

7200 VM 06_R Half Side Disc Cutters

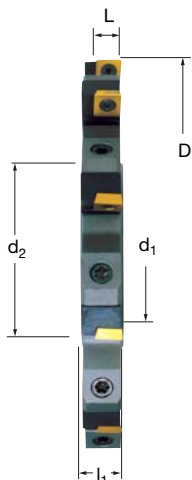


7200 VM 06_R Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares			
		D	L	l_1	d_1	d_2	a_r max.	EDP#				EDP#	EDP#	EDP#	
016656	7200VM 06 -100R08/09	100	6,3	12	32	48	23	12	016761	72VMR08/09	015060	F2505T	018488	T7	
016657	7200VM 06 -100R09/10	100	6,3	12	32	48	23	12	016762	72VMR09/10	015060	F2505T	018488	T7	
016658	7200VM 06 -125R08/09	125	6,3	12	40	58	31	14	016761	72VMR08/09	015060	F2505T	018488	T7	
016659	7200VM 06 -125R09/10	125	6,3	12	40	58	31	14	016762	72VMR09/10	015060	F2505T	018488	T7	

7200 VM 06_R Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016761	72VMR08/09	015258	72.697T	015240	T15
016762	72VMR09/10	015258	72.697T	015240	T15

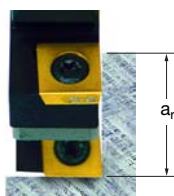


7200 VM 06_R Technical Advice

Milling Cutter Order Example: **7200VM06-100R08/09**
 Milling Insert Order Example: **MPHW06020PPTR X500**
 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:

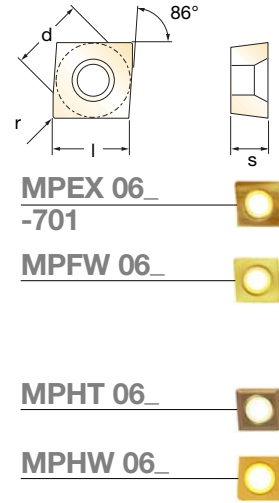
FORMULA EXAMPLE

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

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

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 06_R



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024927	MPEX 06 02PPFR-701	GH1	◆	◆	◆	6,35	6,35	2,38	Facet	0,02
017638	MPEX 06 02PPFR-701	SFZ				6,35	6,35	2,38	Facet	0,02
017649	MPFW 06 02PPTR	GH1				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ	◆◆	◆◆	◆◆	6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44				6,35	6,35	2,38	Facet	0,07
023247	MPHT 06 02PPER	X44				6,35	6,35	2,38	Facet	0,04
017301	MPHW 06 02PPTR	MP91M	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
023253	MPHW 06 02PPTR	PFZ				6,35	6,35	2,38	Facet	0,07
017668	MPHW 06 02PPTR	X500	◆	◆	◆	6,35	6,35	2,38	Facet	0,07

Recommended Cutting Conditions

Material	Speed V _C (m/min)	Feed h _m (mm)
◆ Unalloyed Steels	180 - 220	0,07 - 0,12
◆ Alloyed Steels	70 - 110	0,07 - 0,10
◆ Stainless Steels	120 - 140	0,07 - 0,12
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,07 - 0,10
◆ Aluminium & Alloys	275 - 450	0,04 - 0,12
◆ 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 ◆ Aluminium & Alloys	H ◆ Hard Materials	