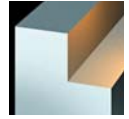


7200 VM 08_L Half Side Disc Cutters

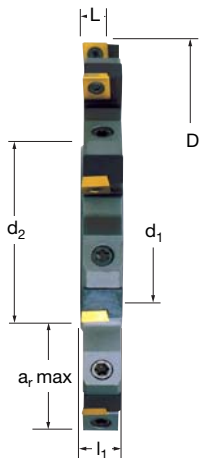


7200 VM 08_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	Spares		EDP#	EDP#	EDP#	EDP#
		D	L	I ₁	d ₁	d ₂	a _r max.	EDP#		Cartridge					
023978	A7200VM08-100L10/12	3.94	0.311	0.433	1.25	1.89	0.94	8	016755	72VML10/12	015063	F3008T	013214	T9	
023979	A7200VM08-125L10/12	4.92	0.311	0.433	1.5	2.28	1.26	10	016755	72VML10/12	015063	F3008T	013214	T9	
023980	A7200VM08-125L12/14	4.92	0.311	0.433	1.5	2.28	1.26	10	016756	72VML12/14	015063	F3008T	013214	T9	

7200 VM 08_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016755	72VML10/12	015256	72.693T	015273	T20TB
016756	72VML12/14	015256	72.693T	015273	T20TB



7200 VM 08_L Technical Advice

Milling Cutter Order Example: **A7200VM08-125L10/12**
 Milling Insert Order Example: **MPFW0803PPTL SFZ**
 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

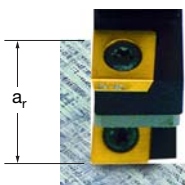
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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

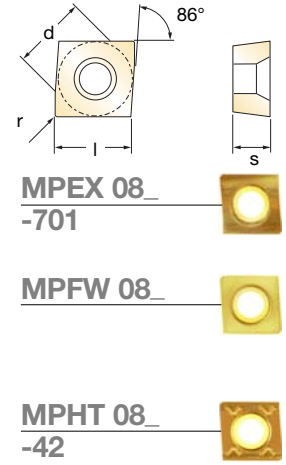


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VM 08_L



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
017641	MPEX0803PPEL-701	PFZ				0.313	0.313	0.125	Facet	0.0008
024928	MPEX0803PPFL-701	GH1	◆	◆	◆	0.313	0.313	0.125	Facet	0.0008
017490	MPEX0803PPFL-701	SFZ				0.313	0.313	0.125	Facet	0.0008
017658	MPFW0803PPTL	GH1				0.313	0.313	0.125	Facet	0.0039
017656	MPFW0803PPTL	SF30				0.313	0.313	0.125	Facet	0.0039
017659	MPFW0803PPTL	SFZ	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039
017657	MPFW0803PPTL	X44				0.313	0.313	0.125	Facet	0.0039
017296	MPHT0803PPTL-42	MP91M	◆	◆	◆	0.313	0.313	0.125	Facet	0.0039
023249	MPHT0803PPTL-42	PFZ				0.313	0.313	0.125	Facet	0.0039
015138	MPHT0803PPTL-42	X500	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039

Recommended Cutting Conditions

Material	Speed V_C (feet/min)	Feed h_m (inch)
◆ Unalloyed Steels	600 - 720	0.004 - 0.006
◆ Alloyed Steels	230 - 360	0.004 - 0.005
◆ Stainless Steels	400 - 450	0.004 - 0.005
◆ PH Stainless	190 - 220	0.005 - 0.008
◆ Cast Irons	460 - 910	0.004 - 0.005
◆ 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