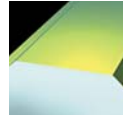




# 8\_0 VR00\_16 Face Mills



## 8000 VR00\_16 Unequal Pitch - Assembled Body & Cartridge

EDP #	Part Number	Dimensions (mm)					No. of Inserts	EDP#	Cartridge	EDP#	Spares	
		D	H	d <sub>1</sub>	a							
021844	8000VR00-100R	100	68	32	8	6	014316	80VRP00R-16	015266	D5013T	015241	T20
021845	8000VR00-125R	125	63	40	8	8	014316	80VRP00R-16	015266	D5013T	015241	T20
021846	8000VR00-160R	160	63	40	8	10	014316	80VRP00R-16	015266	D5013T	015241	T20
021847	8000VR00-200R	200	63	60	8	12	014316	80VRP00R-16	015266	D5013T	015241	T20
021848	8000VR00-250R	250	63	60	8	16	014316	80VRP00R-16	015266	D5013T	015241	T20
021849	8000VR00-315R	315	80	60	8	20	014316	80VRP00R-16	015266	D5013T	015241	T20
021850	8000VR00-400R	400	80	60	8	24	014316	80VRP00R-16	015266	D5013T	015241	T20

## 8010 VR00\_16 Equal Pitch - Assembled Body & Cartridge

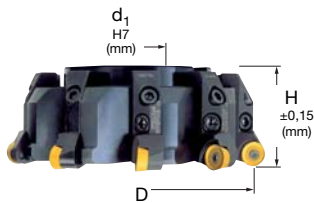
021940	8010VR00-100R	100	68	32	8	6	014316	80VRP00R-16	015266	D5013T	015241	T20
021941	8010VR00-125R	125	63	40	8	8	014316	80VRP00R-16	015266	D5013T	015241	T20
021942	8010VR00-160R	160	63	40	8	10	014316	80VRP00R-16	015266	D5013T	015241	T20
021943	8010VR00-200R	200	63	60	8	12	014316	80VRP00R-16	015266	D5013T	015241	T20

## 8100 VR00\_16 Unequal Pitch - Assembled Body & Cartridge

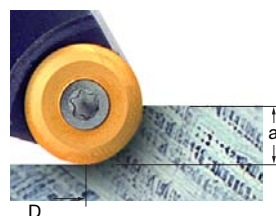
021988	8100VR00-125R	125	63	40	8	6	014316	80VRP00R-16	015266	D5013T	015241	T20
021989	8100VR00-160R	160	63	40	8	8	014316	80VRP00R-16	015266	D5013T	015241	T20
021990	8100VR00-200R	200	63	60	8	10	014316	80VRP00R-16	015266	D5013T	015241	T20
021991	8100VR00-250R	250	63	60	8	10	014316	80VRP00R-16	015266	D5013T	015241	T20
021992	8100VR00-315R	315	80	60	8	12	014316	80VRP00R-16	015266	D5013T	015241	T20
021993	8100VR00-400R	400	80	60	8	14	014316	80VRP00R-16	015266	D5013T	015241	T20

## 8\_0 VR00\_16 Cartridge Spares

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



Cutter Body & Cartridge



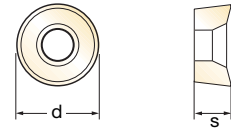
Depth of Cut (a)

## 8\_0 VR00\_16 Technical Advice

Milling Cutter Order Example: **8000VR00-400R**  
 Milling Insert Order Example: **RPET1606MOE SFZ**  
 For complete cutting conditions refer to page: **264**



## Inserts for 8\_0 VR00\_ 16



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
017683	RPET 16 06M0E	SF30				16,0	-	6,35	8,0	0,03
017685	RPET 16 06M0E	SFZ		◆◆	◆◆◆	16,0	-	6,35	8,0	0,03
017684	RPET 16 06M0E	X44				16,0	-	6,35	8,0	0,03
015131	RPHT 16 06M0E-421	PFZ			◆◆	16,0	-	6,35	8,0	0,04
024151	RPHT 16 06M0E-421	X500		◆◆	◆◆	16,0	-	6,35	8,0	0,04
017311	RPMT 16 06M0E-41	MP91M	◆◆◆	◆◆		16,0	-	6,35	8,0	0,05
015223	RPMT 16 06M0E-41	X500	◆◆	◆◆		16,0	-	6,35	8,0	0,05



## RP\_16 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)
◆ Unalloyed Steels	180 - 220	0,30 - 0,70	3,0 - 8,0	220 - 260	0,20 - 0,40	1,0 - 3,0	220 - 300	0,08 - 0,15	0,2 - 1,0
◆ Alloyed Steels	70 - 110	0,25 - 0,60	3,0 - 8,0	100 - 150	0,20 - 0,35	1,0 - 3,0	100 - 195	0,08 - 0,15	0,2 - 1,0
◆ Stainless Steels	120 - 140	0,25 - 0,45	3,0 - 8,0	140 - 180	0,15 - 0,25	1,0 - 3,0	180 - 230	0,05 - 0,15	0,2 - 1,0
◆ PH Stainless	-	-	-	70 - 85	0,10 - 0,20	1,0 - 3,0	80 - 100	0,05 - 0,10	0,2 - 1,0
◆ Cast Irons	140 - 280	0,20 - 0,40	3,0 - 8,0	180 - 300	0,15 - 0,25	1,0 - 3,0	200 - 350	0,05 - 0,15	0,2 - 1,0
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	35 - 50	0,10 - 0,20	1,0 - 3,0	45 - 60	0,05 - 0,10	0,2 - 1,0
◆ Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,03 - 0,08	1,0 - 2,5	50 - 100	0,03 - 0,06	0,2 - 1,0

h<sub>m</sub> = 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