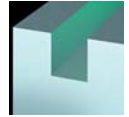
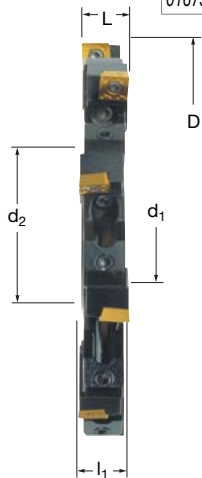


7200 VM 04_N Full Side Disc Cutters



7200 VM 04_N Assembled Disc & Cartridge															
EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares			
		D	L	d_1	d_2	a_r max.	l_1	d_1				EDP#	EDP#	EDP#	EDP#
016626	7200VM 04 -080N06/07	80	6-7	14	27	42	16	10	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6	
016627	7200VM 04 -080N07/08	80	7-8	14	27	42	16	10	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6	
016628	7200VM 04 -100N06/07	100	6-7	14	32	48	23	12	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6	
016629	7200VM 04 -100N07/08	100	7-8	14	32	48	23	12	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6	
016630	7200VM 04 -125N06/07	125	6-7	14	40	58	30	16	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6	
016631	7200VM 04 -125N07/08	125	7-8	14	40	58	30	16	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6	

7200 VM 04_N Cartridge Spares									
EDP #	Cartridge Part Number	Cartridge							
		EDP#	EDP#	EDP#	EDP#				
016759	72VMR06/07	015259	72.698T	013214	T9				
016751	72VML06/07	015259	72.698T	013214	T9				
016760	72VMR07/08	015259	72.698T	013214	T9				
016752	72VML07/08	015259	72.698T	013214	T9				

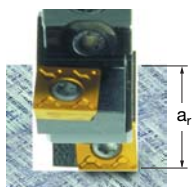


7200 VM 04_N Technical Advice

Milling Cutter Order Example: **7200VM04-125N06/07**
 Milling Insert Order Example: **MPFW0402PPTR X44 / MPFW0402PPTL X44**
 For complete cutting conditions refer to page: **264**



Disc Cutter & Cartridge



Depth of Cut (a_r)



IMPORTANT

For a given f_z (mm/tooth.) feed rate, the thickness of the chip h_m (effective feed rate per tooth) **decreases with the depth of cut a_r** . It is imperative that this parameter be taken into account when selecting the machine feed rate, calculated in accordance with the formula below:

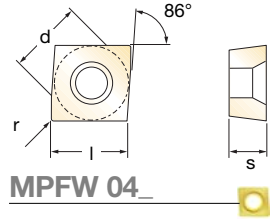
FORMULA EXAMPLE

$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

a_r = Depth of Cut (D.O.C.) f_z = Feed per tooth
 D = Cutter diameter h_m = Effective chip thickness

Inserts for 7200 VM 04_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024148	MPFW 04 02PPTR	GH1				4,76	4,76	2,38	Facet	0,07
025799	MPFW 04 02PPTL	GH1				4,76	4,76	2,38	Facet	0,07
017645	MPFW 04 02PPTR	SF30				4,76	4,76	2,38	Facet	0,07
017646	MPFW 04 02PPTL	SF30				4,76	4,76	2,38	Facet	0,07
015158	MPFW 04 02PPTR	SFZ	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
015157	MPFW 04 02PPTL	SFZ	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
017427	MPFW 04 02PPTR	X44				4,76	4,76	2,38	Facet	0,07
017426	MPFW 04 02PPTL	X44				4,76	4,76	2,38	Facet	0,07
017666	MPHW 04 02PPTR	X500	◆	◆	◆	4,76	4,76	2,38	Facet	0,07
017667	MPHW 04 02PPTL	X500	◆	◆	◆	4,76	4,76	2,38	Facet	0,07



Recommended Cutting Conditions

Material	Speed V _C (m/min)	Feed h _m (mm)
◆ Unalloyed Steels	180 - 220	0,07 - 0,10
◆ Alloyed Steels	70 - 110	0,07 - 0,08
◆ Stainless Steels	120 - 140	0,07 - 0,10
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,07 - 0,08
◆ Aluminium & Alloys	-	-
◆ High Temp. Alloys	-	-
◆ Hard Steels (52-56 HRC)	-	-

h_m = average chip thickness

Star Guide Key to Recommended Tools

Material Designations						
	P ◆	Unalloyed Steels	M ◆	Stainless Steels	K ◆	Cast Irons
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminium & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials