






7220 VM 06_L Half Side Disc Cutters



7220 VM 06_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#		
025503	7220VM 06 -100R08/09L	100	6,3	50	32	48	12	016753	72VML08/09	015060	 F2505T	018488	T7	
025504	7220VM 06 -100R09/10L	100	6,3	50	32	48	12	016754	72VML09/10	015060	 F2505T	018488	T7	
025505	7220VM 06 -125R09/10L	125	6,3	55	40	62	14	016754	72VML09/10	015060	 F2505T	018488	T7	

7220 VM 06_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	 EDP#	EDP#	 EDP#
016753	72VML08/09	015258	72.697T	015240	T15
016754	72VML09/10	015258	72.697T	015240	T15



7220 VM 06_L Technical Advice

Milling Cutter Order Example: **7220VM06-100R08/09L**
 Milling Insert Order Example: **MPFW0602PPTL SFZ**
 For complete cutting conditions refer to page: **264**

IMPORTANT

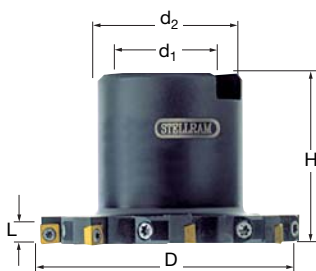
For a given f_z (mm/tooth.) feed rate, **the thickness of the chip h_m (effective feed rate per tooth) decreases with the depth of cut a_r .** It is imperative that this parameter be taken into account when selecting the machine feed rate, calculated in accordance with the formula below:

FORMULA EXAMPLE

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

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

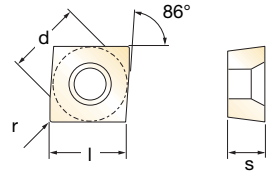
a_r = Depth of Cut (D.O.C.) f_z = Feed per tooth
 D = Cutter diameter h_m = Effective chip thickness



Disc Cutter & Cartridge



Inserts for 7220 VM 06_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h_m min
024926	MPEX 06 02PPFL-701	GH1	◆	◆	◆	6,35	6,35	2,38	Facet	0,02
017639	MPEX 06 02PPFL-701	SFZ				6,35	6,35	2,38	Facet	0,02
017652	MPFW 06 02PPTL	GH1				6,35	6,35	2,38	Facet	0,07
017650	MPFW 06 02PPTL	SF30				6,35	6,35	2,38	Facet	0,07
015159	MPFW 06 02PPTL	SFZ	◆◆	◆◆	◆◆	6,35	6,35	2,38	Facet	0,07
017651	MPFW 06 02PPTL	X44				6,35	6,35	2,38	Facet	0,07
017300	MPHW 06 02PPTL	MP91M	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
017669	MPHW 06 02PPTL	X500	◆	◆	◆	6,35	6,35	2,38	Facet	0,07



Recommended Cutting Conditions

Material	Speed V_C (m/min)	Feed h_m (mm)
◆ Unalloyed Steels	180 - 220	0,07 - 0,12
◆ Alloyed Steels	70 - 110	0,07 - 0,10
◆ Stainless Steels	120 - 140	0,07 - 0,12
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,07 - 0,10
◆ Aluminium & Alloys	275 - 450	0,04 - 0,12
◆ 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