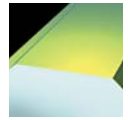




8_0 VT60_22 Face Mills



8000 VT60_22 Unequal Pitch - Assembled Body & Cartridge

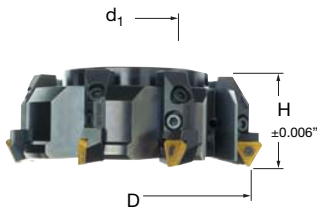
EDP #	Part Number	Dimensions (inch)					No. of Inserts	EDP#	Cartridge	Spares			
		D	H	d ₁	a					EDP#		EDP#	
015568	A8000VT60-100R	3.94	2.68	1.25	0.55	6	015394	80VT60R-22	015266	D5013T	015241	T20	
015569	A8000VT60-125R	4.92	2.48	1.50	0.55	8	015394	80VT60R-22	015266	D5013T	015241	T20	
015570	A8000VT60-160R	6.30	2.48	1.50	0.55	10	015394	80VT60R-22	015266	D5013T	015241	T20	
015571	A8000VT60-200R	7.87	2.48	2.50	0.55	12	015394	80VT60R-22	015266	D5013T	015241	T20	
015572	A8000VT60-250R	9.84	2.48	2.50	0.55	16	015394	80VT60R-22	015266	D5013T	015241	T20	
015573	A8000VT60-315R	12.40	3.15	2.50	0.55	20	015394	80VT60R-22	015266	D5013T	015241	T20	
015574	A8000VT60-400R	15.75	3.15	2.50	0.55	24	015394	80VT60R-22	015266	D5013T	015241	T20	

8100 VT60_22 Unequal Pitch - Assembled Body & Cartridge

015642	A8100VT60-125R	4.92	2.48	1.50	0.55	6	015394	80VT60R-22	015266	D5013T	015241	T20
015643	A8100VT60-160R	6.30	2.48	1.50	0.55	8	015394	80VT60R-22	015266	D5013T	015241	T20
015644	A8100VT60-200R	7.87	2.48	2.50	0.55	10	015394	80VT60R-22	015266	D5013T	015241	T20
015645	A8100VT60-250R	9.84	2.48	2.50	0.55	10	015394	80VT60R-22	015266	D5013T	015241	T20
015646	A8100VT60-315R	12.40	3.15	2.50	0.55	12	015394	80VT60R-22	015266	D5013T	015241	T20
015647	A8100VT60-400R	15.75	3.15	2.50	0.55	14	015394	80VT60R-22	015266	D5013T	015241	T20

8_0 VT60_22 Cartridge Spares

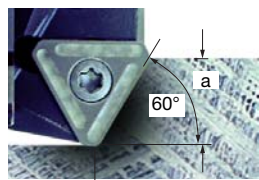
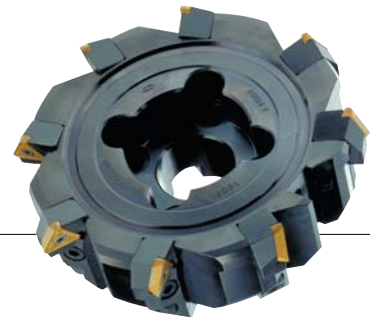
EDP #	Cartridge Part Number	EDP#	
015394	80VT60R-22	015255	7065



Cutter Body & Cartridge

8_0 VT60_22 Technical Advice

Milling Cutter Order Example: **A8100VT60-400R**
 Milling Insert Order Example: **TNHT2204DDTR PFZ**
 For complete cutting conditions refer to page: 208

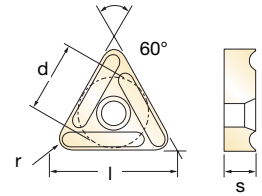


Depth of Cut (a)

Feedrate compensation: For 60° cutting, divide the h_m value by the sine of the approach angle (the sine of 60° = 0.866)

$$\text{ie: } \frac{h_m}{0.866} \quad \text{or} \quad \frac{0.006''}{0.866} = 0.0069 \text{ in. programmed feed rate}$$

Inserts for 8_0 VT60_ 22



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017284	TNCT2204DDTR	GH1	◆	◆	◆	0.500	0.472	0.187	Facet	0.0059
017285	TNCT2204DDTR	SF30				0.500	0.472	0.187	Facet	0.0059

TNCT 22_



024084	TNHT2204DDTR	PFZ	◆◆	◆◆	◆◆	0.500	0.866	0.187	Facet	0.0059
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TNHT 22_



TN_22 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 Steel	600 - 720	0.014 - 0.024	0.35 - 0.55	730 - 850	0.012 - 0.022	0.12 - 0.35	730 - 980	0.010 - 0.020	0.02 - 0.12
◆ Alloyed Steel	230 - 360	0.012 - 0.020	0.35 - 0.55	330 - 490	0.010 - 0.018	0.12 - 0.35	330 - 630	0.008 - 0.016	0.02 - 0.12
◆ Stainless Steel	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	460 - 910	0.011 - 0.019	0.35 - 0.55	600 - 980	0.010 - 0.018	0.12 - 0.35	660 - 1140	0.008 - 0.016	0.02 - 0.12
◆ Aluminum & Alloys	-	-	-	-	-	-	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ Hard Steel (52-56 HRC)	-	-	-	-	-	-	-	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations								
	◆	Unalloyed Steels	◆	Stainless Steels	◆	Cast Irons	◆	High Temp. Alloys
	◆	Alloyed Steels	◆	PH Stainless	◆	Aluminum & Alloys	◆	Hard Materials