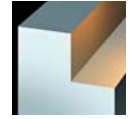


7200 VA 16_L Half Side Disc Cutters

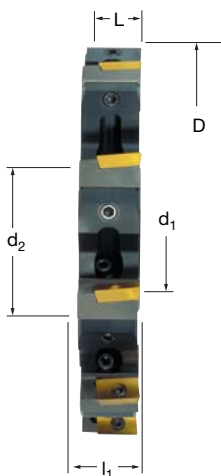


7200 VA 16_L Assembled Disc & Cartridge

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#	
025470	7200VA 16 -160L20/23	160	16	21	40	58	49	10	016747	72VAL20/23	015262	D4010T	015240	T15	
025471	7200VA 16 -160L23/26	160	16	24	40	58	49	10	016748	72VAL23/26	015262	D4010T	015240	T15	
025472	7200VA 16 -200L20/23	200	16	21	50	72	62	12	016747	72VAL20/23	015262	D4010T	015240	T15	
025473	7200VA 16 -250L20/23	250	16	21	50	85	81	16	016747	72VAL20/23	015262	D4010T	015240	T15	
025474	7200VA 16 -250L23/26	250	16	24	50	85	81	16	016748	72VAL23/26	015262	D4010T	015240	T15	

7200 VA 16_L Cartridge Spares

EDP #	Cartridge Part Number	Adjusting		Cartridge		
		EDP#	EDP#	EDP#	EDP#	EDP#
016747	72VAL20/23	016858	72.602	015257	72.694T	015273 T20TB
016748	72VAL23/26	016858	72.602	015257	72.694T	015273 T20TB



7200 VA 16_L Technical Advice

Milling Cutter Order Example: **7200VA16-250L23/26**
 Milling Insert Order Example: **APFW1604PDTL SFZ**
 For complete cutting conditions refer to page: **264**

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

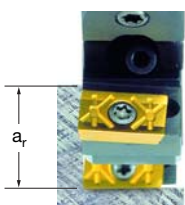
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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

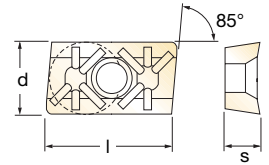


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VA 16_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017625	APEX 16 04PDFL-701	SFZ				9,52	16,66	4,76	Facet	0,02
017624	APEX 16 04PDFL-701	GH1	◆	◆	◆	9,52	16,66	4,76	Facet	0,02
024922	APFW 16 04PDTL	X44				9,52	16,66	4,76	Facet	0,1
017630	APFW 16 04PDTL	GH1				9,52	16,66	4,76	Facet	0,1
017631	APFW 16 04PDTL	SF30				9,52	16,66	4,76	Facet	0,1
024075	APFW 16 04PDTL	SFZ	◆	◆	◆	9,52	16,66	4,76	Facet	0,1
017292	APHT 16 04PDTL-42	MP91M	◆◆	◆◆	◆◆	9,52	16,66	4,76	Facet	0,1
024088	APHT 16 04PDTL-42	PFZ				9,52	16,66	4,76	Facet	0,1
017635	APHT 16 04PDTL-42	X500	◆◆	◆◆	◆◆	9,52	16,66	4,76	Facet	0,1



Recommended Cutting Conditions

Material	Speed V _C (m/min)	Feed h _m (mm)
◆ Unalloyed Steels	180 - 220	0,15 - 0,28
◆ Alloyed Steels	70 - 110	0,14 - 0,25
◆ Stainless Steels	120 - 140	0,12 - 0,25
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,12 - 0,20
◆ 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	