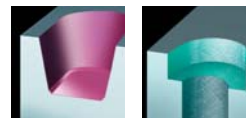


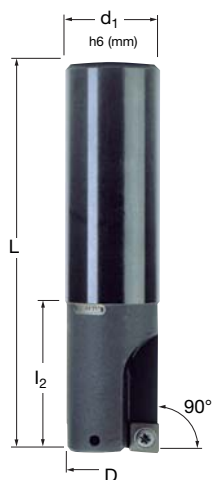


5140 VM 06

Routing /
Pocketing Cutter



5140 VM 06 Weldon Shank		Dimensions (mm)						No. of Inserts	Spares			
EDP #	Part Number	D	L	l_2	d_1	$a_{max.}$		EDP#		EDP#		
021640	5140VM 06 WA018R	18	82	32	20	5,5	2	015267	F2505TP	018488	T7	
021641	5140VM 06 WA020R	20	82	32	20	5,5	2	015267	F2505TP	018488	T7	



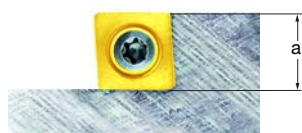
Weldon Shank



5140 VM Technical Advice

Milling Cutter Order Example: **5140VM06WA018R**
 Milling Insert Order Example: **MPFW0602PPTR SFZ**
 For complete cutting conditions refer to page: **264**

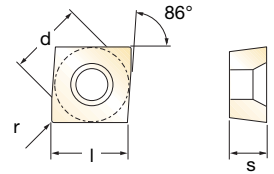
Reduce feed rate by 50% on drilling operation.



Depth of Cut (a)



Inserts for 5140 VM 06



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024927	MPEX 06 02PPFR-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
017649	MPFW 06 02PPTR	GH1				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ		◆◆◆		6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44				6,35	6,35	2,38	Facet	0,07
023247	MPHT 06 02PPER	X44				6,35	6,35	2,38	Facet	0,04
017301	MPHW 06 02PPTR	MP91M		◆		6,35	6,35	2,38	Facet	0,07
023253	MPHW 06 02PPTR	PFZ		◆		6,35	6,35	2,38	Facet	0,07
017668	MPHW 06 02PPTR	X500				6,35	6,35	2,38	Facet	0,07
017302	MPMT 06 0204EN-43	MP91M				6,35	6,35	2,38	0,4	0,04
015180	MPMT 06 0204EN-43	X500				6,35	6,35	2,38	0,4	0,04

MPEX 06_ -701

MPFW 06_

MPHT 06_

MPHW 06_

MPMT 06_ -43

MP_06 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)	Speed V _C (m/min)	Feed h _m (mm)	D.O.C. a _p (mm)
◆ Unalloyed Steels	-	-	-	220 - 260	0,07 - 0,12	0,5 - 5,5	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,07 - 0,10	0,5 - 5,5	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,07 - 0,12	0,5 - 5,5	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,07 - 0,10	0,5 - 5,5	-	-	-
◆ Aluminium & Alloys	-	-	-	400 - 750	0,04 - 0,12	0,5 - 5,5	-	-	-
◆ 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