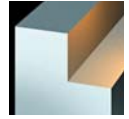




# 7220 VM 06\_R Half Side Disc Cutters



## 7220 VM 06\_R Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	EDP#	Cartridge	Spares			
		D	L	H	d <sub>1</sub>	d <sub>2</sub>	EDP#					EDP#		
016713	7220VM 06 -100R08/09R	100	6,3	50	32	48	12	016761	72VMR08/09	015060	F2505T	018488	T7	
016714	7220VM 06 -100R09/10R	100	6,3	50	32	48	12	016762	72VMR09/10	015060	F2505T	018488	T7	
016715	7220VM 06 -125R09/10R	125	6,3	55	40	62	14	016762	72VMR09/10	015060	F2505T	018488	T7	

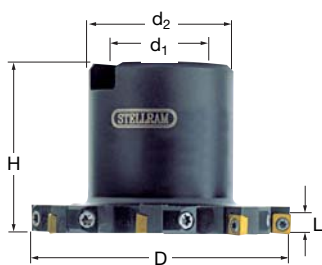
## 7220 VM 06\_R Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#		EDP#	
016761	72VMR08/09	015258	72.697T	015240	T15
016762	72VMR09/10	015258	72.697T	015240	T15



## 7220 VM 06\_R Technical Advice

Milling Cutter Order Example: **7220VM06-100R08/09R**  
 Milling Insert Order Example: **MPFW0602PPTR 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:

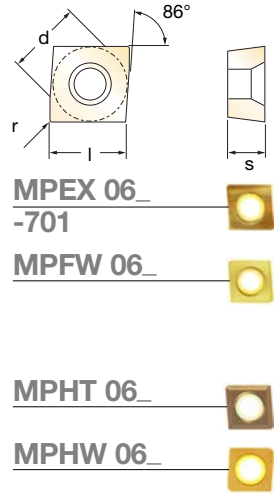
### FORMULA EXAMPLE

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

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

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

## Inserts for 7220 VM 06\_R



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
024927	MPEX 06 02PPFR-701	GH1	◆	◆	◆	6,35	6,35	2,38	Facet	0,02
017638	MPEX 06 02PPFR-701	SFZ				6,35	6,35	2,38	Facet	0,02
017649	MPFW 06 02PPTR	GH1				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ	◆◆	◆◆	◆◆	6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44				6,35	6,35	2,38	Facet	0,07
023247	MPHT 06 02PPER	X44				6,35	6,35	2,38	Facet	0,04
017301	MPHW 06 02PPTR	MP91M	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
023253	MPHW 06 02PPTR	PFZ				6,35	6,35	2,38	Facet	0,07
017668	MPHW 06 02PPTR	X500	◆	◆	◆	6,35	6,35	2,38	Facet	0,07

## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (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<sub>m</sub> = 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