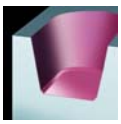
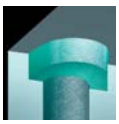
5140 VM 04

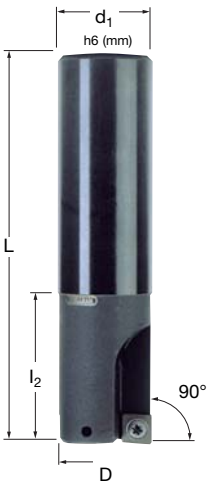
Routing / Pocketing Cutter





5140 VM 04 Weldon Shank

EDP #	Part Number	Dimensions (mm) D	L	l_2	d_1	$a_{max.}$	No. of Inserts	Spares EDP#		EDP#	
021638	**5140VM 04 WA014R**	14	75	27	16	4	2	*015059*	F2004T	*018487*	T6
021639	**5140VM 04 WA016R**	16	75	27	16	4	2	*015059*	F2004T	*018487*	T6



Weldon Shank

5140 VM Technical Advice

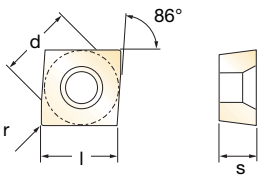
Milling Cutter Order Example: **5140VM04WA014R**
Milling Insert Order Example: **MPFW0402PPTR SFZ**
For complete cutting conditions refer to page: **264**

Reduce feed rate by 50% on drilling operation.

Depth of Cut (a)

Inserts for 5140 VM 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
017645	**MPFW 04 02PPTR**	**SF30**				4,76	4,76	2,38	Facet	0,07
015158	**MPFW 04 02PPTR**	**SFZ**		◆◆◆		4,76	4,76	2,38	Facet	0,07
017427	**MPFW 04 02PPTR**	**X44**				4,76	4,76	2,38	Facet	0,07
017666	**MPHW 04 02PPTR**	**X500**		◆		4,76	4,76	2,38	Facet	0,07



MPFW 04_

MPHW 04_

MP_04 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼ Semi-Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)	▼▼▼ Finishing Speed V_c (m/min)	Feed h_m (mm)	D.O.C. a_p (mm)
◆ Unalloyed Steels	-	-	-	220 - 260	0,07 - 0,10	0,5 - 4,0	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,07 - 0,08	0,5 - 4,0	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,07 - 0,10	0,5 - 4,0	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,07 - 0,08	0,5 - 4,0	-	-	-
◆ 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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