



# 7200 VM 04\_R Half Side Disc Cutters

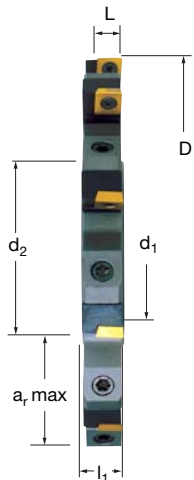


## 7200 VM 04\_R Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	EDP#	Cartridge	Spares		
		D	L	$l_1$	$d_1$	$d_2$	$a_r$ max.	EDP#					EDP#	
016738	A7200VM04-100R06/07	3.94	0.185	0.55	1.25	1.89	0.90	12	016759	72VMR06/07	015059	F2004T	018487	T6
016739	A7200VM04-100R07/08	3.94	0.185	0.55	1.25	1.89	0.90	12	016760	72VMR07/08	015059	F2004T	018487	T6

## 7200 VM 04\_R Cartridge Spares

EDP #	Cartridge Part Number	EDP#		EDP#	
016759	72VMR06/07	015259	72.698T	013214	T9
016760	72VMR07/08	015259	72.698T	013214	T9



## 7200 VM 04\_R Technical Advice

Milling Cutter Order Example: **A7200VM04-100R06/07**  
 Milling Insert Order Example: **MPHW0402PPTR X500**  
 For complete cutting conditions refer to page: 208

### IMPORTANT

For a given  $f_z$  (in./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

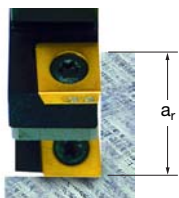
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

$$h_m = \sqrt{\frac{0.4}{6.3}} \times 0.004 = 0.001''$$

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

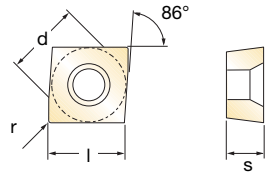


Disc Cutter & Cartridge

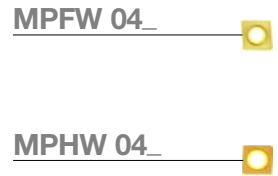


Depth of Cut ( $a_r$ )

## Inserts for 7200 VM 04\_R



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	$h_m$ min
024148	MPFW0402PPTR	GH1				0.187	0.187	0.094	Facet	0.0028
017645	MPFW0402PPTR	SF30				0.187	0.187	0.094	Facet	0.0028
015158	MPFW0402PPTR	SFZ	◆◆	◆◆	◆◆	0.187	0.187	0.094	Facet	0.0028
017427	MPFW0402PPTR	X44				0.187	0.187	0.094	Facet	0.0028
017666	MPHW0402PPTR	X500	◆	◆	◆	0.187	0.187	0.094	Facet	0.0028



## Recommended Cutting Conditions

Material	Speed $V_C$ (feet/min)	Feed $h_m$ (inch)
◆ Unalloyed Steels	600 - 720	0.003 - 0.004
◆ Alloyed Steels	230 - 360	0.003 - 0.003
◆ Stainless Steels	400 - 450	0.003 - 0.004
◆ PH Stainless	-	-
◆ Cast Irons	460 - 910	0.003 - 0.003
◆ Aluminum & 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	S ◆	High Temp. Alloys
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys	H ◆	Hard Materials