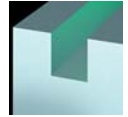
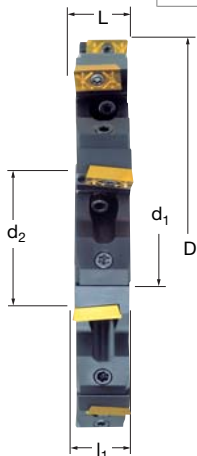


7200 VA 16_N Full Side Disc Cutters



7200 VA 16_N Assembled Disc & Cartridge															
EDP #	Assembled Part Number	Dimensions (mm)							No. of Inserts	EDP#	Cartridge	Spares			
		D	L	d_1	d_2	a_r max.	min-max.	l_1				EDP#	EDP#	EDP#	EDP#
016616	7200VA 16 -160N20/23	160	20-23	21	40	58	49	10	016749 016747	72VAR20/23 72VAL20/23	015262	D4010T	015240	T15	
016617	7200VA 16 -160N23/26	160	23-26	24	40	58	49	10	016750 016748	72VAR23/26 72VAL23/26	015262	D4010T	015240	T15	
016618	7200VA 16 -200N20/23	200	20-23	21	50	72	62	12	016749 016747	72VAR20/23 72VAL20/23	015262	D4010T	015240	T15	
016619	7200VA 16 -250N20/23	250	20-23	21	50	85	81	16	016749 016747	72VAR20/23 72VAL20/23	015262	D4010T	015240	T15	
016620	7200VA 16 -250N23/26	250	23-26	24	50	85	81	16	016750 016748	72VAR23/26 72VAL23/26	015262	D4010T	015240	T15	

7200 VA 16_N Cartridge Spares									
EDP #	Cartridge Part Number	Adjusting		Cartridge		EDP#	EDP#	EDP#	EDP#
		EDP#	EDP#	EDP#	EDP#				
016749	72VAR20/23	016858	72.602	015257	72.694T	015273	T20TB		
016747	72VAL20/23	016858	72.602	015257	72.694T	015273	T20TB		
016750	72VAR23/26	016858	72.602	015257	72.694T	015273	T20TB		
016748	72VAL23/26	016858	72.602	015257	72.694T	015273	T20TB		

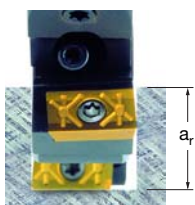


7200 VA 16_N Technical Advice

Milling Cutter Order Example: **7200VA16-200N20/23**
 Milling Insert Order Example: **APFW1604PDTL SFZ / APFW1604PDTR SFZ**
 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:

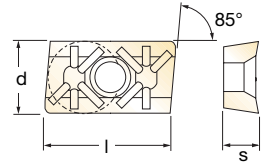
FORMULA EXAMPLE

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

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

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

Inserts for 7200 VA 16_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
017623	APEX 16 04PDFR-701	SFZ				9,52	16,66	4,76	Facet	0,02
017625	APEX 16 04PDFL-701	SFZ				9,52	16,66	4,76	Facet	0,02
014066	APEX 16 04PDFR-701	GH1	◆	◆	◆	9,52	16,66	4,76	Facet	0,02
017624	APEX 16 04PDFL-701	GH1	◆	◆	◆	9,52	16,66	4,76	Facet	0,02
017627	APFW 16 04PDTR	X44				9,52	16,66	4,76	Facet	0,1
024922	APFW 16 04PDTL	X44				9,52	16,66	4,76	Facet	0,1
017628	APFW 16 04PDTR	GH1				9,52	16,66	4,76	Facet	0,1
017630	APFW 16 04PDTL	GH1				9,52	16,66	4,76	Facet	0,1
017626	APFW 16 04PDTR	SF30				9,52	16,66	4,76	Facet	0,1
017631	APFW 16 04PDTL	SF30				9,52	16,66	4,76	Facet	0,1
017629	APFW 16 04PDTR	SFZ	◆	◆	◆	9,52	16,66	4,76	Facet	0,1
024075	APFW 16 04PDTL	SFZ	◆	◆	◆	9,52	16,66	4,76	Facet	0,1
017293	APHT 16 04PDTR-42	MP91M	◆◆	◆◆	◆◆	9,52	16,66	4,76	Facet	0,1
017292	APHT 16 04PDTL-42	MP91M	◆◆	◆◆	◆◆	9,52	16,66	4,76	Facet	0,1
017634	APHT 16 04PDTR-42	PFZ				9,52	16,66	4,76	Facet	0,1
024088	APHT 16 04PDTL-42	PFZ				9,52	16,66	4,76	Facet	0,1
015155	APHT 16 04PDTR-42	X500	◆◆	◆◆	◆◆	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