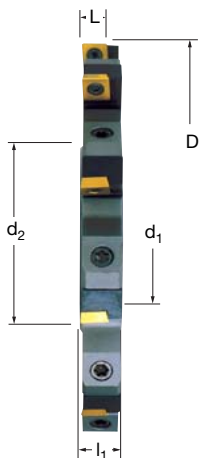


7200 VM 11_L Half Side Disc Cutters



7200 VM 11_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#				EDP#	EDP#	EDP#	
025490	7200VM 11 -125L14/16	125	11,1	15	40	58	32	8	016757	72VML14/16	015262	D4010T	015240	T15	
025492	7200VM 11 -125L16/18	125	11,1	17	40	58	32	8	016758	72VML16/18	015262	D4010T	015240	T15	
025493	7200VM 11 -160L14/16	160	11,1	15	40	58	49	10	016757	72VML14/16	015262	D4010T	015240	T15	
025494	7200VM 11 -160L16/18	160	11,1	17	40	58	49	10	016758	72VML16/18	015262	D4010T	015240	T15	
025495	7200VM 11 -160L18/20	160	11,1	19	40	58	49	10	015444	72VML18/20	015262	D4010T	015240	T15	
025496	7200VM 11 -200L16/18	200	11,1	17	50	72	62	12	016758	72VML16/18	015262	D4010T	015240	T15	
025497	7200VM 11 -200L18/20	200	11,1	19	50	72	62	12	015444	72VML18/20	015262	D4010T	015240	T15	
025498	7200VM 11 -250L18/20	250	11,1	19	50	85	81	16	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: **7200VM11-200L16/18**
 Milling Insert Order Example: **MPFW1104PPTL 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

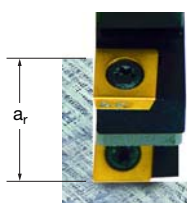
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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



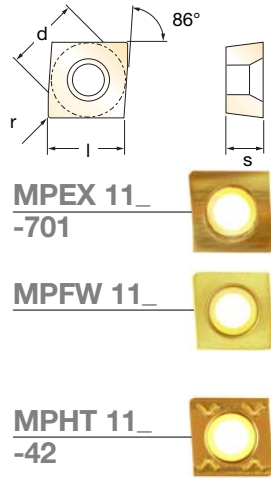
Disc Cutter & Cartridge



Depth of Cut (a_r)



Inserts for 7200 VM 11_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h_m min
017644	MPEX 11 04PPFL-701	GH1	▼	▼▼	▼▼▼	11,11	11,11	4,76	Facet	0,02
017439	MPFW 11 04PPTL	GH1				11,11	11,11	4,76	Facet	0,15
018181	MPFW 11 04PPTL	SF30				11,11	11,11	4,76	Facet	0,15
017662	MPFW 11 04PPTL	SFZ	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,15
017336	MPFW 11 04PPTL	X44				11,11	11,11	4,76	Facet	0,15
017298	MPHT 11 04PPTL-42	MP91M	◆	◆	◆	11,11	11,11	4,76	Facet	0,1
015141	MPHT 11 04PPTL-42	X500	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,1

Recommended Cutting Conditions

Material	Speed V_C (m/min)	Feed h_m (mm)
◆ Unalloyed Steels	180 - 220	0,15 - 0,40
◆ Alloyed Steels	70 - 110	0,15 - 0,30
◆ Stainless Steels	120 - 140	0,12 - 0,30
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,12 - 0,30
◆ Aluminium & Alloys	275 - 450	0,06 - 0,28
◆ 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