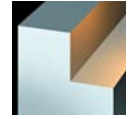


7200 VA 16_R Half Side Disc Cutters

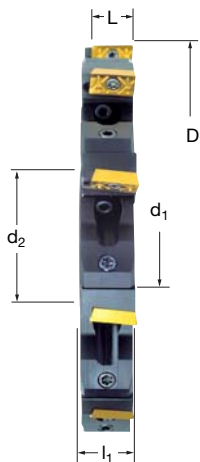


7200 VA 16_R Assembled Disc & Cartridge

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#	EDP#	
016621	7200VA 16 -160R20/23	160	16	21	40	58	49	10	016749	72VAR20/23	015262	D4010T	015240	T15	
016622	7200VA 16 -160R23/26	160	16	24	40	58	49	10	016750	72VAR23/26	015262	D4010T	015240	T15	
016623	7200VA 16 -200R20/23	200	16	21	50	72	62	12	016749	72VAR20/23	015262	D4010T	015240	T15	
016624	7200VA 16 -250R20/23	250	16	21	50	85	81	16	016749	72VAR20/23	015262	D4010T	015240	T15	
016625	7200VA 16 -250R23/26	250	16	24	50	85	81	16	016750	72VAR23/26	015262	D4010T	015240	T15	

7200 VA 16_R Spares

EDP #	Cartridge Part Number	Adjusting		Cartridge			
		EDP#	EDP#	EDP#	EDP#	EDP#	
016749	72VAR20/23	016858	72.602	015257	72.694T	015273	T20TB
016750	72VAR23/26	016858	72.602	015257	72.694T	015273	T20TB

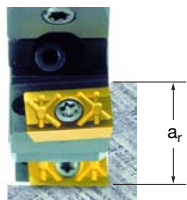


7200 VA 16_R Technical Advice

Milling Cutter Order Example: **7200VA16-160R20/23**
 Milling Insert Order Example: **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:

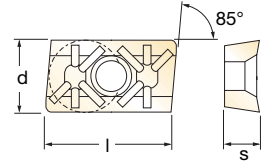
FORMULA EXAMPLE

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

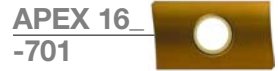
$$h_m = \sqrt{\frac{10}{200}} \times 0,5 = 0,223 \times 0,5 = 0,111 \text{ mm}$$

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_R



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
014066	APEX 16 04PDFR-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
017628	APFW 16 04PDTR	GH1				9,52	16,66	4,76	Facet	0,1
017626	APFW 16 04PDTR	SF30				9,52	16,66	4,76	Facet	0,1
017629	APFW 16 04PDTR	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
017634	APHT 16 04PDTR-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



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