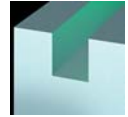




# 7200 VM 08\_N Full Side Disc Cutters

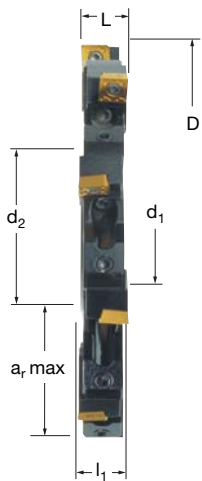


## 7200 VM 08\_N Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	Spares		EDP# 	EDP# 	
		D	L	$l_1$	$d_1$	$d_2$	$a_r$ max.	EDP#		Cartridge				
016733	A7200VM08-125N10/12	4.92	0.394-	0.433	1.50	2.28	1.26	55	016763	72VMR10/12	015063	F3008T	013214	T9
			0.472						016755	72VML10/12				
016734	A7200VM08-125N12/14	4.92	0.472-	0.433	1.50	2.28	1.26	55	016764	72VMR12/14	015063	F3008T	013214	T9
			0.551						016756	72VML12/14				

## 7200 VM 08\_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#		EDP#	
016763	72VMR10/12	015256	72.693T	015273	T20TB
016755	72VML10/12	015256	72.693T	015273	T20TB
016764	72VMR12/14	015256	72.693T	015273	T20TB
016756	72VML12/14	015256	72.693T	015273	T20TB

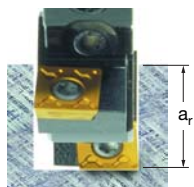


## 7200 VM 08\_N Technical Advice

Milling Cutter Order Example: **A7200VM08-125N10/12**  
 Milling Insert Order Example: **MPHT0803PPTR-42 MP91M / MPHT0803PPTL-42 MP91M**  
 For complete cutting conditions refer to page: **208**



Disc Cutter & Cartridge



Depth of Cut ( $a_r$ )



### 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:

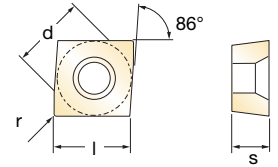
### FORMULA EXAMPLE

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

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

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

## Inserts for 7200 VM 08\_N



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
017640	MPEX0803PPER-701	PFZ				0.313	0.313	0.125	Facet	0.0008
017641	MPEX0803PEL-701	PFZ				0.313	0.313	0.125	Facet	0.0008
017642	MPEX0803PPFR-701	GH1	◆	◆	◆	0.313	0.313	0.125	Facet	0.0008
024928	MPEX0803PPFL-701	GH1	◆	◆	◆	0.313	0.313	0.125	Facet	0.0008
017489	MPEX0803PPFR-701	SFZ				0.313	0.313	0.125	Facet	0.0008
017490	MPEX0803PPFL-701	SFZ				0.313	0.313	0.125	Facet	0.0008
017655	MPFW0803PPTR	GH1				0.313	0.313	0.125	Facet	0.0039
017658	MPFW0803PPTL	GH1				0.313	0.313	0.125	Facet	0.0039
017653	MPFW0803PPTR	SF30				0.313	0.313	0.125	Facet	0.0039
017656	MPFW0803PPTL	SF30				0.313	0.313	0.125	Facet	0.0039
014401	MPFW0803PPTR	SFZ	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039
017659	MPFW0803PPTL	SFZ	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039
017654	MPFW0803PPTR	X44				0.313	0.313	0.125	Facet	0.0039
017657	MPFW0803PPTL	X44				0.313	0.313	0.125	Facet	0.0039
017297	MPHT0803PPTR-42	MP91M	◆	◆	◆	0.313	0.313	0.125	Facet	0.0039
017296	MPHT0803PPTL-42	MP91M	◆	◆	◆	0.313	0.313	0.125	Facet	0.0039
023250	MPHT0803PPTR-42	PFZ				0.313	0.313	0.125	Facet	0.0039
023249	MPHT0803PPTL-42	PFZ				0.313	0.313	0.125	Facet	0.0039
015140	MPHT0803PPTR-42	X500	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039
015138	MPHT0803PPTL-42	X500	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039

MPEX 08\_  
-701

MPFW 08\_

MPHT 08\_  
-42

## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (feet/min)	Feed h <sub>m</sub> (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<sub>m</sub> = average chip thickness

### Star Guide Key to Recommended Tools

Material Designations							
	P ◆	Unalloyed Steels	M ◆	Stainless Steels	K ◆	Cast Irons	
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys	
				S ◆	High Temp. Alloys	H ◆	Hard Materials