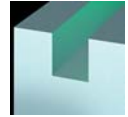


7200 VM 11_N Full Side Disc Cutters

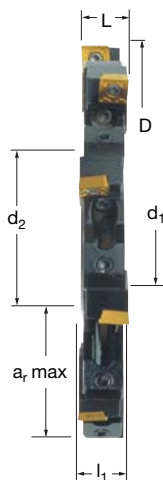


7200 VM 11_N Assembled Disc & Cartridge

| EDP # | Assembled Part Number | Dimensions (inch) | | | | | | | No. of Inserts | Spares | | EDP# | EDP# | EDP# | EDP# |
|--------|-----------------------|-------------------|-------------|----------|----------------|----------------|----------------|---------------------|------------------|--------------------------|-----------|--------|--------|------|------|
| | | D | L | min-max. | l ₁ | d ₁ | d ₂ | a _r max. | | EDP# | Cartridge | | | | |
| 016735 | A7200VM11-160N14/16 | 6.30 | 0.551-0.630 | 0.591 | 1.50 | 2.28 | 1.9 | 55 | 016765 016757 | 72VMR14/16 72VML14/16 | 015262 | D4010T | 015240 | T15 | |
| 016736 | A7200VM11-160N16/18 | 6.30 | 0.630-0.709 | 0.669 | 1.50 | 2.28 | 1.9 | 55 | 016766 016758 | 72VMR16/18 72VML16/18 | 015262 | D4010T | 015240 | T15 | |
| 016737 | A7200VM11-160N18/20 | 6.30 | 0.709-0.787 | 0.748 | 1.50 | 2.28 | 1.9 | 55 | 015445 015444 | 72VMR18/20 72VML18/20 | 015262 | D4010T | 015240 | T15 | |

7200 VM 11_N Cartridge Spares

| EDP # | Cartridge Part Number | Adjusting | | Cartridge | | | |
|--------|-----------------------|-----------|--------|-----------|---------|--------|-------|
| | | EDP# | EDP# | EDP# | EDP# | EDP# | |
| 016765 | 72VMR14/12 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |
| 016757 | 72VML14/12 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |
| 016766 | 72VMR16/18 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |
| 016758 | 72VML16/18 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |
| 015445 | 72VMR18/20 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |
| 015444 | 72VML18/20 | 016858 | 72.602 | 015257 | 72.694T | 015273 | T20TB |

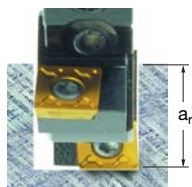


7200 VM 11_N Technical Advice

Milling Cutter Order Example: **A7200VM11-160N18/20**
 Milling Insert Order Example: **MPHT1104PPTR-42 MP91M / MPHT1104PPTL-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:

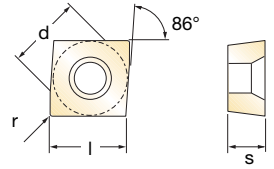
FORMULA EXAMPLE

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

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

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 11_N



| EDP# | Part Number | Grade | Application & Material | | | Dimensions (inch) | | | | |
|--------|------------------|-------|------------------------|----------------|-----------|-------------------|-------|-------|-------|-----------|
| | | | Roughing | Semi-Finishing | Finishing | d | l | s | r | h_m min |
| 017643 | MPEX1104PPFR-701 | GH1 | ◆ | ◆◆ | ◆◆◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0008 |
| 017644 | MPEX1104PPFL-701 | GH1 | ◆ | ◆ | ◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0008 |
| 017440 | MPFW1104PPTR | GH1 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017439 | MPFW1104PPTL | GH1 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 018182 | MPFW1104PPTR | SF30 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 018181 | MPFW1104PPTL | SF30 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017660 | MPFW1104PPTR | SFZ | ◆◆ | ◆◆ | ◆◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017662 | MPFW1104PPTL | SFZ | ◆◆ | ◆◆ | ◆◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017777 | MPFW1104PPTR | X44 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017336 | MPFW1104PPTL | X44 | | | | 0.437 | 0.437 | 0.187 | Facet | 0.0059 |
| 017299 | MPHT1104PPTR-42 | MP91M | ◆ | ◆ | ◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0039 |
| 017298 | MPHT1104PPTL-42 | MP91M | ◆ | ◆ | ◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0039 |
| 015142 | MPHT1104PPTR-42 | X500 | ◆◆ | ◆◆ | ◆◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0039 |
| 015141 | MPHT1104PPTL-42 | X500 | ◆◆ | ◆◆ | ◆◆ | 0.437 | 0.437 | 0.187 | Facet | 0.0039 |



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 | |