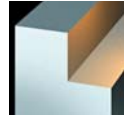




7220 VM 04_L Half Side Disc Cutters



7220 VM 04_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	EDP#	Cartridge	Spares		
		D	L	H	d ₁	d ₂	EDP#				 EDP#	 EDP#	
025499	7220VM 04 -063R06/07L	63	4,7	40	22	35	8	016751	72VML06/07	015059	F2004T	018487	T6
025500	7220VM 04 -063R07/08L	63	4,7	40	22	35	8	016752	72VML07/08	015059	F2004T	018487	T6
025501	7220VM 04 -080R06/07L	80	4,7	45	27	45	10	016751	72VML06/07	015059	F2004T	018487	T6
025502	7220VM 04 -080R07/08L	80	4,7	45	27	45	10	016752	72VML07/08	015059	F2004T	018487	T6

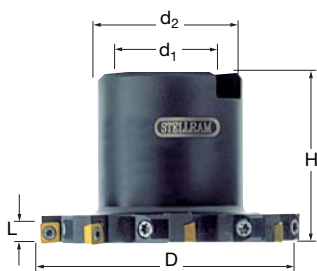
7220 VM 04_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	 EDP#	 EDP#	
016751	72VML06/07	015259	72.698T	013214	T9
016752	72VML07/08	015259	72.698T	013214	T9



7220 VM 04_L Technical Advice

Milling Cutter Order Example: **7220VM04-080R07/08L**
 Milling Insert Order Example: **MPHW0402PPTL X500**
 For complete cutting conditions refer to page: **264**



Disc Cutter & Cartridge

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:

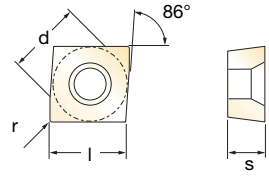
FORMULA EXAMPLE

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

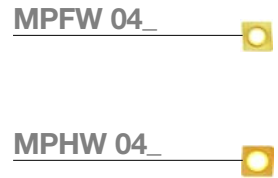
$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

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

Inserts for 7220 VM 04_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
025799	MPFW 04 02PPTL	GH1				4,76	4,76	2,38	Facet	0,07
017646	MPFW 04 02PPTL	SF30				4,76	4,76	2,38	Facet	0,07
015157	MPFW 04 02PPTL	SFZ	◆◆	◆◆	◆◆	4,76	4,76	2,38	Facet	0,07
017426	MPFW 04 02PPTL	X44				4,76	4,76	2,38	Facet	0,07
017667	MPHW 04 02PPTL	X500	◆	◆	◆	4,76	4,76	2,38	Facet	0,07



Recommended Cutting Conditions

Material	Speed V_C (m/min)	Feed h_m (mm)
◆ Unalloyed Steels	180 - 220	0,07 - 0,10
◆ Alloyed Steels	70 - 110	0,07 - 0,08
◆ Stainless Steels	120 - 140	0,07 - 0,10
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,07 - 0,08
◆ Aluminium & Alloys	-	-
◆ 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