



INSIDE THIS ISSUE:

HIGH FEED MILLING 2

PROMOTION 3

**STELLRAM INTRODUCES THE
NEW D41 INSERT GEOMETRY –**

**AVAILABLE FOR MACHINING STAINLESS STEELS
AND HIGH TEMPERATURE ALLOYS.**



In this issue of our newsletter, we offer information on a new product from **Stellram**. In addition to the economy of the purchase of the product, both the versatility and metal removal rates are outstanding.

**TYPICAL CUSTOMER COMMENTS
AFTER USING THIS TOOL INCLUDE:**

- “I did not believe a machine of this size could handle that cut, I was amazed!”
- “Our shop would like to thank you for giving us back our weekends...”
- The performance and tool life is impressive...”

TEST THE BEST

Promotion is from
9/15 to 11/30/2005

1 TOOL—3 USES

For a limited time, you can test the best High Feed cutter in the industry.

No cost!

No Obligation!

**QUALIFY FOR A
FREE HIGH-FEED FACE MILL
WITH INSERT PURCHASE.**

Stellram's C7792VXD High-Feed Mill has been extremely successful since its introduction. Test after test have confirmed the 7792VXD to save time and money by pushing feed rates to the limit—typically to 300 inches per minute on steel. And, this tool works on both high power and low power machines with stable or unstable set-ups.

**Use one tool for
facing, pocketing
and plunging at
feeds up to
0.118IPT per
tooth.**

HIGH FEED MILLING—

Maximize Metal Removal

C7792VXD:

- **Reduced Component Costs—**The C7792VXD maximizes metal removal rates using high feed rates and low depths of cut.
- **Reduced Processing Time—**The C7792VXD allows close to profile pocketing of 90 degree walls compared to machining using round inserts.
- **Maximize Machine Capability—**The C7792VXD works on both new and old machines, and can bring new productivity to older equipment.
- **Reduced vibration and cutter deflection in deep cavities—**The C7792VXD directs cutting forces in the axial direction lessening vibration at extended reaches.
- **Improved Tool Economy—**C7792VXD features inserts with four cutting edges and cutters can perform four operations—facing, plunging, pocketing and slotting.
- **Achieve New Productivity Levels Machine All Materials—**Insert grades and geometry are available for use with steels, stainless steels, cast irons, aluminum, titanium and superalloys.
- **Improved Insert Life—**Cutters feature through coolant for directing chip away from the cutting edge.

**NOTHING
IS EASY TO
THE UNWILLING.**

Nikki Giovanni

Poet

Please contact your **METRO TOOL & ABRASIVES Sales Engineer** for more information or to test this new tool.

METRO TOOL & ABRASIVES

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**SUCCESS
ISN'T
PERMANENT,
AND FAILURE
ISN'T
FATAL.**

Mike Ditka

NEW D41 Geometry available for machining stainless steels and high temperature alloys.



9mm inserts: Purchase 30 inserts and receive a free C7792VXD09 cutter

EDP	C7792VXD Weldon Shank	Dia.	No. of flutes	Shank Dia.	Bore Dia.	Utilizes insert style	Req No. Inserts
029474	C7792VXD09WA1.00Z2R	1.00	2	1.00	-	XD..090408	30
029475	C7792VXD09WA1.25Z3R	1.25	3	1.25	-	XD..090408	30
C7792VXD Shell Mill							
029476	C7792VXD09-A1.50Z3R	1.50	3	-	0.500	XD..090408	30
029477	C7792VXD09-A1.50Z4R	1.50	4	-	0.500	XD..090408	30
C7792VXD Modular Head							
029478	A7792VXD09S1.00Z2R1.4	1.00	2	M12	-	XD..090408	30
029479	A7792VXD09S1.25Z3R1.7	1.25	3	M16	-	XD..090408	30

12mm inserts: Purchase 50 inserts and receive a free C7792VXD12 cutter

EDP	C7792VXD Weldon Shank	Dia.	No. of flutes	Shank Dia.	Bore Dia.	Utilizes insert style	Req No. Inserts
029480	C7792VXD12-A2.00Z3R	2.00	3	-	0.750	XD..120508	50
029481	C7792VXD12-A2.00Z4R	2.00	4	-	0.750	XD..120508	50
029482	C7792VXD12-A2.50Z4R	2.50	4	-	1.000	XD..120508	50
029483	C7792VXD12-A2.50Z5R	2.50	5	-	1.000	XD..120508	50
029484	C7792VXD12-A3.00Z5R	3.00	5	-	1.000	XD..120508	50

