHT1606M0E-421	X500		◆◆	◆◆◆	0.630	-	0.250	0.315	0.0016
017311	RPMT1606M0E-41	MP91M	◆◆◆	◆◆◆		0.630	-	0.250	0.315	0.0020
015223	RPMT1606M0E-41	X500	◆◆	◆◆		0.630	-	0.250	0.315	0.0020

RPET 16_



RPHT 16_-421



RPMT 16_-41



RP_16 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	0.12 - 0.31	730 - 850	0.008 - 0.016	0.04 - 0.12	730 - 980	0.003 - 0.006	0.01 - 0.04
◆ Alloyed Steels	230 - 360	0.010 - 0.024	0.12 - 0.31	330 - 490	0.008 - 0.014	0.04 - 0.12	330 - 630	0.003 - 0.006	0.01 - 0.04
◆ Stainless Steels	400 - 450	0.010 - 0.018	0.12 - 0.31	460 - 590	0.006 - 0.010	0.04 - 0.12	600 - 750	0.002 - 0.006	0.01 - 0.04
◆ PH Stainless	-	-	-	230 - 270	0.004 - 0.008	0.04 - 0.12	270 - 320	0.002 - 0.004	0.01 - 0.04
◆ Cast Irons	460 - 910	0.008 - 0.016	0.12 - 0.31	600 - 980	0.006 - 0.010	0.04 - 0.12	660 - 1140	0.002 - 0.006	0.01 - 0.04
◆ Aluminum & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	120 - 160	0.004 - 0.008	0.04 - 0.12	150 - 190	0.002 - 0.004	0.01 - 0.04
◆ Hard Steels (52-56 HRC)	-	-	-	170 - 270	0.001 - 0.003	0.04 - 0.10	170 - 320	0.001 - 0.002	0.01 - 0.04

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	Aluminum & Alloys	◆ H	Hard Materials