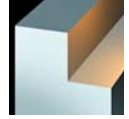


7200 VM 11_R Half Side Disc Cutters

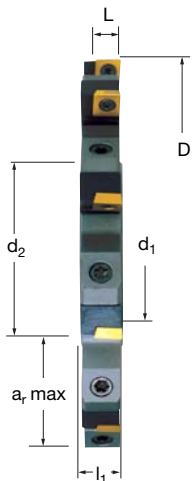


7200 VM 11_R Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	Spares				
		D	L	l_1	d_1	d_2	a_r max.	EDP#		Cartridge	EDP#	EDP#	EDP#	
016744	A7200VM11-160R14/16	6.29	0.437	0.591	1.50	2.28	1.90	10	016765	72VMR14/16	015262	D4010T	015240	T15
016745	A7200VM11-160R16/18	6.29	0.437	0.669	1.50	2.28	1.90	10	016766	72VMR16/18	015262	D4010T	015240	T15
016746	A7200VM11-160R18/20	6.29	0.437	0.748	1.50	2.28	1.90	10	015445	72VMR18/20	015262	D4010T	015240	T15

7200 VM 11_R Cartridge Spares

EDP #	Cartridge Part Number	Adjusting		Cartridge			
		EDP#	EDP#	EDP#	EDP#	EDP#	
016765	72VMR14/16	016858	72.602	015257	72.694T	015273	T20TB
016766	72VMR16/18	016858	72.602	015257	72.694T	015273	T20TB
015445	72VMR18/20	016858	72.602	015257	72.694T	015273	T20TB



7200 VM 11_R Technical Advice

Milling Cutter Order Example: **A7200VM11-160R16/18**
 Milling Insert Order Example: **MPFW1104PPTR 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

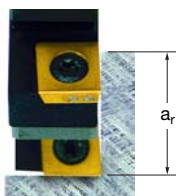
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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

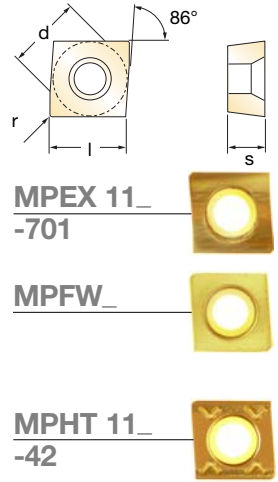


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VM 11_R



EDP#	Assembled 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
017440	MPFW1104PPTR	GH1				0.437	0.437	0.187	Facet	0.0059
018182	MPFW1104PPTR	SF30				0.437	0.437	0.187	Facet	0.0059
017660	MPFW1104PPTR	SFZ	◆◆	◆◆	◆◆	0.437	0.437	0.187	Facet	0.0059
017777	MPFW1104PPTR	X44				0.437	0.437	0.187	Facet	0.0059
017299	MPHT1104PPTR-42	MP91M	◆	◆	◆	0.437	0.437	0.187	Facet	0.0039
015142	MPHT1104PPTR-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
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials