

7200 VM 08_L Half Side Disc Cutters

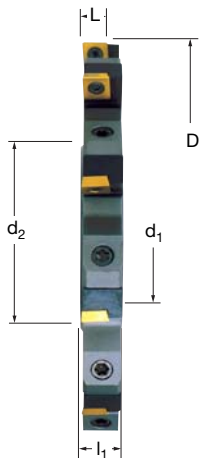


7200 VM 08_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares			
		D	L	l ₁	d ₁	d ₂	a _r max.	EDP#				Cartridge	EDP#	EDP#	EDP#
025485	7200VM 08 -100L10/12	100	7,9	11	32	48	24	8	016755	72VML10/12	015063	F3008T	013214	T9	
025486	7200VM 08 -100L12/14	100	7,9	13	32	48	24	8	016756	72VML12/14	015063	F3008T	013214	T9	
025487	7200VM 08 -125L10/12	125	7,9	11	40	58	32	10	016755	72VML10/12	015063	F3008T	013214	T9	
025488	7200VM 08 -125L12/14	125	7,9	13	40	58	32	10	016756	72VML12/14	015063	F3008T	013214	T9	
025489	7200VM 08 -160L10/12	160	7,9	11	40	58	49	12	016755	72VML10/12	015063	F3008T	013214	T9	
025491	7200VM 08 -160L12/14	160	7,9	13	40	58	49	12	016756	72VML12/14	015063	F3008T	013214	T9	

7200 VM 08_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	Cartridge	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: **7200VM08-125L10/12**
 Milling Insert Order Example: **MPFW0803PPTL SFZ**
 For complete cutting conditions refer to page: **264**

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

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

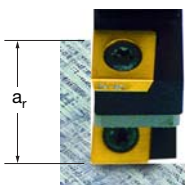
$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

a_r = Depth of Cut (D.O.C.) f_z = Feed per tooth

D = Cutter diameter h_m = Effective chip thickness

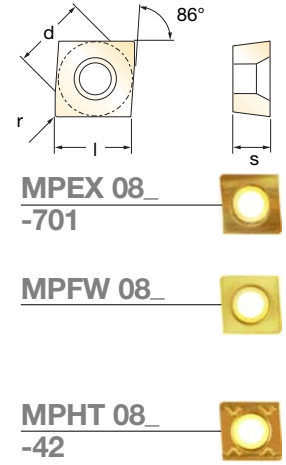


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VM 08_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017641	MPEX 08 03PPEL-701	PFZ				7,94	7,94	3,18	Facet	0,02
024928	MPEX 08 03PPFL-701	GH1	◆	◆	◆	7,94	7,94	3,18	Facet	0,02
017490	MPEX 08 03PPFL-701	SFZ				7,94	7,94	3,18	Facet	0,02
017658	MPFW 08 03PPTL	GH1				7,94	7,94	3,18	Facet	0,1
017656	MPFW 08 03PPTL	SF30				7,94	7,94	3,18	Facet	0,1
017659	MPFW 08 03PPTL	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017657	MPFW 08 03PPTL	X44				7,94	7,94	3,18	Facet	0,1
017296	MPHT 08 03PPTL-42	MP91M	◆	◆	◆	7,94	7,94	3,18	Facet	0,1
023249	MPHT 08 03PPTL-42	PFZ				7,94	7,94	3,18	Facet	0,1
015138	MPHT 08 03PPTL-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1

Recommended Cutting Conditions

Material	Speed V _C (m/min)	Feed h _m (mm)
◆ Unalloyed Steels	180 - 220	0,10 - 0,14
◆ Alloyed Steels	70 - 110	0,10 - 0,12
◆ Stainless Steels	120 - 140	0,10 - 0,12
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,10 - 0,12
◆ 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