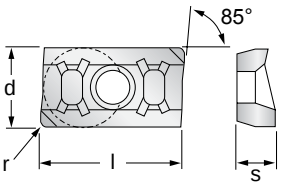
STELLRAM

APET16-48



Product			Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼					
EDP	Item Description	Grade	Depth of Cut (mm)			d (IC)	l	s	r	h_m min
			a_p max. 15,80	a_p min. - max. 1,50 - 5,00	a_p min. - max. 0,10 - 1,50					
030811	APET1604PDER-48	X500				9,52	16,66	4,76	Facet	0,04
030733	APET1604PDER-48	SP6519				9,52	16,66	4,76	Facet	0,04
030860	APET160408ER-48	X500				9,52	16,66	4,76	0,80	0,04
030861	APET160408ER-48	SP6519				9,52	16,66	4,76	0,80	0,04
030812	APET160412ER-48	X500				9,52	16,66	4,76	1,20	0,04
030799	APET160412ER-48	SP6519				9,52	16,66	4,76	1,20	0,04
030813	APET160416ER-48	X500				9,52	16,66	4,76	1,60	0,04
030774	APET160416ER-48	SP6519				9,52	16,66	4,76	1,60	0,04
030914	APET160420ER-48	X500				9,52	16,66	4,76	2,00	0,04
030915	APET160420ER-48	SP6519				9,52	16,66	4,76	2,00	0,04
030916	APET160424ER-48	X500				9,52	16,66	4,76	2,40	0,04
030917	APET160424ER-48	SP6519				9,52	16,66	4,76	2,40	0,04
030918	APET160430ER-48	X500				9,52	16,66	4,76	3,00	0,04
030919	APET160430ER-48	SP6519				9,52	16,66	4,76	3,00	0,04
030814	APET160432ER-48	X500				9,52	16,66	4,76	3,20	0,04
030775	APET160432ER-48	SP6519				9,52	16,66	4,76	3,20	0,04
030907	APET160440ER-48	X500				9,52	16,66	4,76	4,00	0,04
030906	APET160440ER-48	SP6519				9,52	16,66	4,76	4,00	0,04
030920	APET160450ER-48	X500				9,52	16,66	4,76	5,00	0,04
030921	APET160450ER-48	SP6519				9,52	16,66	4,76	5,00	0,04
030922	APET160460ER-48	X500				9,52	16,66	4,76	6,00	0,04
030923	APET160460ER-48	SP6519				9,52	16,66	4,76	6,00	0,04
030924	APET160464ER-48	X500				9,52	16,66	4,76	6,40	0,04
030925	APET160464ER-48	SP6519				9,52	16,66	4,76	6,40	0,04

Machining Choice: ◆ 1st Choice ■ 2nd Choice ● 3rd Choice | Material Guide Key descriptions found on page A5.

The 7690VAP series are ideal for roughing, semi-finishing and finishing of Stainless Steel, High Temperature Alloys plus Low Carbon Steels. This cutter is designed to utilise one geometery of insert only - APET1604...ER-48

7690VAP16 Feeds f_z (mm/tooth)

Geometry	Grade	Operation	Unalloyed Steel	Alloyed Steel	Stainless Steel	Stainless Steel Refractory PH	Gray Iron	Spheroidal-Ductile Iron	Malleable Iron	Aluminium & Alloys <16% Si 116 HBN	Aluminium & Silicon >16% Si 92 HBN	HTA Iron Based Alloys	HTA Cobalt Based Alloys	HTA Nickel Based Alloys	HTA Titanium Based Alloys	Hard Steel >1400 N/mm² >415 HBN	Chilled Cast Iron >1400 N/mm² >400 HBN
			Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.
ER-48	X500	Facing	0,05 - 0,25	-	0,05 - 0,25	0,05 - 0,20	-	-	-	-	-	0,05 - 0,10	0,05 - 0,10	0,05 - 0,13	0,05 - 0,18	-	-
ER-48	SP6519	Facing	0,05 - 0,20	-	0,05 - 0,20	0,05 - 0,18	-	-	-	-	-	0,05 - 0,08	0,05 - 0,08	0,05 - 0,10	0,05 - 0,15	-	-

Note: HTA = High Temperature Alloys

Note: Speed recommendations can be found on page A58.