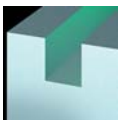
7200 VM 04_N Full Side Disc Cutters

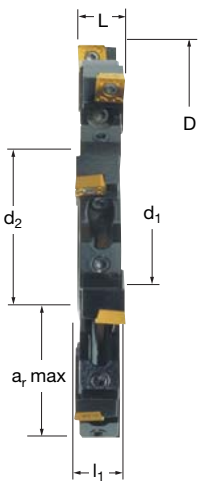


7200 VM 04_N Assembled Disc & Cartridge

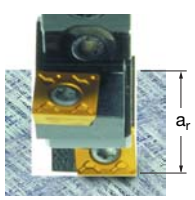
EDP #	Assembled Part Number	Dimensions (inch) D	L min-max.	l_1	d_1	d_2	a_r max.	No. of Inserts	EDP#	Cartridge	Spares EDP#		EDP#	
016729	**A7200VM04-100N06/07**	3.94	0.236-0.276	0.55	1.25	1.89	0.90	66	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6
016730	**A7200VM04-100N07/08**	3.94	0.276-0.315	0.55	1.25	1.89	0.90	66	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6

7200 VM 04_N Cartridge Spares

EDP #	Cartridge Part Number	Cartridge EDP#		EDP#	
016759	**72VMR06/07**	015259	72.698T	013214	T9
016751	**72VML06/07**	015259	72.698T	013214	T9
016760	**72VMR07/08**	015259	72.698T	013214	T9
016752	**72VML07/08**	015259	72.698T	013214	T9



Disc Cutter & Cartridge



Depth of Cut (a_r)

7200 VM 04_N Technical Advice

Milling Cutter Order Example: **A7200VM04-100N06/07**
Milling Insert Order Example: **MPFW0402PPTR X44 / MPFW0402PPTL X44**
For complete cutting conditions refer to page: **208**

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:

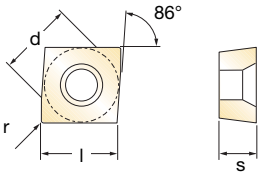
FORMULA
EXAMPLE

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

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

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 04_N



MPFW 04_

EDP#	Part Number	Grade	Application & Material Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	Dimensions (inch) d	l	s	r	h_m min
024148	**MPFW0402PPTR**	**GH1**				0.187	0.187	0.094	Facet	0.0028
025799	**MPFW0402PPTL**	**GH1**				0.187	0.187	0.094	Facet	0.0028
017645	**MPFW0402PPTR**	**SF30**				0.187	0.187	0.094	Facet	0.0028
017646	**MPFW0402PPTL**	**SF30**				0.187	0.187	0.094	Facet	0.0028
015158	**MPFW0402PPTR**	**SFZ**	◆◆◆	◆◆◆	◆◆◆	0.187	0.187	0.094	Facet	0.0028
015157	**MPFW0402PPTL**	**SFZ**	◆◆◆	◆◆◆	◆◆◆	0.187	0.187	0.094	Facet	0.0028
017427	**MPFW0402PPTR**	**X44**				0.187	0.187	0.094	Facet	0.0028
017426	**MPFW0402PPTL**	**X44**				0.187	0.187	0.094	Facet	0.0028

MPHW 04_

017666	**MPHW0402PPTR**	**X500**	◆	◆	◆	0.187	0.187	0.094	Facet	0.0028
017667	**MPHW0402PPTL**	**X500**	◆	◆	◆	0.187	0.187	0.094	Facet	0.0028

Recommended Cutting Conditions

Material	Speed V_c (feet/min)	Feed h_m (inch)
Unalloyed Steels	600 - 720	0.003 - 0.004
Alloyed Steels	230 - 360	0.003 - 0.003
Stainless Steels	400 - 450	0.003 - 0.004
PH Stainless	-	-
Cast Irons	460 - 910	0.003 - 0.003
Aluminum & Alloys	-	-
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 Aluminum & Alloys	H Hard Materials

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