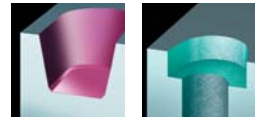


5140 VM 06

Routing /
Pocketing Cutter



5140 VM 06 Weldon Shank

EDP #	Part Number	Dimensions (inch)					No. of Inserts	Spares			
		D	L	l_2	d_1	a		EDP#	EDP#	EDP#	
014299	C5140VM06WA.750R1.25	0.750	3.300	1.250	0.750	0.216	2	015267	F2505TP	018488	T7



Weldon Shank



5140 VM Technical Advice

Milling Cutter Order Example: **C5140VM06WA.750R1.25**
 Milling Insert Order Example: **MPFW0602PPTR SFZ**
 For complete cutting conditions refer to page: **208**

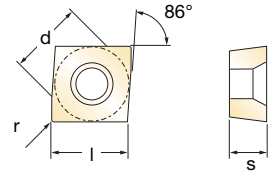
Reduce feed rate by 50% on drilling operation.



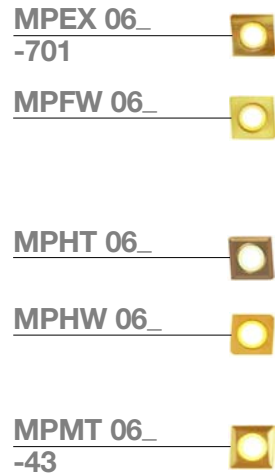
Depth of Cut (a)



Inserts for 5140 VM 06



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h_m min
024927	MPEX0602PPFR-701	GH1		◆		0.250	0.250	0.094	Facet	0.0008
017638	MPEX0602PPFR-701	SFZ				0.250	0.250	0.094	Facet	0.0008
017649	MPFW0602PPTR	GH1				0.250	0.250	0.094	Facet	0.0028
017647	MPFW0602PPTR	SF30				0.250	0.250	0.094	Facet	0.0028
014400	MPFW0602PPTR	SFZ		◆◆◆		0.250	0.250	0.094	Facet	0.0028
017648	MPFW0602PPTR	X44				0.250	0.250	0.094	Facet	0.0028
023247	MPHT0602PPER	X44				0.250	0.250	0.094	Facet	0.0016
017301	MPHW0602PPTR	MP91M				0.250	0.250	0.094	Facet	0.0028
023253	MPHW0602PPTR	PFZ		◆		0.250	0.250	0.094	Facet	0.0028
017668	MPHW0602PPTR	X500				0.250	0.250	0.094	Facet	0.0028
017302	MPMT060204EN-43	MP91M				0.250	0.250	0.094	0.016	0.0016
015180	MPMT060204EN-43	X500				0.250	0.250	0.094	0.016	0.0016



MP_06 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V_C (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	Speed V_C (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	Speed V_C (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)
◆ Unalloyed Steels	-	-	-	730 - 850	0.003 - 0.005	0.02 - 0.22	-	-	-
◆ Alloyed Steels	-	-	-	330 - 490	0.003 - 0.004	0.02 - 0.22	-	-	-
◆ Stainless Steels	-	-	-	460 - 590	0.003 - 0.005	0.02 - 0.22	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	600 - 980	0.003 - 0.004	0.02 - 0.22	-	-	-
◆ Aluminum & Alloys	-	-	-	1320 - 2460	0.002 - 0.005	0.02 - 0.22	-	-	-
◆ 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	
	P ◆	Alloyed Steels	M ◆	PH Stainless	N ◆	Aluminum & Alloys	
				S ◆	High Temp. Alloys	H ◆	Hard Materials