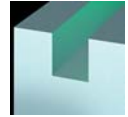


7200 VM 06_N Full Side Disc Cutters

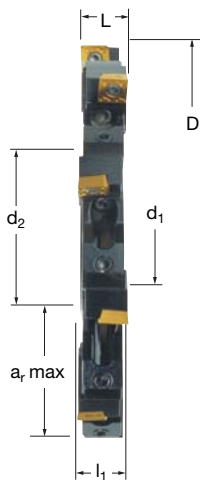


7200 VM 06_N Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)							No. of Inserts	Spares		EDP#	EDP#	EDP#	EDP#
		D	L	d_1	d_2	a_r max.	EDP#	Cartridge							
016731	A7200VM06-100N08/09	3.94	0.315-0.354	0.472	1.25	1.89	0.90	66	016761 016753	72VMR08/09 72VML08/09	015060	F2505T	018488	T7	
016732	A7200VM06-100N09/10	3.94	0.354-0.394	0.472	1.25	1.89	0.90	66	016762 016754	72VMR09/10 72VML09/10	015060	F2505T	018488	T7	

7200 VM 06_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016761	72VMR08/09	015258	72.697T	015240	T15
016753	72VML08/09	015258	72.697T	015240	T15
016762	72VMR09/10	015258	72.697T	015240	T15
016754	72VML09/10	015258	72.697T	015240	T15

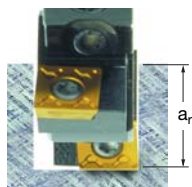


7200 VM 06_N Technical Advice

Milling Cutter Order Example: **A7200VM06-100N09/10**
 Milling Insert Order Example: **MPHW0602PPTL X500 / MPHW0602PPTR X500**
 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:

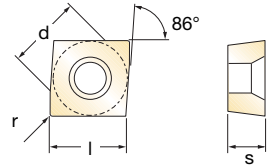
FORMULA EXAMPLE

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

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

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 06_N



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h_m min
024927	MPEX0602PPFR-701	GH1	◆	◆	◆	0.250	0.250	0.094	Facet	0.0008
024926	MPEX0602PPFL-701	GH1	◆	◆	◆	0.250	0.250	0.094	Facet	0.0008
017638	MPEX0602PPFR-701	SFZ				0.250	0.250	0.094	Facet	0.0008
017639	MPEX0602PPFL-701	SFZ				0.250	0.250	0.094	Facet	0.0008
017649	MPFW0602PPTR	GH1				0.250	0.250	0.094	Facet	0.0028
017652	MPFW0602PPTL	GH1				0.250	0.250	0.094	Facet	0.0028
017647	MPFW0602PPTR	SF30				0.250	0.250	0.094	Facet	0.0028
017650	MPFW0602PPTL	SF30				0.250	0.250	0.094	Facet	0.0028
014400	MPFW0602PPTR	SFZ	◆◆	◆◆	◆◆	0.250	0.250	0.094	Facet	0.0028
015159	MPFW0602PPTL	SFZ	◆◆	◆◆	◆◆	0.250	0.250	0.094	Facet	0.0028
017648	MPFW0602PPTR	X44				0.250	0.250	0.094	Facet	0.0028
017651	MPFW0602PPTL	X44				0.250	0.250	0.094	Facet	0.0028
017301	MPHW0602PPTR	MP91M	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028
017300	MPHW0602PPTL	MP91M	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028
017669	MPHW0602PPTL	X500	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028
017668	MPHW0602PPTR	X500	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028

MPEX 06_ -701

MPFW 06_

MPHW 06_

Recommended Cutting Conditions

Material	Speed V_C (feet/min)	Feed h_m (inch)
◆ Unalloyed Steels	600 - 720	0.003 - 0.005
◆ Alloyed Steels	230 - 360	0.003 - 0.004
◆ Stainless Steels	400 - 450	0.003 - 0.005
◆ PH Stainless	-	-
◆ Cast Irons	460 - 910	0.003 - 0.004
◆ Aluminum & Alloys	910 - 1470	0.002 - 0.005
◆ 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