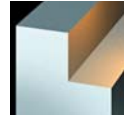




# 7220 VM 08\_R Half Side Disc Cutters



## 7220 VM 08\_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#	 EDP#		
016716	7220VM 08 -125R10/12R	125	7,9	55	40	62	10	016763	72VMR10/12	015063	F3008T	013214	T9	
016717	7220VM 08 -160R10/12R	160	7,9	60	40	66	12	016763	72VMR10/12	015063	F3008T	013214	T9	

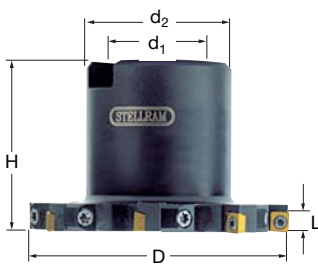
## 7220 VM 08\_R Cartridge Spares

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



## 7220 VM 08\_R Technical Advice

Milling Cutter Order Example: **7220VM08-160R10/12R**  
 Milling Insert Order Example: **MPFW0803PPTR 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\_R



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
017642	MPEX 08 03PPFR-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
017655	MPFW 08 03PPTR	GH1				7,94	7,94	3,18	Facet	0,1
017653	MPFW 08 03PPTR	SF30				7,94	7,94	3,18	Facet	0,1
014401	MPFW 08 03PPTR	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017654	MPFW 08 03PPTR	X44				7,94	7,94	3,18	Facet	0,1
017663	MPHT 08 03PPER	SF30				7,94	7,94	3,18	Facet	0,04
017664	MPHT 08 03PPER	SFZ				7,94	7,94	3,18	Facet	0,04
017665	MPHT 08 03PPFR	GH1				7,94	7,94	3,18	Facet	0,04
017297	MPHT 08 03PPTR-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
015140	MPHT 08 03PPTR-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	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	