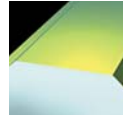




8_0 VS45_12 Face Mills



8000 VS45_12 Unequal Pitch - Assembled Body & Cartridge

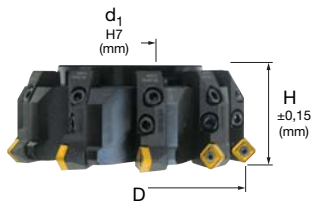
EDP #	Part Number	Dimensions (mm)					No. of Inserts	EDP#	Cartridge	Spares		
		D	H	d ₁	a	EDP#					EDP#	
021851	8000VS45-100R	100	68	32	7	6	014946	80VS45R-12	015266	D5013T	015241	T20
021852	8000VS45-125R	125	63	40	7	8	014946	80VS45R-12	015266	D5013T	015241	T20
021853	8000VS45-160R	160	63	40	7	10	014946	80VS45R-12	015266	D5013T	015241	T20
021854	8000VS45-200R	200	63	60	7	12	014946	80VS45R-12	015266	D5013T	015241	T20
021855	8000VS45-250R	250	63	60	7	16	014946	80VS45R-12	015266	D5013T	015241	T20
021856	8000VS45-315R	315	80	60	7	20	014946	80VS45R-12	015266	D5013T	015241	T20
021857	8000VS45-400R	400	80	60	7	24	014946	80VS45R-12	015266	D5013T	015241	T20

8100 VS45_12 Unequal Pitch - Assembled Body & Cartridge

021994	8100VS45-125R	125	63	40	7	6	014946	80VS45R-12	015266	D5013T	015241	T20
021995	8100VS45-160R	160	63	40	7	8	014946	80VS45R-12	015266	D5013T	015241	T20
021996	8100VS45-200R	200	63	60	7	10	014946	80VS45R-12	015266	D5013T	015241	T20
021997	8100VS45-250R	250	63	60	7	10	014946	80VS45R-12	015266	D5013T	015241	T20
021998	8100VS45-315R	315	80	60	7	12	014946	80VS45R-12	015266	D5013T	015241	T20
021999	8100VS45-400R	400	80	60	7	14	014946	80VS45R-12	015266	D5013T	015241	T20

8_0 VS45_12 Cartridge Spares

EDP #	Cartridge Part Number	EDP#	
014946	80VS45R-12	015255	7065



Cutter Body & Cartridge

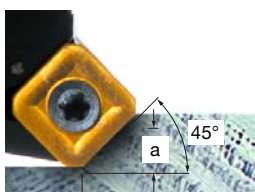


8_0 VS45_12 Technical Advice

Milling Cutter Order Example: **8000VS45-315R**
 Milling Insert Order Example: **SCMT12M512EN-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)

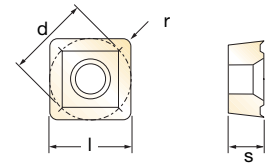
$$\text{ie: } \frac{h_m}{0,707} \quad \text{or} \quad \frac{0,08}{0,707} = 0,113 \text{ mm programmed feed rate}$$



Depth of Cut (a)



Inserts for 8_0 VS45_ 12



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017312	SCCT 12 M5ACER	MP91M		▼	▼	12,7	12,7	5,0	Facet	0,03
025811	SCCT 12 M5ACTR	SP4036		◆	◆◆◆◆	12,7	12,7	5,0	Facet	0,15
017695	SCCT 12 M5ACTR	GH1			◆◆◆◆	12,7	12,7	5,0	Facet	0,15
017693	SCCT 12 M5ACTR	SF30				12,7	12,7	5,0	Facet	0,15
017696	SCCT 12 M5ACTR	SFZ				12,7	12,7	5,0	Facet	0,15
017694	SCCT 12 M5ACTR	X44				12,7	12,7	5,0	Facet	0,15
017697	SCHT 12 M5ACTN	PFZ		◆◆		12,7	12,7	5,0	Facet	0,15
017698	SCHT 12 M5ACTN	X500		◆		12,7	12,7	5,0	Facet	0,15
015144	SCKT 12 M5ACSN-41	X500	◆			12,7	12,7	5,0	Facet	0,12
017314	SCKT 12 M5ACSN-41	MP91M	◆◆			12,7	12,7	5,0	Facet	0,12
017699	SCKT 12 M5ACSN-41	PFZ	◆◆			12,7	12,7	5,0	Facet	0,12
024083	SCKT 12 M5ACSN-41	SF30	◆◆			12,7	12,7	5,0	Facet	0,12
017706	SCMT 12 M508E	SF30				12,7	12,7	5,0	0,8	0,15
024944	SCMT 12 M508E	X44				12,7	12,7	5,0	0,8	0,15
017707	SCMT 12 M512E	SF30				12,7	12,7	5,0	1,2	0,15
017709	SCMT 12 M512T	GH1				12,7	12,7	5,0	1,2	0,15
017316	SCMT 12 M512T	MP91M				12,7	12,7	5,0	1,2	0,15
015227	SCMT 12 M512T	PFZ				12,7	12,7	5,0	1,2	0,15
017708	SCMT 12 M512T	SF30				12,7	12,7	5,0	1,2	0,15
017710	SCMT 12 M512T	SFZ				12,7	12,7	5,0	1,2	0,15
015228	SCMT 12 M512T	X44				12,7	12,7	5,0	1,2	0,15
024129	SCMT 12 M512T	X500				12,7	12,7	5,0	1,2	0,12
017317	SCMT 12 M512EN-41	MP91M				12,7	12,7	5,0	1,2	0,05
024108	SCMT 12 M512EN-41	PFZ				12,7	12,7	5,0	1,2	0,05
015226	SCMT 12 M512EN-41	X500				12,7	12,7	5,0	1,2	0,05
027732	SCMT 12 M512EN-41	SP6564				12,7	12,7	5,0	1,2	0,05

SCCT 12_ 

SCHT 12_ 

SCKT 12_ -41 

SCMT 12_ 

SCMT 12_ -41 

SC_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	0,20 - 0,60	3,5 - 7,0	220 - 260	0,20 - 0,45	1,0 - 3,5	220 - 300	0,15 - 0,28	0,2 - 1,0
◆ Alloyed Steels	70 - 110	0,20 - 0,45	3,5 - 7,0	100 - 150	0,20 - 0,40	1,0 - 3,5	100 - 195	0,15 - 0,28	0,2 - 1,0
◆ Stainless Steels	120 - 140	0,20 - 0,35	3,5 - 7,0	140 - 180	0,15 - 0,30	1,0 - 3,5	180 - 230	0,15 - 0,28	0,2 - 1,0
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,15 - 0,40	3,5 - 7,0	180 - 300	0,15 - 0,30	1,0 - 3,5	200 - 350	0,15 - 0,28	0,2 - 1,0
◆ Aluminium & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ Hard Steels (52-56 HRC)	-	-	-	50 - 85	0,06 - 0,12	1,0 - 2,5	50 - 100	0,04 - 0,08	0,2 - 1,0

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	