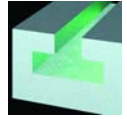
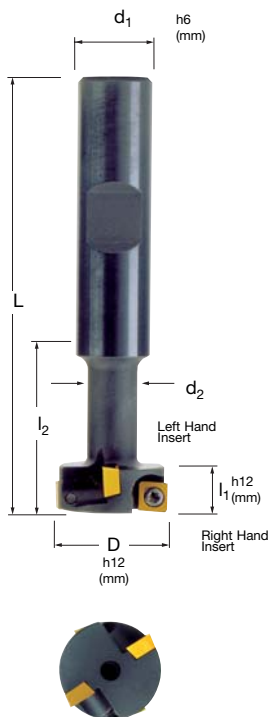


5400 VM 06 T-Slot Milling Cutter



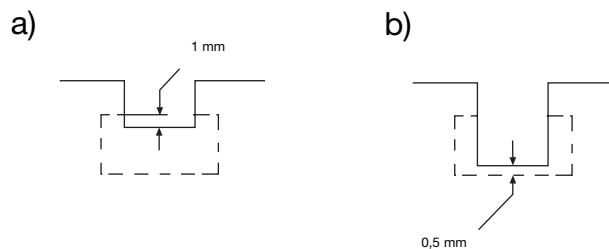
5400 VM 06 Weldon Shank

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	l ₁	l ₂	d ₁	d ₂		EDP#	EDP#	EDP#	
021664	5400VM 06 WA025R	25	83	11	35	16	12	2 x 2	015060	F2505T	018488	T7



5400 VM 06 Technical Advice

Milling Cutter Order Example: **5400VM06WA025R**
 Milling Insert Order Example: **MPHW0602PPTR MP91M**
MPHW0602PPTL MP91M
 For complete cutting conditions refer to page: **264**

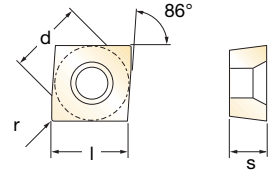


Stellram recommends the use of method a) whenever possible. Compressed air or sufficient coolant is used to ensure adequate chip evacuation.

Weldon Shank



Inserts for 5400 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
024926	MPEX 06 02PPFL-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
017639	MPEX 06 02PPFL-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
017652	MPFW 06 02PPTL	GH1				6,35	6,35	2,38	Facet	0,07
017647	MPFW 06 02PPTR	SF30				6,35	6,35	2,38	Facet	0,07
017650	MPFW 06 02PPTL	SF30				6,35	6,35	2,38	Facet	0,07
014400	MPFW 06 02PPTR	SFZ	◆	◆		6,35	6,35	2,38	Facet	0,07
015159	MPFW 06 02PPTL	SFZ	◆	◆		6,35	6,35	2,38	Facet	0,07
017648	MPFW 06 02PPTR	X44	◆			6,35	6,35	2,38	Facet	0,07
017651	MPFW 06 02PPTL	X44	◆			6,35	6,35	2,38	Facet	0,07
017301	MPHW 06 02PPTR	MP91M				6,35	6,35	2,38	Facet	0,07
017300	MPHW 06 02PPTL	MP91M				6,35	6,35	2,38	Facet	0,07
017669	MPHW 06 02PPTL	X500				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_

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	180 - 220	0,10 - 0,15	-	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,08 - 0,12	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,08 - 0,12	-	-	-	-	-	-	-
◆ Aluminium & Alloys	275 - 450	0,06 - 0,10	-	-	-	-	-	-	-
◆ 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	