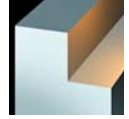


7200 VM 04_L Half Side Disc Cutters

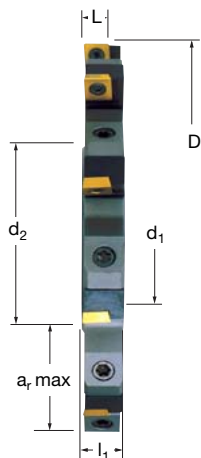


7200 VM 04_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	EDP#	Cartridge	Spares		
		D	L	l ₁	d ₁	d ₂	a _r max.	EDP#				EDP#	EDP#	
023974	A7200VM04-100L06/07	3.94	0.185	0.55	1.25	1.89	0.90	12	016751	72VML06/07	015059	F2004T	018487	T6
023975	A7200VM04-100L07/08	3.94	0.185	0.55	1.25	1.89	0.90	12	016752	72VML07/08	015059	F2004T	018487	T6

7200 VM 04_L Cartridge Spares

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



7200 VM 04_L Technical Advice

Milling Cutter Order Example: **A7200VM04-100L06/07**
 Milling Insert Order Example: **MPHW0402PPTL X500**
 For complete cutting conditions refer to page: **208**

IMPORTANT

For a given f_z (in./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

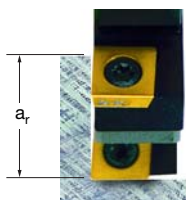
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

$$h_m = \sqrt{\frac{0.4}{6.3}} \times 0.004" = 0.001"$$

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

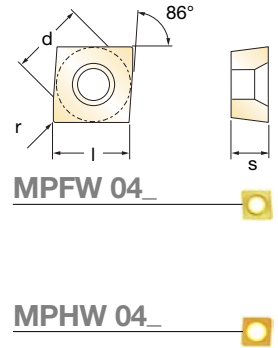


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VM 04_L



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
025799	MPFW0402PPTL	GH1				0.187	0.187	0.094	Facet	0.0028
017646	MPFW0402PPTL	SF30				0.187	0.187	0.094	Facet	0.0028
015157	MPFW0402PPTL	SFZ	◆◆	◆◆	◆◆	0.187	0.187	0.094	Facet	0.0028
017426	MPFW0402PPTL	X44				0.187	0.187	0.094	Facet	0.0028
017667	MPHW0402PPTL	X500	◆	◆	◆	0.187	0.187	0.094	Facet	0.0028

Recommended Cutting Conditions

Material	Speed V_C (feet/min)	Feed h_m (inch)
◆ Unalloyed Steels	600 - 720	0.003 - 0.004
◆ Alloyed Steels	230 - 360	0.003 - 0.003
◆ Stainless Steels	400 - 450	0.003 - 0.004
◆ PH Stainless	-	-
◆ Cast Irons	460 - 910	0.003 - 0.003
◆ Aluminum & 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
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys
					S ◆	High Temp. Alloys
					H ◆	Hard Materials