7220 VM 04_N Full Side Disc Cutters

7220 VM 04_N Assembled Disc & Cartridge

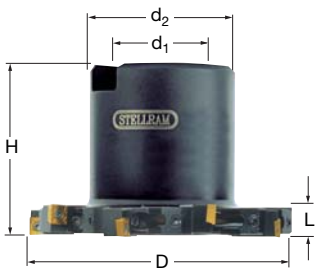
EDP #	Assembled Part Number	Dimensions (mm) D	L min-max.	H	d_1	d_2	No. of Inserts	EDP#	Cartridge	Spares EDP#		EDP#	
016700	**7220VM 04 -063R06/07N**	63	6-7	40	22	35	8	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6
016701	**7220VM 04 -063R07/08N**	63	7-8	40	22	35	8	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6
016702	**7220VM 04 -080R06/07N**	80	6-7	45	27	45	10	016759 016751	72VMR06/07 72VML06/07	015059	F2004T	018487	T6
016703	**7220VM 04 -080R07/08N**	80	7-8	45	27	45	10	016760 016752	72VMR07/08 72VML07/08	015059	F2004T	018487	T6

7220 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

7220 VM 04_N Technical Advice

Milling Cutter Order Example: **7220VM04-063R06/07N**
Milling Insert Order Example: **MPFW0402PPTL SFZ / MPFW0402PPTR SFZ**
For complete cutting conditions refer to page: **264**



Disc Cutter & Cartridge

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:

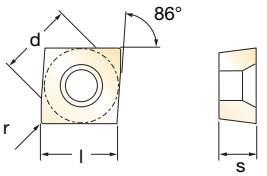
FORMULA
EXAMPLE

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

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

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

Inserts for 7220 VM 04_N



MPFW 04_

EDP#	Part Number	Grade	Application & Material Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	Dimensions (mm) d	l	s	r	h_m min
024148	**MPFW 04 02PPTR**	**GH1**				4,76	4,76	2,38	Facet	0,07
025799	**MPFW 04 02PPTL**	**GH1**				4,76	4,76	2,38	Facet	0,07
017645	**MPFW 04 02PPTR**	**SF30**				4,76	4,76	2,38	Facet	0,07
017646	**MPFW 04 02PPTL**	**SF30**				4,76	4,76	2,38	Facet	0,07
015158	**MPFW 04 02PPTR**	**SFZ**	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
015157	**MPFW 04 02PPTL**	**SFZ**	◆◆◆	◆◆◆	◆◆◆	4,76	4,76	2,38	Facet	0,07
017427	**MPFW 04 02PPTR**	**X44**				4,76	4,76	2,38	Facet	0,07
017426	**MPFW 04 02PPTL**	**X44**				4,76	4,76	2,38	Facet	0,07

MPHW 04_

017666	**MPHW 04 02PPTR**	**X500**	◆	◆	◆	4,76	4,76	2,38	Facet	0,07
017667	**MPHW 04 02PPTL**	**X500**	◆	◆	◆	4,76	4,76	2,38	Facet	0,07

Recommended Cutting Conditions

Material	Speed V_c (m/min)	Feed h_m (mm)
◆ Unalloyed Steels	180 - 220	0,07 - 0,10
◆ Alloyed Steels	70 - 110	0,07 - 0,08
◆ Stainless Steels	120 - 140	0,07 - 0,10
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,07 - 0,08
◆ Aluminium & 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 ◆ Aluminium & Alloys	H ◆ Hard Materials

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