

7200 VM 11_L Half Side Disc Cutters

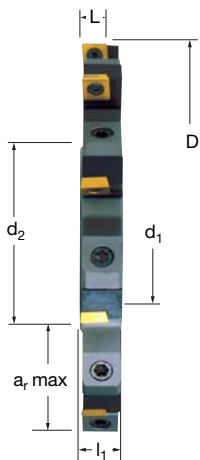


7200 VM 11_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	Spares		EDP#	EDP#	EDP#
		D	L	l_1	d_1	d_2	a_r max.	EDP#		Cartridge				
023981	A7200VM11-160L14/16	6.30	0.437	0.591	1.50	2.28	1.90	10	016757	72VML14/16	015262	D4010T	015240	T15
023982	A7200VM11-160L16/18	6.30	0.437	0.669	1.50	2.28	1.90	10	016758	72VML16/18	015262	D4010T	015240	T15
023983	A7200VM11-160L18/20	6.30	0.437	0.748	1.50	2.28	1.90	10	015444	72VML18/20	015262	D4010T	015240	T15

7200 VM 11_L Cartridge Spares

EDP #	Cartridge Part Number	Adjusting		Cartridge			
		EDP#	EDP#	EDP#	EDP#	EDP#	
016757	72VML14/16	016858	72.602	015257	72.694T	015273	T20TB
016758	72VML16/18	016858	72.602	015257	72.694T	015273	T20TB
015444	72VML18/20	016858	72.602	015257	72.694T	015273	T20TB



7200 VM 11_L Technical Advice

Milling Cutter Order Example: **A7200VM11-160L16/18**
 Milling Insert Order Example: **MPFW1104PPTL 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

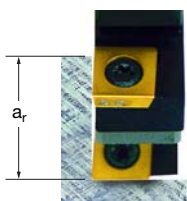
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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



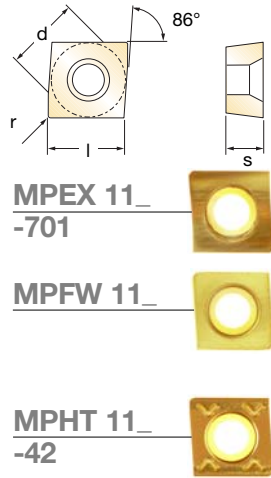
Disc Cutter & Cartridge



Depth of Cut (a_r)



Inserts for 7200 VM 11_L



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h_m min
017644	MPEX1104PPFL-701	GH1	◆	◆	◆	0.437	0.437	0.187	Facet	0.0008
017439	MPFW1104PPTL	GH1				0.437	0.437	0.187	Facet	0.0059
018181	MPFW1104PPTL	SF30				0.437	0.437	0.187	Facet	0.0059
017662	MPFW1104PPTL	SFZ	◆◆	◆◆	◆◆	0.437	0.437	0.187	Facet	0.0059
017336	MPFW1104PPTL	X44				0.437	0.437	0.187	Facet	0.0059
017298	MPHT1104PPTL-42	MP91M	◆	◆	◆	0.437	0.437	0.187	Facet	0.0039
015141	MPHT1104PPTL-42	X500	◆◆	◆◆	◆◆	0.437	0.437	0.187	Facet	0.0039

MPEX 11_
-701

MPFW 11_

MPHT 11_
-42

Recommended Cutting Conditions

Material	Speed V_C (feet/min)	Feed h_m (inch)
◆ Unalloyed Steels	600 - 720	0.006 - 0.016
◆ Alloyed Steels	230 - 360	0.006 - 0.012
◆ Stainless Steels	400 - 450	0.005 - 0.012
◆ PH Stainless	190 - 220	0.005 - 0.008
◆ Cast Irons	460 - 910	0.005 - 0.012
◆ Aluminum & Alloys	910 - 1470	0.002 - 0.011
◆ 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	