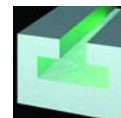


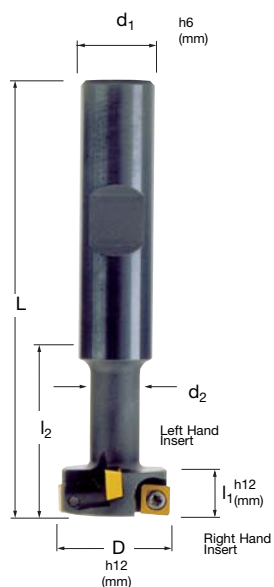


5400 VM 04 T-Slot Milling Cutter



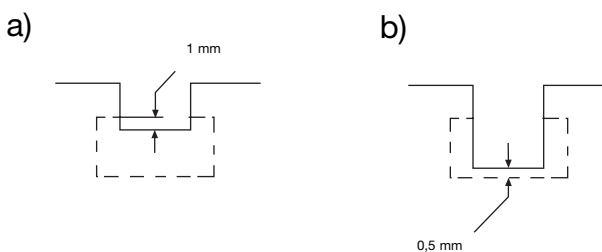
5400 VM 04 Weldon Shank

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	l_1	l_2	d_1	d_2		EDP#	 EDP#	 EDP#	
021662	5400VM 04 WA018R	18	70	8	25	12	8	2 x 2	015059	F2004T	018487	T6
021663	5400VM 04 WA021R	21	75	9	30	12	10	2 x 2	015059	F2004T	018487	T6



5400 VM 04 Technical Advice

Milling Cutter Order Example: **5400VM04WA021R**
 Milling Insert Order Example: **MPFW0402PPTR X44**
MPFW0402PPTL X44
 For complete cutting conditions refer to page: **264**

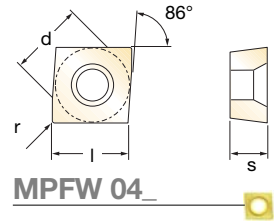


Stellram recommends the use of method a) whenever possible. Compressed air or sufficient coolant is used to ensure adequate chip evacuation.

Weldon Shank



Inserts for 5400 VM 04



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h _m min
024148	MPFW 04 02PPTR	GH1				4,76	4,76	2,38	Facet	0,07
025799	MPFW 04 02PPTL	GH1				4,76	4,76	2,38	Facet	0,07
017645	MPFW 04 02PPTR	SF30				4,76	4,76	2,38	Facet	0,07
017646	MPFW 04 02PPTL	SF30				4,76	4,76	2,38	Facet	0,07
015158	MPFW 04 02PPTR	SFZ	◆◆			4,76	4,76	2,38	Facet	0,07
015157	MPFW 04 02PPTL	SFZ	◆◆			4,76	4,76	2,38	Facet	0,07
017427	MPFW 04 02PPTR	X44	◆			4,76	4,76	2,38	Facet	0,07
017426	MPFW 04 02PPTL	X44	◆			4,76	4,76	2,38	Facet	0,07
017666	MPHW 04 02PPTR	X500				4,76	4,76	2,38	Facet	0,07
017687	MPHW 04 02PPTL	X500				4,76	4,76	2,38	Facet	0,07

MPHW 04_

MP_04 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	0,08 - 0,12	-	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,07 - 0,10	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,07 - 0,10	-	-	-	-	-	-	-
◆ 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