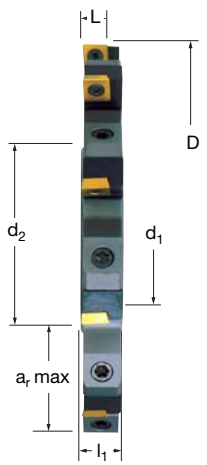
7200 VM 06_L Half Side Disc Cutters

7200 VM 06_L Assembled Disc & Cartridge

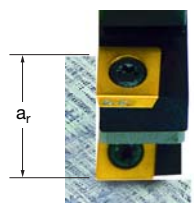
EDP #	Assembled Part Number	Dimensions (inch) D	L	l_1	d_1	d_2	a_r max.	No. of Inserts	Spares EDP#	Cartridge	EDP#		EDP#	
023976	**A7200VM06-100L08/09**	3.94	0.248	0.472	1.25	1.89	0.90	12	*016753*	72VML08/09	*015060*	F2505T	*018488*	T7
023977	**A7200VM06-100L09/10**	3.94	0.248	0.472	1.25	1.89	0.90	12	*016754*	72VML09/10	*015060*	F2505T	*018488*	T7

7200 VM 06_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge EDP#		EDP#	
016753	**72VML08/09**	*015258*	72.697T	*015240*	T15
016754	**72VML09/10**	*015258*	72.697T	*015240*	T15



Disc Cutter & Cartridge



Depth of Cut (a_r)

7200 VM 06_L Technical Advice

Milling Cutter Order Example: **A7200VM06-100L08/09**
Milling Insert Order Example: **MPHW0602PPTL 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

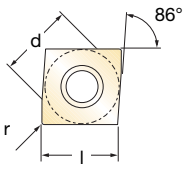
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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

Inserts for 7200 VM 06_L

EDP#	Part Number	Grade	Application & Material: Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	Dimensions (inch): d	l	s	r	h_m min
024926	**MPEX0602PPFL-701**	**GH1**	♦	♦	♦	0.250	0.250	0.094	Facet	0.0008
017639	**MPEX0602PPFL-701**	**SFZ**				0.250	0.250	0.094	Facet	0.0008
017652	**MPFW0602PPTL**	**GH1**				0.250	0.250	0.094	Facet	0.0028
017650	**MPFW0602PPTL**	**SF30**				0.250	0.250	0.094	Facet	0.0028
015159	**MPFW0602PPTL**	**SFZ**	♦♦	♦♦	♦♦	0.250	0.250	0.094	Facet	0.0028
017651	**MPFW0602PPTL**	**X44**				0.250	0.250	0.094	Facet	0.0028
017300	**MPHW0602PPTL**	**MP91M**	♦	♦	♦	0.250	0.250	0.094	Facet	0.0028
017669	**MPHW0602PPTL**	**X500**	♦	♦	♦	0.250	0.250	0.094	Facet	0.0028



MPEX 06_ -701

MPFW 06_

MPHW 06_

Recommended Cutting Conditions

Material	Speed V_c (feet/min)	Feed h_m (inch)
♦ Unalloyed Steels	600 - 720	0.003 - 0.005
♦ Alloyed Steels	230 - 360	0.003 - 0.004
♦ Stainless Steels	400 - 450	0.003 - 0.005
♦ PH Stainless	-	-
♦ Cast Irons	460 - 910	0.003 - 0.004
♦ Aluminum & Alloys	910 - 1470	0.002 - 0.005
♦ 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

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