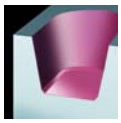
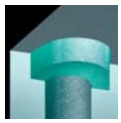
5140 VM 08

Routing / Pocketing Cutter





5140 VM 08 Weldon Shank

EDP #	Part Number	Dimensions (inch) D	L	l_2	d_1	a	No. of Inserts	Spares EDP#		EDP#	
014300	**C5140VM08WA1.00R2.30**	1.000	4.640	2.300	1.000	0.295	*a.* 1	015267	F2505TP	018488	T7
							b. 2	015062	F3006T	013214	T9

Weldon Shank

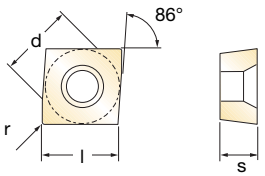
5140 VM Technical Advice

Milling Cutter Order Example: **C5140VM08WA1.00R2.30**
Milling Insert Order Example: **MPFW0602PPTR SFZ**
MPFW0803PPTR 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 08



EDP#	Part Number	Grade		Application & Material: Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	Dimensions (inch): d	l	s	r	h_m min	
024927	MPEX0602PPFR-701	GH1	b.		◆		0.250	0.250	0.094	Facet	0.0008	MPEX 06_ -701
017638	MPEX0602PPFR-701	SFZ	b.				0.250	0.250	0.094	Facet	0.0008	
017649	MPFW0602PPTR	GH1	b.				0.250	0.250	0.094	Facet	0.0028	MPFW 06_
017647	MPFW0602PPTR	SF30	b.				0.250	0.250	0.094	Facet	0.0028	
014400	MPFW0602PPTR	SFZ	b.		◆◆◆		0.250	0.250	0.094	Facet	0.0028	
017648	MPFW0602PPTR	X44	b.				0.250	0.250	0.094	Facet	0.0028	
023247	MPHT0602PPER	X44	b.				0.250	0.250	0.094	Facet	0.0016	MPHT 06_
017301	MPHW0602PPTR	MP91M	b.				0.250	0.250	0.094	Facet	0.0028	MPHW 06_
023253	MPHW0602PPTR	PFZ	b.				0.250	0.250	0.094	Facet	0.0028	
017668	MPHW0602PPTR	X500	b.		◆		0.250	0.250	0.094	Facet	0.0028	
017640	MPEX0803PPER-701	PFZ	a.				0.313	0.313	0.125	Facet	0.0008	MPEX 08_ -701
017642	MPEX0803PPFR-701	GH1	a.		◆		0.313	0.313	0.125	Facet	0.0008	
017489	MPEX0803PPFR-701	SFZ	a.				0.313	0.313	0.125	Facet	0.0008	
017655	MPFW0803PPTR	GH1	a.				0.313	0.313	0.125	Facet	0.0039	MPFW 08_
017653	MPFW0803PPTR	SF30	a.				0.313	0.313	0.125	Facet	0.0039	
014401	MPFW0803PPTR	SFZ	a.		◆◆◆		0.313	0.313	0.125	Facet	0.0039	
017654	MPFW0803PPTR	X44	a.				0.313	0.313	0.125	Facet	0.0039	
017663	MPHT0803PPER	SF30	a.				0.313	0.313	0.125	Facet	0.0016	MPHT 08_
017664	MPHT0803PPER	SFZ	a.				0.313	0.313	0.125	Facet	0.0016	
017665	MPHT0803PPFR	GH1	a.				0.313	0.313	0.125	Facet	0.0016	
017297	MPHT0803PPTR-42	MP91M	a.				0.313	0.313	0.125	Facet	0.0039	MPHT 08_ -42
023250	MPHT0803PPTR-42	PFZ	a.				0.313	0.313	0.125	Facet	0.0039	
015140	MPHT0803PPTR-42	X500	a.		◆		0.313	0.313	0.125	Facet	0.0039	
017302	MPMT060204EN-43	MP91M	b.				0.250	0.250	0.094	0.016	0.0016	MPMT 06_ -43
015180	MPMT060204EN-43	X500	b.				0.250	0.250	0.094	0.016	0.0016	

MP_08 Recommended Cutting Conditions

Material	▼ Roughing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	▼▼ Semi-Finishing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)	▼▼▼ Finishing Speed V_c (feet/min)	Feed h_m (inch)	D.O.C. a_p (inch)
◆ Unalloyed Steels	-	-	-	730 - 850	0.008 - 0.014	0.04 - 0.30	-	-	-
◆ Alloyed Steels	-	-	-	330 - 490	0.008 - 0.012	0.04 - 0.30	-	-	-
◆ Stainless Steels	-	-	-	460 - 590	0.006 - 0.010	0.04 - 0.30	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	600 - 980	0.006 - 0.010	0.04 - 0.30	-	-	-
◆ Aluminum & Alloys	-	-	-	1320 - 2460	0.004 - 0.010	0.04 - 0.30	-	-	-
◆ 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 ◆ Aluminum & Alloys	H ◆ Hard Materials

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