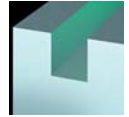
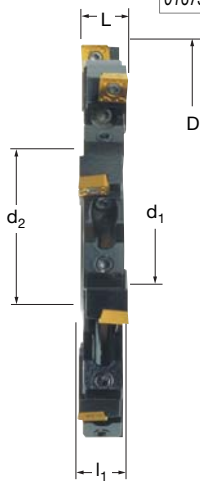


# 7200 VM 08\_N Full Side Disc Cutters



7200 VM 08_N Assembled Disc & Cartridge															
EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares			
		D	L	$l_1$	$d_1$	$d_2$	$a_r$ max.	EDP#				EDP#	EDP#	EDP#	
016636	7200VM 08 -100N10/12	100	10-12	11	32	48	24	8	016763	72VMR10/12	015063	F3008T	013214	T9	
									016755	72VML10/12					
016637	7200VM 08 -100N12/14	100	12-14	13	32	48	24	8	016764	72VMR12/14	015063	F3008T	013214	T9	
									016756	72VML12/14					
016638	7200VM 08 -125N10/12	125	10-12	11	40	58	32	10	016763	72VMR10/12	015063	F3008T	013214	T9	
									016755	72VML10/12					
016639	7200VM 08 -125N12/14	125	12-14	13	40	58	32	10	016764	72VMR12/14	015063	F3008T	013214	T9	
									016756	72VML12/14					
016640	7200VM 08 -160N10/12	160	10-12	11	40	58	49	12	016763	72VMR10/12	015063	F3008T	013214	T9	
									016755	72VML10/12					
016641	7200VM 08 -160N12/14	160	12-14	13	40	58	49	12	016764	72VMR12/14	015063	F3008T	013214	T9	
									016756	72VML12/14					

7200 VM 08_N Cartridge Spares										
EDP #	Cartridge Part Number	Cartridge								
		EDP#	EDP#	EDP#	EDP#					
016763	72VMR10/12	015256	72.693T	015273	T20TB					
016755	72VML10/12	015256	72.693T	015273	T20TB					
016764	72VMR12/14	015256	72.693T	015273	T20TB					
016756	72VML12/14	015256	72.693T	015273	T20TB					

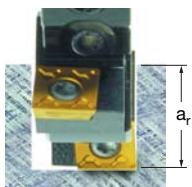


## 7200 VM 08\_N Technical Advice

Milling Cutter Order Example: **7200VM08-100N10/12**  
 Milling Insert Order Example: **MPHT0803PPTR-42 MP91M / MPHT0803PPTL-42 MP91M**  
 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:

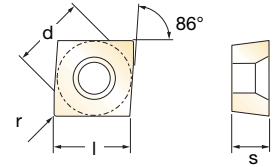
### FORMULA EXAMPLE

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

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

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

# Inserts for 7200 VM 08\_N



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
017641	MPEX 08 03PEL-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
024928	MPEX 08 03PPFL-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
017490	MPEX 08 03PPFL-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
017658	MPFW 08 03PPTL	GH1				7,94	7,94	3,18	Facet	0,1
017653	MPFW 08 03PPTR	SF30				7,94	7,94	3,18	Facet	0,1
017656	MPFW 08 03PPTL	SF30				7,94	7,94	3,18	Facet	0,1
014401	MPFW 08 03PPTR	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017659	MPFW 08 03PPTL	SFZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017654	MPFW 08 03PPTR	X44				7,94	7,94	3,18	Facet	0,1
017657	MPFW 08 03PPTL	X44				7,94	7,94	3,18	Facet	0,1
017297	MPHT 08 03PPTR-42	MP91M	◆	◆	◆	7,94	7,94	3,18	Facet	0,1
017296	MPHT 08 03PPTL-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
023249	MPHT 08 03PPTL-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
015138	MPHT 08 03PPTL-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1

MPEX 08\_ -701

MPFW 08\_

MPHT 08\_ -42

## 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