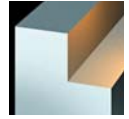


7200 VM 11_R Half Side Disc Cutters

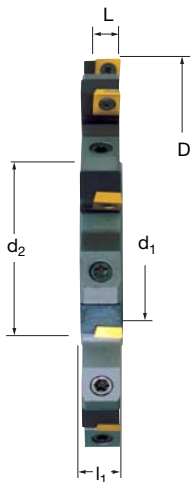


7200 VM 11_R Assembled Disc & Cartridge

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#	
016668	7200VM 11 -125R14/16	125	11,1	15	40	58	32	8	016765	72VMR14/16	015262	D4010T	015240	T15
016669	7200VM 11 -125R16/18	125	11,1	17	40	58	32	8	016766	72VMR16/18	015262	D4010T	015240	T15
016670	7200VM 11 -160R14/16	160	11,1	15	40	58	49	10	016765	72VMR14/16	015262	D4010T	015240	T15
016671	7200VM 11 -160R16/18	160	11,1	17	40	58	49	10	016766	72VMR16/18	015262	D4010T	015240	T15
016672	7200VM 11 -160R18/20	160	11,1	19	40	58	49	10	015445	72VMR18/20	015262	D4010T	015240	T15
016673	7200VM 11 -200R16/18	200	11,1	17	50	72	62	12	016766	72VMR16/18	015262	D4010T	015240	T15
016674	7200VM 11 -200R18/20	200	11,1	19	50	72	62	12	015445	72VMR18/20	015262	D4010T	015240	T15
016675	7200VM 11 -250R18/20	250	11,1	19	50	85	81	16	015445	72VMR18/20	015262	D4010T	015240	T15

7200 VM 11_R Cartridge Spares

EDP #	Cartridge Part Number	Adjusting		Cartridge		
		EDP#	EDP#	EDP#	EDP#	EDP#
016765	72VMR14/12	016858	72.602	015257	72.694T	015273 T20TB
016766	72VMR16/18	016858	72.602	015257	72.694T	015273 T20TB
015445	72VMR18/20	016858	72.602	015257	72.694T	015273 T20TB



7200 VM 11_R Technical Advice

Milling Cutter Order Example: **7200VM11-200R16/18**
 Milling Insert Order Example: **MPFW1104PPTR 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

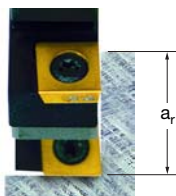
$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

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

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

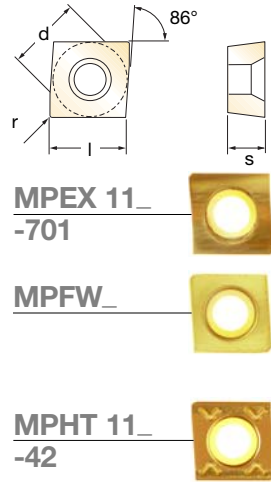


Disc Cutter & Cartridge



Depth of Cut (a_r)

Inserts for 7200 VM 11_R



EDP#	Assembled Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017643	MPEX 11 04PPFR-701	GH1	▼	▼▼	▼▼▼	11,11	11,11	4,76	Facet	0,02
017440	MPFW 11 04PPTR	GH1				11,11	11,11	4,76	Facet	0,15
018182	MPFW 11 04PPTR	SF30				11,11	11,11	4,76	Facet	0,15
017660	MPFW 11 04PPTR	SFZ	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,15
017777	MPFW 11 04PPTR	X44				11,11	11,11	4,76	Facet	0,15
017299	MPHT 11 04PPTR-42	MP91M	◆	◆	◆	11,11	11,11	4,76	Facet	0,1
015142	MPHT 11 04PPTR-42	X500	◆◆	◆◆	◆◆	11,11	11,11	4,76	Facet	0,1

Recommended Cutting Conditions

Material	Speed V _C (m/min)	Feed h _m (mm)
◆ Unalloyed Steels	180 - 220	0,15 - 0,40
◆ Alloyed Steels	70 - 110	0,15 - 0,30
◆ Stainless Steels	120 - 140	0,12 - 0,30
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,12 - 0,30
◆ Aluminium & Alloys	275 - 450	0,06 - 0,28
◆ 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