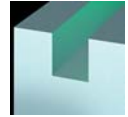






# 7220 VM 06\_N Full Side Disc Cutters



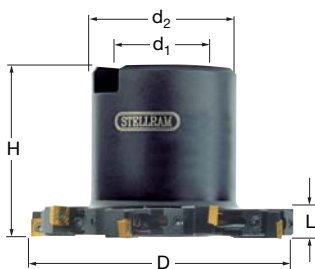
7220 VM 06_N Assembled Disc & Cartridge														
EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	EDP# Cartridge		Spares			
		D	L min-max.	H	d <sub>1</sub>	d <sub>2</sub>	EDP#		Cartridge	EDP#		EDP#		
016704	7220VM 06 -100R08/09N	100	8-9	50	32	48	12	016761 016753	72VMR08/09 72VML08/09	015060	F2505T	018488	T7	
016705	7220VM 06 -100R09/10N	100	9-10	50	32	48	12	016762 016754	72VMR09/10 72VML09/10	015060	F2505T	018488	T7	
016706	7220VM 06 -125R09/10N	125	9-10	55	40	62	14	016762 016754	72VMR09/10 72VML09/10	015060	F2505T	018488	T7	

7220 VM 06_N Cartridge Spares									
EDP #	Cartridge Part Number	Cartridge							
		EDP#		EDP#					
016761	72VMR08/09	015258	72.697T	015240	T15				
016753	72VML08/09	015258	72.697T	015240	T15				
016762	72VMR09/10	015258	72.697T	015240	T15				
016754	72VML09/10	015258	72.697T	015240	T15				



## 7220 VM 06\_N Technical Advice

Milling Cutter Order Example: **7220VM06-100R08/09N**  
 Milling Insert Order Example: **MPHW0602PPTR MP91M / MPHW0602PPTL MP91M**  
 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:

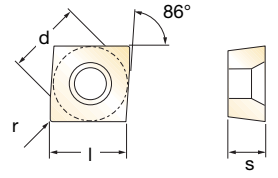
### FORMULA EXAMPLE

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

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

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

## Inserts for 7220 VM 06\_N



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h <sub>m</sub> min
024927	MPEX 06 02PPFR-701	GH1	◆	◆	◆	6,35	6,35	2,38	Facet	0,02
024926	MPEX 06 02PPFL-701	GH1	◆	◆	◆	6,35	6,35	2,38	Facet	0,02
017638	MPEX 06 02PPFR-701	SFZ				6,35	6,35	2,38	Facet	0,02
017639	MPEX 06 02PPFL-701	SFZ				6,35	6,35	2,38	Facet	0,02
017649	MPFW 06 02PPTR	GH1				6,35	6,35	2,38	Facet	0,07
017652	MPFW 06 02PPTL	GH1				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30				6,35	6,35	2,38	Facet	0,07
017650	MPFW 06 02PPTL	SF30				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ	◆◆	◆◆	◆◆	6,35	6,35	2,38	Facet	0,07
015159	MPFW 06 02PPTL	SFZ	◆◆	◆◆	◆◆	6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44				6,35	6,35	2,38	Facet	0,07
017651	MPFW 06 02PPTL	X44				6,35	6,35	2,38	Facet	0,07
017301	MPHW 06 02PPTR	MP91M	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
017300	MPHW 06 02PPTL	MP91M	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
017669	MPHW 06 02PPTL	X500	◆	◆	◆	6,35	6,35	2,38	Facet	0,07
017668	MPHW 06 02PPTR	X500	◆	◆	◆	6,35	6,35	2,38	Facet	0,07

MPEX 06\_ -701

MPFW 06\_

MPHW 06\_

## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)
◆ Unalloyed Steels	180 - 220	0,10 - 0,15
◆ Alloyed Steels	70 - 110	0,08 - 0,12
◆ Stainless Steels	-	-
◆ PH Stainless	-	-
◆ Cast Irons	140 - 280	0,08 - 0,12
◆ Aluminium & Alloys	275 - 450	0,06 - 0,10
◆ High Temp. Alloys	-	-
◆ Hard Steels (52-56 HRC)	-	-

h<sub>m</sub> = 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	