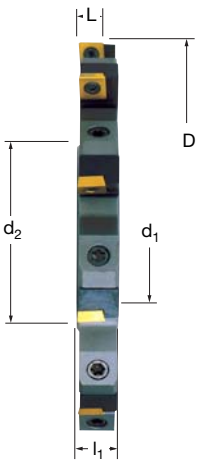
# 7200 VM 06_L Half Side Disc Cutters

## 7200 VM 06_L Assembled Disc & Cartridge

| EDP # | Assembled Part Number | Dimensions (mm) D | L | $l_1$ | $d_1$ | $d_2$ | $a_r$ max. | No. of Inserts | EDP# | Cartridge | Spares EDP# | | EDP# | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 025481 | **7200VM 06 -100L08/09** | 100 | 6,3 | 12 | 32 | 48 | 23 | 12 | 016753 | 72VML08/09 | 015060 | F2505T | 018488 | T7 |
| 025482 | **7200VM 06 -100L09/10** | 100 | 6,3 | 12 | 32 | 48 | 23 | 12 | 016754 | 72VML09/10 | 015060 | F2505T | 018488 | T7 |
| 025483 | **7200VM 06 -125L08/09** | 125 | 6,3 | 12 | 40 | 58 | 31 | 14 | 016753 | 72VML08/09 | 015060 | F2505T | 018488 | T7 |
| 025484 | **7200VM 06 -125L09/10** | 125 | 6,3 | 12 | 40 | 58 | 31 | 14 | 016754 | 72VML09/10 | 015060 | F2505T | 018488 | T7 |

## 7200 VM 06_L Cartridge Spares

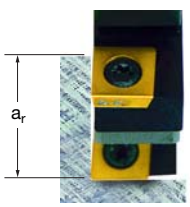
| EDP # | Cartridge Part Number | Cartridge EDP# | | EDP# | |
|---|---|---|---|---|---|
| 016753 | **72VML08/09** | 015258 | 72.697T | 015240 | T15 |
| 016754 | **72VML09/10** | 015258 | 72.697T | 015240 | T15 |




## 7200 VM 06_L Technical Advice

Milling Cutter Order Example: **7200VM06-100L08/09**
Milling Insert Order Example: **MPHW0602PPTL X500**
For complete cutting conditions refer to page: **264**

Disc Cutter & Cartridge




Depth of Cut ($a_r$)

**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:

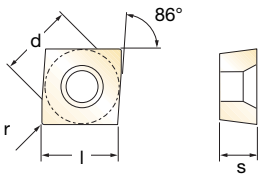
**FORMULA**
**EXAMPLE**

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

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

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

# Inserts for 7200 VM 06_L




| EDP# | Part Number | Grade | Application & Material: Roughing ▼ | Semi-Finishing ▼▼ | Finishing ▼▼▼ | d | l | s | r | $h_m$ min |
|---|---|---|---|---|---|---|---|---|---|---|
| 024926 | **MPEX 06 02PPFL-701** | **GH1** | ♦ | ♦ | ♦ | 6,35 | 6,35 | 2,38 | Facet | 0,02 |
| 017639 | **MPEX 06 02PPFL-701** | **SFZ** | | | | 6,35 | 6,35 | 2,38 | Facet | 0,02 |
| 017652 | **MPFW 06 02PPTL** | **GH1** | | | | 6,35 | 6,35 | 2,38 | Facet | 0,07 |
| 017650 | **MPFW 06 02PPTL** | **SF30** | | | | 6,35 | 6,35 | 2,38 | Facet | 0,07 |
| 015159 | **MPFW 06 02PPTL** | **SFZ** | ♦♦ | ♦♦ | ♦♦ | 6,35 | 6,35 | 2,38 | Facet | 0,07 |
| 017651 | **MPFW 06 02PPTL** | **X44** | | | | 6,35 | 6,35 | 2,38 | Facet | 0,07 |
| 017300 | **MPHW 06 02PPTL** | **MP91M** | ♦ | ♦ | ♦ | 6,35 | 6,35 | 2,38 | Facet | 0,07 |
| 017669 | **MPHW 06 02PPTL** | **X500** | ♦ | ♦ | ♦ | 6,35 | 6,35 | 2,38 | Facet | 0,07 |

**MPEX 06_ -701**

**MPFW 06_**

**MPHW 06_**

## Recommended Cutting Conditions

| Material | Speed $V_c$ (m/min) | Feed $h_m$ (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) | - | - |

$h_m$ = 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 |



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