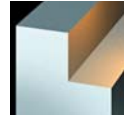




# 7220 VM 08\_L Half Side Disc Cutters



## 7220 VM 08\_L Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (mm)						No. of Inserts	EDP#	Cartridge	Spares		
		D	L	H	d <sub>1</sub>	d <sub>2</sub>	EDP#				 EDP#	 EDP#	
025506	7220VM 08 -125R10/12L	125	7,9	55	40	62	10	016755	72VML10/12	015063	F3008T	013214	T9
025507	7220VM 08 -160R10/12L	160	7,9	60	40	66	12	016755	72VML10/12	015063	F3008T	013214	T9

## 7220 VM 08\_L Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	 EDP#	 EDP#	
016755	72VML10/12	015256	72.693T	015273	T20TB



## 7220 VM 08\_L Technical Advice

Milling Cutter Order Example: **7220VM08-160R10/12L**  
 Milling Insert Order Example: **MPFW0803PPTL SFZ**  
 For complete cutting conditions refer to page: **264**

### IMPORTANT

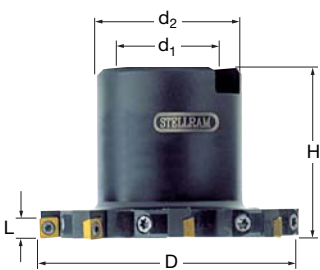
For a given  $f_z$  (mm/tooth.) feed rate, **the thickness of the chip  $h_m$**  (effective feed rate per tooth) **decreases with the depth of cut  $a_r$** . It is imperative that this parameter be taken into account when selecting the machine feed rate, calculated in accordance with the formula below:

### FORMULA EXAMPLE

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

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

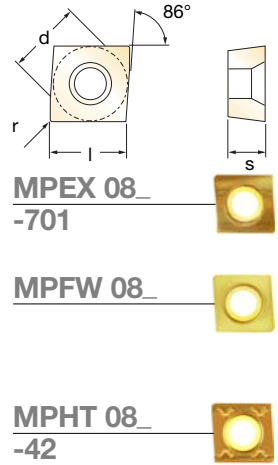
$a_r$  = Depth of Cut (D.O.C.)     $f_z$  = Feed per tooth  
 $D$  = Cutter diameter             $h_m$  = Effective chip thickness



Disc Cutter & Cartridge



## Inserts for 7220 VM 08\_L



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
017641	MPEX 08 03PPEL-701	PfZ				7,94	7,94	3,18	Facet	0,02
024928	MPEX 08 03PPFL-701	GH1	◆	◆	◆	7,94	7,94	3,18	Facet	0,02
017490	MPEX 08 03PPFL-701	SfZ				7,94	7,94	3,18	Facet	0,02
017658	MPFW 08 03PPTL	GH1				7,94	7,94	3,18	Facet	0,1
017656	MPFW 08 03PPTL	Sf30				7,94	7,94	3,18	Facet	0,1
017659	MPFW 08 03PPTL	SfZ	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1
017657	MPFW 08 03PPTL	X44				7,94	7,94	3,18	Facet	0,1
017296	MPHT 08 03PPTL-42	MP91M	◆	◆	◆	7,94	7,94	3,18	Facet	0,1
023249	MPHT 08 03PPTL-42	PfZ				7,94	7,94	3,18	Facet	0,1
015138	MPHT 08 03PPTL-42	X500	◆◆	◆◆	◆◆	7,94	7,94	3,18	Facet	0,1

## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)
◆ Unalloyed Steels	180 - 220	0,10 - 0,14
◆ Alloyed Steels	70 - 110	0,10 - 0,12
◆ Stainless Steels	120 - 140	0,10 - 0,12
◆ PH Stainless	55 - 70	0,12 - 0,20
◆ Cast Irons	140 - 280	0,10 - 0,12
◆ Aluminium & Alloys	275 - 450	0,04 - 0,12
◆ 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