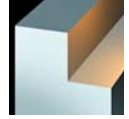




7200 VM 08_R Half Side Disc Cutters

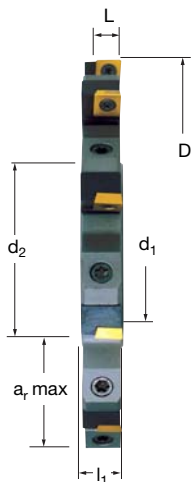


7200 VM 08_R Assembled Disc & Cartridge

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				
017274	A7200VM08-100R10/12	3.94	0.311	0.433	1.25	1.89	0.94	8	016763	72VMR10/12	015063	F3008T	013214	T9
016742	A7200VM08-125R10/12	4.92	0.311	0.433	1.50	2.28	1.26	10	016763	72VMR10/12	015063	F3008T	013214	T9
016743	A7200VM08-125R12/14	4.92	0.311	0.433	1.50	2.28	1.26	10	016764	72VMR12/14	015063	F3008T	013214	T9

7200 VM 08_R Cartridge Spares

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

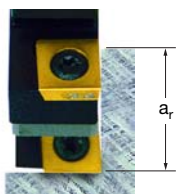


7200 VM 08_R Technical Advice

Milling Cutter Order Example: **A7200VM08-125R10/12**
 Milling Insert Order Example: **MPFW0803PPTR SFZ**
 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:

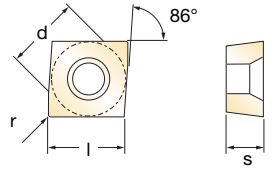
FORMULA EXAMPLE

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

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

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_R



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017640	MPEX0803PPER-701	PFZ				0.313	0.313	0.125	Facet	0.0008
017642	MPEX0803PPFR-701	GH1	◆	◆	◆	0.313	0.313	0.125	Facet	0.0008
017489	MPEX0803PPFR-701	SFZ				0.313	0.313	0.125	Facet	0.0008
017655	MPFW0803PPTR	GH1				0.313	0.313	0.125	Facet	0.0039
017653	MPFW0803PPTR	SF30				0.313	0.313	0.125	Facet	0.0039
014401	MPFW0803PPTR	SFZ	◆◆	◆◆	◆◆	0.313	0.313	0.125	Facet	0.0039
017654	MPFW0803PPTR	X44				0.313	0.313	0.125	Facet	0.0039
017663	MPHT0803PPER	SF30				0.313	0.313	0.125	Facet	0.0016
017664	MPHT0803PPER	SFZ				0.313	0.313	0.125	Facet	0.0016
017665	MPHT0803PPFR	GH1				0.313	0.313	0.125	Facet	0.0016
017297	MPHT0803PPTR-42	MP91M	◆	◆	◆	0.313	0.313	0.125	Facet	0.0039
023250	MPHT0803PPTR-42	PFZ				0.313	0.313	0.125	Facet	0.0039
015140	MPHT0803PPTR-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