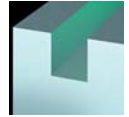


7220 VM 04_N Full Side Disc Cutters



7220 VM 04_N Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	EDP#	Cartridge	Spares			
		D	L min-max.	H	d ₁	d ₂	EDP#				EDP#	EDP#	EDP#	
016700	7220VM 04 -063R06/07N	63	6-7	40	22	35	8	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6	
016701	7220VM 04 -063R07/08N	63	7-8	40	22	35	8	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6	
016702	7220VM 04 -080R06/07N	80	6-7	45	27	45	10	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6	
016703	7220VM 04 -080R07/08N	80	7-8	45	27	45	10	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6	

7220 VM 04_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016759	72VMR06/07	015259	72.698T	013214	T9
016751	72VML06/07	015259	72.698T	013214	T9
016760	72VMR07/08	015259	72.698T	013214	T9
016752	72VML07/08	015259	72.698T	013214	T9

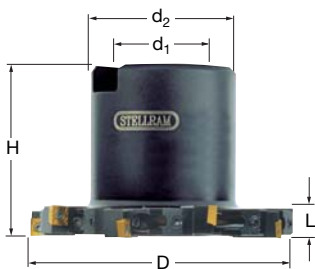


7220 VM 04_N Technical Advice

Milling Cutter Order Example: **7220VM04-063R06/07N**

Milling Insert Order Example: **MPFW0402PPTL SFZ / MPFW0402PPTR SFZ**

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:

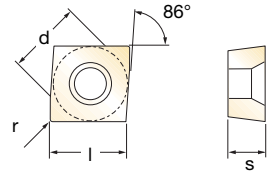
FORMULA EXAMPLE

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

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

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_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024148	MPFW 04 02PPTR	GH1				4,76	4,76	2,38	Facet	0,07
025799	MPFW 04 02PPTL	GH1				4,76	4,76	2,38	Facet	0,07
017645	MPFW 04 02PPTR	SF30				4,76	4,76	2,38	Facet	0,07
017646	MPFW 04 02PPTL	SF30				4,76	4,76	2,38	Facet	0,07
015158	MPFW 04 02PPTR	SFZ	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
015157	MPFW 04 02PPTL	SFZ	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
017427	MPFW 04 02PPTR	X44				4,76	4,76	2,38	Facet	0,07
017426	MPFW 04 02PPTL	X44				4,76	4,76	2,38	Facet	0,07
017666	MPHW 04 02PPTR	X500	◆	◆	◆	4,76	4,76	2,38	Facet	0,07
017667	MPHW 04 02PPTL	X500	◆	◆	◆	4,76	4,76	2,38	Facet	0,07

MPFW 04_

MPHW 04_

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