Inserts

EDP	Part Number	Grade	Application & Material
9mm inserts			
029485	XDLW090408SR-D	X500	Roughing
029486	XDLW090408SR-D	SC3025	
029487	XDLW090408SR-D	X400	
029637	XDLT090408ER-D721	GH2	
029685 NEW!	XDLT090408ER-D41	X500	
029686 NEW!	XDLT090408ER-D41	SP6564	
12mm inserts			
029488	XDLW120508SR-D	X500	
029489	XDLW120508SR-D	SC3025	
029490	XDLW120508SR-D	X400	
029638	XDLT120508ER-D721	GH2	
029682 NEW!	XDLT120508ER-D41	X500	
029683 NEW!	XDLT120508ER-D41	SP6564	

Cutting Conditions

9mm

ISO	Material	Facing			Slotting			Plunging		
		Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)	Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)	Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)
P	Unalloyed Steels	395 - 770	0.012 - 0.079	0.059	395 - 770	0.012 - 0.059	0.059	395 - 770	0.004 - 0.006	0.236
P	Alloyed Steels	230 - 525	0.012 - 0.079	0.059	230 - 525	0.012 - 0.059	0.059	230 - 525	0.004 - 0.008	0.236
M	Stainless Steels	370 - 870	0.008 - 0.039	0.059	370 - 870	0.008 - 0.031	0.059	370 - 870	0.004 - 0.006	0.236
M	PH Stainless Steels	160 - 320	0.008 - 0.024	0.059	160 - 320	0.004 - 0.016	0.059	160 - 320	0.002 - 0.003	0.236
K	Cast Irons	400 - 1300	0.012 - 0.079	0.059	400 - 1300	0.012 - 0.059	0.059	400 - 1300	0.004 - 0.008	0.236
N	Aluminum Alloys	1310 - 3280	0.008 - 0.039	0.059	1310 - 3280	0.012 - 0.039	0.059	1310 - 3280	0.004 - 0.012	0.236
S	High Temp. Alloys	80 - 200	0.008 - 0.031	0.059	80 - 200	0.004 - 0.020	0.059	80 - 200	0.002 - 0.004	0.236
H	Hard Materials (52-56 HRC)	115 - 330	0.012 - 0.039	0.059	115 - 330	0.012 - 0.032	0.059	115 - 330	0.003 - 0.005	0.236

12mm

ISO	Material	Facing			Slotting			Plunging		
		Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)	Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)	Speed V _c (SFM)	Feed f _t (IPT)	D.O.C a _p max (in)
P	Unalloyed Steels	395 - 770	0.012 - 0.118	0.098	395 - 770	0.012 - 0.079	0.079	395 - 770	0.004 - 0.007	0.354
P	Alloyed Steels	230 - 525	0.012 - 0.118	0.098	230 - 525	0.012 - 0.079	0.079	230 - 525	0.004 - 0.010	0.354
M	Stainless Steels	370 - 870	0.008 - 0.047	0.098	370 - 870	0.008 - 0.040	0.079	370 - 870	0.004 - 0.007	0.354
M	PH Stainless Steels	160 - 320	0.008 - 0.028	0.098	160 - 320	0.004 - 0.024	0.079	160 - 320	0.002 - 0.004	0.354
K	Cast Irons	400 - 1300	0.012 - 0.118	0.098	400 - 1300	0.012 - 0.079	0.079	400 - 1300	0.004 - 0.010	0.354
N	Aluminum Alloys	1310 - 3280	0.012 - 0.059	0.098	1310 - 3280	0.012 - 0.059	0.079	1310 - 3280	0.004 - 0.016	0.354
S	High Temp. Alloys	80 - 200	0.008 - 0.040	0.098	80 - 200	0.004 - 0.028	0.079	80 - 200	0.002 - 0.004	0.354
H	Hard Materials (52-56 HRC)	115 - 330	0.012 - 0.059	0.098	115 - 330	0.012 - 0.039	0.079	115 - 330	0.003 - 0.006	0.354