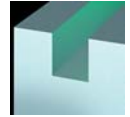


7200 VM 04_N Full Side Disc Cutters

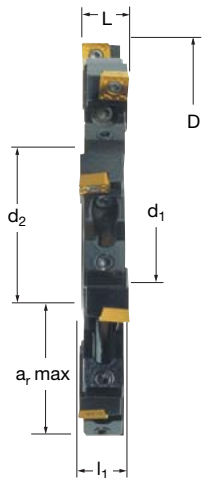


7200 VM 04_N Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	EDP#	Cartridge	Spares		
		D	L	a_r min-max.	l_1	d_1	d_2	a_r max.				EDP#	EDP#	EDP#
016729	A7200VM04-100N06/07	3.94	0.236-0.276	0.55	1.25	1.89	0.90	66	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6
016730	A7200VM04-100N07/08	3.94	0.276-0.315	0.55	1.25	1.89	0.90	66	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6

7200 VM 04_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016759	72VMR06/07	015259	72.698T	013214	T9
016751	72VML06/07	015259	72.698T	013214	T9
016760	72VMR07/08	015259	72.698T	013214	T9
016752	72VML07/08	015259	72.698T	013214	T9

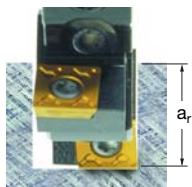


7200 VM 04_N Technical Advice

Milling Cutter Order Example: **A7200VM04-100N06/07**
 Milling Insert Order Example: **MPFW0402PPTR X44 / MPFW0402PPTL X44**
 For complete cutting conditions refer to page: **208**



Disc Cutter & Cartridge



Depth of Cut (a_r)



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:

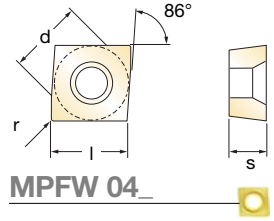
FORMULA EXAMPLE

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

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

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

Inserts for 7200 VM 04_N



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024148	MPFW0402PPTR	GH1				0.187	0.187	0.094	Facet	0.0028
025799	MPFW0402PPTL	GH1				0.187	0.187	0.094	Facet	0.0028
017645	MPFW0402PPTR	SF30				0.187	0.187	0.094	Facet	0.0028
017646	MPFW0402PPTL	SF30				0.187	0.187	0.094	Facet	0.0028
015158	MPFW0402PPTR	SFZ	◆◆◆	◆◆◆	◆◆◆	0.187	0.187	0.094	Facet	0.0028
015157	MPFW0402PPTL	SFZ	◆◆◆	◆◆◆	◆◆◆	0.187	0.187	0.094	Facet	0.0028
017427	MPFW0402PPTR	X44				0.187	0.187	0.094	Facet	0.0028
017426	MPFW0402PPTL	X44				0.187	0.187	0.094	Facet	0.0028
017666	MPHW0402PPTR	X500	◆	◆	◆	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 ◆
			H ◆	Hard Materials			