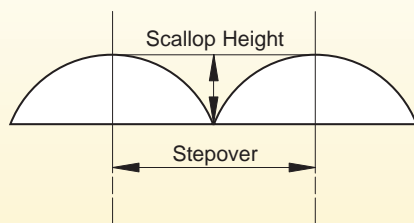
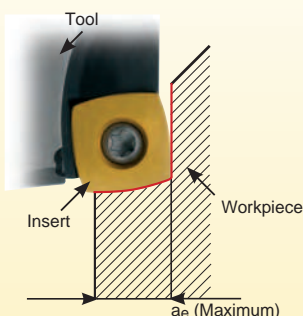




**Plunging**



The cutting edge should not be in contact with the material face after machining to maintain the cutting edge quality.

The scallop height is calculated in relation to the step over.



The maximum radial engagement is directly in relation to insert cutting edge length.

For insert type: **XP...06** the  $a_e$ , max is 3mm.

For insert type: **XD...09** the  $a_e$ , max is 6mm.

For insert type: **XD...12** the  $a_e$ , max is 9mm.

For insert type: **XE...16** the  $a_e$ , max is 13mm.

**Plunging Information** (mm) tool definition-scallop height and step over

	Tool definition (mm)																				
	7792VXP06				7792VXD09				7792VXD12								7792VXE16				
Diameter	16	20	25	32	25	32	40	50	32	52	63	66	80	100	125	160	63	80	100	125	160
Insert size	6	6	6	6	9	9	9	9	12	12	12	12	12	12	12	12	16	16	16	16	16
$a_e$ max	3	3	3	3	6	6	6	6	9	9	9	9	9	9	9	9	13	13	13	13	13
Scallop height	Step over (mm)																				
0,25	3,97	4,44	4,97	5,63	4,97	5,63	6,30	7,05	5,63	7,19	7,92	8,11	8,93	9,99	11,17	12,64	7,92	8,93	9,99	11,17	12,64
0,50	5,57	6,24	7,00	7,94	7,00	7,94	8,89	9,95	7,94	10,15	11,18	11,44	12,61	14,11	15,78	17,86	11,18	12,61	14,11	15,78	17,86
0,75	6,76	7,60	8,53	9,68	8,53	9,68	10,85	12,16	9,68	12,40	13,67	13,99	15,42	17,26	19,31	21,86	13,67	15,42	17,26	19,31	21,86
1,00	7,75	8,72	9,80	11,14	9,80	11,14	12,49	14,00	11,14	14,28	15,75	16,12	17,78	19,90	22,27	25,22	15,75	17,78	19,90	22,27	25,22
2,00	10,58	12,00	13,56	15,49	13,56	15,49	17,44	19,60	15,49	20,00	22,09	22,63	24,98	28,00	31,37	35,55	22,09	24,98	28,00	31,37	35,55
3,00	12,49	14,28	16,25	18,65	16,25	18,65	21,07	23,75	18,65	24,25	26,83	27,49	30,40	34,12	38,26	43,41	26,83	30,40	34,12	38,26	43,41
4,00					18,33	21,17	24,00	27,13	21,17	27,71	30,72	31,50	34,87	39,19	44,00	49,96	30,72	34,87	39,19	44,00	49,96
5,00					20,00	23,24	26,46	30,00	23,24	30,66	34,06	34,93	38,73	43,59	48,99	55,68	34,06	38,73	43,59	48,99	55,68
6,00					21,35	24,98	28,57	32,49	24,98	33,23	36,99	37,95	42,14	47,50	53,44	60,79	36,99	42,14	47,50	53,44	60,79
7,00									26,46	35,50	39,60	40,64	45,21	51,03	57,48	65,45	39,60	45,21	51,03	57,48	65,45
8,00									27,71	37,52	41,95	43,08	48,00	54,26	61,19	69,74	41,95	48,00	54,26	61,19	69,74
9,00									28,77	39,34	44,09	45,30	50,56	57,24	64,62	73,73	44,09	50,56	57,24	64,62	73,73
10,00																	46,04	52,92	60,00	67,82	77,46
11,00																	47,83	55,10	62,58	70,82	80,97
12,00																	49,48	57,13	64,99	73,65	84,29
13,00																	50,99	59,03	67,26	76,32	87,43

Max. flat surface (mm)		
Insert size	Cutter dia.	Pitch
06	16	7,60
	20	11,60
	25	16,60
	32	23,60
09	25	11,75
	32	18,75
	40	26,75
	50	36,75
12	32	10,60
	52	33,60
	63	44,60
	66	47,60
	80	61,60
	100	81,60
16	125	106,60
	160	141,60
	63	37,45
	80	54,45
	100	74,45
	125	99,45
	160	134,50



Helical Interpolation



Facing Pitch

Helical interpolation capacity for 7792VX (mm)			
Insert Size	Cutter dia.	Hole min.	Hole max.
06	16	22	30
	20	30	38
	25	40	48
	32	54	62
09	25	34	48
	32	48	62
	40	64	78
	50	84	98
12	32	42	62
	52	82	102
	63	104	124
	66	110	130
	80	138	158
	100	178	198
	125	228	248
16	160	298	318
	63	96	124
	80	130	158
	100	170	198
	125	220	248
	160	290	318