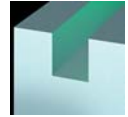
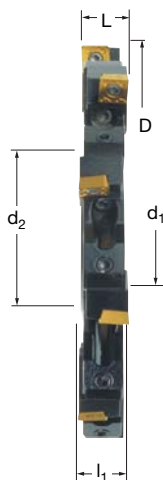


7200 VM 11_N Full Side Disc Cutters



7200 VM 11_N Assembled Disc & Cartridge														
EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares		
		D	L min-max.	l ₁	d ₁	d ₂	a _r max.	EDP#				EDP#	EDP#	
016642	7200VM11-125N14/16	125	14-16	15	40	58	32	8	016765 016757	72VMR14/16 72VML14/16	015262	D4010T	015240	T15
016643	7200VM11-125N16/18	125	16-18	17	40	58	32	8	016766 016758	72VMR16/18 72VML16/18	015262	D4010T	015240	T15
016644	7200VM11-160N14/16	160	14-16	15	40	58	49	10	016765 016757	72VMR14/16 72VML14/16	015262	D4010T	015240	T15
016645	7200VM11-160N16/18	160	16-18	17	40	58	49	10	016766 016758	72VMR16/18 72VML16/18	015262	D4010T	015240	T15
016646	7200VM11-160N18/20	160	18-20	19	40	58	49	10	015445 015444	72VMR18/20 72VML18/20	015262	D4010T	015240	T15
016647	7200VM11-200N16/18	200	16-18	17	50	72	62	12	016766 016758	72VMR16/18 72VML16/18	015262	D4010T	015240	T15
016648	7200VM11-200N18/20	200	18-20	19	50	72	62	12	015445 015444	72VMR18/20 72VML18/20	015262	D4010T	015240	T15
016649	7200VM11-250N18/20	250	18-20	19	50	85	81	16	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#	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

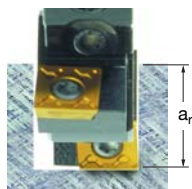


7200 VM 11_N Technical Advice

Milling Cutter Order Example: **7200VM11-250N18/20**
 Milling Insert Order Example: **MPHT1104PPTR-42 MP91M / MPHT1104PPTL-42 MP91M**
 For complete cutting conditions refer to page: **264**



Disc Cutter & Cartridge



Depth of Cut (a_r)



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:

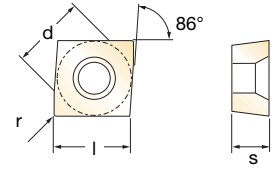
FORMULA EXAMPLE

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

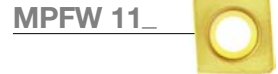
$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

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

Inserts for 7200 VM 11_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h_m min
017643	MPEX 11 04PPFR-701	GH1	▼	▼▼	▼▼▼	11,11	11,11	4,76	Facet	0,02
017644	MPEX 11 04PPFL-701	GH1	◆	◆	◆	11,11	11,11	4,76	Facet	0,02
017440	MPFW 11 04PPTR	GH1				11,11	11,11	4,76	Facet	0,15
017439	MPFW 11 04PPTL	GH1				11,11	11,11	4,76	Facet	0,15
018182	MPFW 11 04PPTR	SF30				11,11	11,11	4,76	Facet	0,15
018181	MPFW 11 04PPTL	SF30				11,11	11,11	4,76	Facet	0,15
017660	MPFW 11 04PPTR	SFZ	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,15
017662	MPFW 11 04PPTL	SFZ	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,15
017777	MPFW 11 04PPTR	X44				11,11	11,11	4,76	Facet	0,15
017336	MPFW 11 04PPTL	X44				11,11	11,11	4,76	Facet	0,15
017299	MPHT 11 04PPTR-42	MP91M	◆	◆	◆	11,11	11,11	4,76	Facet	0,1
017298	MPHT 11 04PPTL-42	MP91M	◆	◆	◆	11,11	11,11	4,76	Facet	0,1
015142	MPHT 11 04PPTR-42	X500	◆◆	◆◆	◆◆	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	