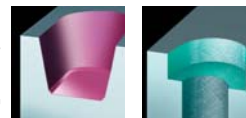




# 5140 VM 08

Routing /  
Pocketing Cutter



5140 VM 08 Weldon Shank												
EDP #	Part Number	Dimensions (mm)					No. of Inserts	Spares				
		D	L	$l_2$	$d_1$	$a_{max}$		EDP#	 EDP#	 EDP#		
021642	5140VM 08 WA025R60	25	116	60	25	7,5	a.	1	015062	F3006T	013214	T9
							b.	2	015267	F2505TP	018488	T7



Weldon Shank



## 5140 VM Technical Advice

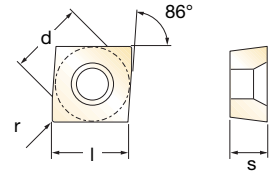
Milling Cutter Order Example: **5140VM08WA025R60**  
 Milling Insert Order Example: **MPFW0803PPTR SFZ**  
 For complete cutting conditions refer to page: **264**

Reduce feed rate by 50% on drilling operation.



Depth of Cut (a)

# Inserts for 5140 VM 08



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
024927	<b>MPEX 06 02PPFR-701</b>	<b>GH1</b> b.		◆		6,35	6,35	2,38	Facet	0,02
017638	<b>MPEX 06 02PPFR-701</b>	<b>SFZ</b> b.				6,35	6,35	2,38	Facet	0,02
017649	<b>MPFW 06 02PPTR</b>	<b>GH1</b> b.				6,35	6,35	2,38	Facet	0,07
017647	<b>MPFW 06 02PPTR</b>	<b>SF30</b> b.				6,35	6,35	2,38	Facet	0,07
014400	<b>MPFW 06 02PPTR</b>	<b>SFZ</b> b.		◆ ◆ ◆		6,35	6,35	2,38	Facet	0,07
017648	<b>MPFW 06 02PPTR</b>	<b>X44</b> b.				6,35	6,35	2,38	Facet	0,07
023247	<b>MPHT 06 02PPER</b>	<b>X44</b> b.				6,35	6,35	2,38	Facet	0,04
017301	<b>MPHW 06 02PPTR</b>	<b>MP91M</b> b.				6,35	6,35	2,38	Facet	0,07
023253	<b>MPHW 06 02PPTR</b>	<b>PFZ</b> b.				6,35	6,35	2,38	Facet	0,07
017668	<b>MPHW 06 02PPTR</b>	<b>X500</b> b.		◆		6,35	6,35	2,38	Facet	0,07
017640	<b>MPEX 08 03PPER-701</b>	<b>PFZ</b> a.				7,94	7,94	3,18	Facet	0,02
017642	<b>MPEX 08 03PPFR-701</b>	<b>GH1</b> a.		◆		7,94	7,94	3,18	Facet	0,02
017489	<b>MPEX 08 03PPFR-701</b>	<b>SFZ</b> a.				7,94	7,94	3,18	Facet	0,02
017655	<b>MPFW 08 03PPTR</b>	<b>GH1</b> a.				7,94	7,94	3,18	Facet	0,1
017653	<b>MPFW 08 03PPTR</b>	<b>SF30</b> a.				7,94	7,94	3,18	Facet	0,1
014401	<b>MPFW 08 03PPTR</b>	<b>SFZ</b> a.		◆ ◆ ◆		7,94	7,94	3,18	Facet	0,1
017654	<b>MPFW 08 03PPTR</b>	<b>X44</b> a.				7,94	7,94	3,18	Facet	0,1
017663	<b>MPHT 08 03PPER</b>	<b>SF30</b> a.				7,94	7,94	3,18	Facet	0,04
017664	<b>MPHT 08 03PPER</b>	<b>SFZ</b> a.				7,94	7,94	3,18	Facet	0,04
017665	<b>MPHT 08 03PPFR</b>	<b>GH1</b> a.				7,94	7,94	3,18	Facet	0,04
017297	<b>MPHT 08 03PPTR-42</b>	<b>MP91M</b> a.				7,94	7,94	3,18	Facet	0,1
023250	<b>MPHT 08 03PPTR-42</b>	<b>PFZ</b> a.				7,94	7,94	3,18	Facet	0,1
015140	<b>MPHT 08 03PPTR-42</b>	<b>X500</b> a.		◆		7,94	7,94	3,18	Facet	0,1
017302	<b>MPMT 06 0204EN-43</b>	<b>MP91M</b> b.				6,35	6,35	2,38	0,4	0,04
015180	<b>MPMT 06 0204EN-43</b>	<b>X500</b> b.				6,35	6,35	2,38	0,4	0,04



## MP\_08 Recommended Cutting Conditions

Material	▼ Roughing			▼▼ Semi-Finishing			▼▼▼ Finishing		
	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)	Speed V <sub>C</sub> (m/min)	Feed h <sub>m</sub> (mm)	D.O.C. a <sub>p</sub> (mm)
◆ Unalloyed Steels	-	-	-	220 - 260	0,20 - 0,35	1,0 - 7,5	-	-	-
◆ Alloyed Steels	-	-	-	100 - 150	0,20 - 0,30	1,0 - 7,5	-	-	-
◆ Stainless Steels	-	-	-	140 - 180	0,15 - 0,25	1,0 - 7,5	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	-	-	-	180 - 300	0,15 - 0,25	1,0 - 7,5	-	-	-
◆ Aluminium & Alloys	-	-	-	400 - 750	0,10 - 0,25	1,0 - 7,5	-	-	-
◆ High Temp. Alloys	-	-	-	-	-	-	-	-	-
◆ Hard Steels (52-56 HRC)	-	-	-	-	-	-	-	-	-

h<sub>m</sub> = average chip thickness

### Star Guide Key to Recommended Tools

Material Designations					
	<b>P</b> ◆ Unalloyed Steels	<b>M</b> ◆ Stainless Steels	<b>K</b> ◆ Cast Irons	<b>S</b> ◆ High Temp. Alloys	
	<b>P</b> ◆ Alloyed Steels	<b>M</b> ◆ PH Stainless	<b>N</b> ◆ Aluminium & Alloys	<b>H</b> ◆ Hard Materials	