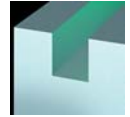


# 7220 VM 08\_N Full Side Disc Cutters



## 7220 VM 08\_N Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	Cartridge		Spares			
		D	L min-max	H	d <sub>1</sub>	d <sub>2</sub>	EDP#		Cartridge	EDP#	EDP#	EDP#	EDP#	
016707	7220VM 08 -125R10/12N	125	10-12	55	40	62	10	016763	72VMR10/12	015063	F3008T	013214	T9	
								016755	72VML10/12					
016708	7220VM 08 -160R10/12N	160	10-12	60	40	66	12	016763	72VMR10/12	015063	F3008T	013214	T9	
								016755	72VML10/12					

## 7220 VM 08\_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016763	72VMR10/12	015256	72.693T	015273	T20TB
016755	72VML10/12	015256	72.693T	015273	T20TB

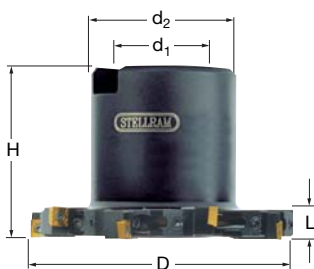


## 7220 VM 08\_N Technical Advice

Milling Cutter Order Example: **7220VM08-125R10/12N**

Milling Insert Order Example: **MPFW08030PPTR SFZ / MPFW08030PPTL 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:

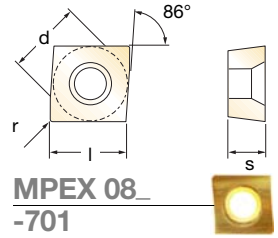
### FORMULA EXAMPLE

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

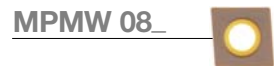
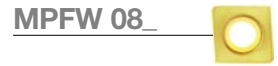
$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

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

# Inserts for 7220 VM 08\_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
017640	MPEX 08 03PPER-701	PFZ				7,94	7,94	3,18	Facet	0,02
017641	MPEX 08 03PEL-701	PFZ				7,94	7,94	3,18	Facet	0,02
017642	MPEX 08 03PPFR-701	GH1	◆	◆	◆	7,94	7,94	3,18	Facet	0,02
024928	MPEX 08 03PPFL-701	GH1	◆	◆	◆	7,94	7,94	3,18	Facet	0,02
017489	MPEX 08 03PPFR-701	SFZ				7,94	7,94	3,18	Facet	0,02
017490	MPEX 08 03PPFL-701	SFZ				7,94	7,94	3,18	Facet	0,02
017655	MPFW 08 03PPTR	GH1				7,94	7,94	3,18	Facet	0,1
017658	MPFW 08 03PPTL	GH1				7,94	7,94	3,18	Facet	0,1
017653	MPFW 08 03PPTR	SF30				7,94	7,94	3,18	Facet	0,1
017656	MPFW 08 03PPTL	SF30				7,94	7,94	3,18	Facet	0,1
014401	MPFW 08 03PPTR	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017659	MPFW 08 03PPTL	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017654	MPFW 08 03PPTR	X44				7,94	7,94	3,18	Facet	0,1
017657	MPFW 08 03PPTL	X44				7,94	7,94	3,18	Facet	0,1
017297	MPHT 08 03PPTR-42	MP91M	◆	◆	◆	7,94	7,94	3,18	Facet	0,1
017296	MPHT 08 03PPTL-42	MP91M	◆	◆	◆	7,94	7,94	3,18	Facet	0,1
023250	MPHT 08 03PPTR-42	PFZ				7,94	7,94	3,18	Facet	0,1
023249	MPHT 08 03PPTL-42	PFZ				7,94	7,94	3,18	Facet	0,1
015140	MPHT 08 03PPTR-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
015138	MPHT 08 03PPTL-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017670	MPMW 08 0304TN	SF30				7,94	7,94	3,18	0,4	0,1



## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)
◆ Unalloyed Steels	180 - 220	0,10 - 0,14
◆ Alloyed Steels	70 - 110	0,10 - 0,12
◆ Stainless Steels	120 - 140	0,10 - 0,12
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,10 - 0,12
◆ 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