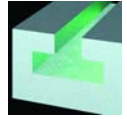
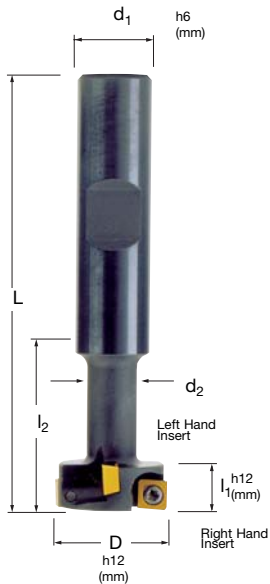


# 5400 VM 08 T-Slot Milling Cutter



## 5400 VM 08 Weldon Shank

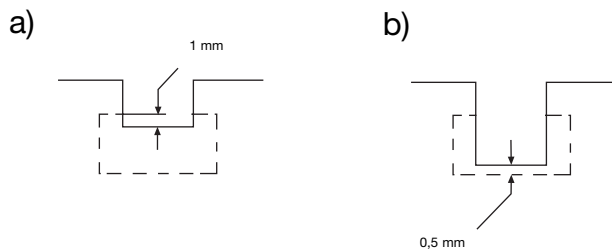
EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	$l_1$	$l_2$	$d_1$	$d_2$		EDP#	EDP#	EDP#	
018313	5400VM 08 WA032R	32	91	14	43	16	15	2 x 2	015063	F3008T	013214	T9



Weldon Shank

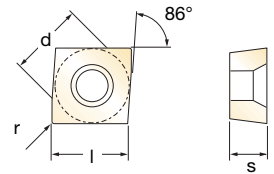
## 5400 VM 08 Technical Advice

Milling Cutter Order Example: **5400VM08WA032R**  
 Milling Insert Order Example: **MPFW0803PPTR SFZ**  
**MPFW0803PPTL SFZ**  
 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.

## Inserts for 5400 VM 08



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	$h_m$ min
017642	MPEX 08 03PPFR-701	GH1	▼	▼▼	▼▼▼	7,94	7,94	3,18	Facet	0,02
024928	MPEX 08 03PPFL-701	GH1	◆			7,94	7,94	3,18	Facet	0,02
017489	MPEX 08 03PPFR-701	SFZ				7,94	7,94	3,18	Facet	0,02
017490	MPEX 08 03PPFL-701	SFZ				7,94	7,94	3,18	Facet	0,02
017655	MPFW 08 03PPTR	GH1				7,94	7,94	3,18	Facet	0,1
017658	MPFW 08 03PPTL	GH1				7,94	7,94	3,18	Facet	0,1
017653	MPFW 08 03PPTR	SF30				7,94	7,94	3,18	Facet	0,1
017656	MPFW 08 03PPTL	SF30				7,94	7,94	3,18	Facet	0,1
014401	MPFW 08 03PPTR	SFZ	◆	◆		7,94	7,94	3,18	Facet	0,1
017659	MPFW 08 03PPTL	SFZ	◆	◆		7,94	7,94	3,18	Facet	0,1
017654	MPFW 08 03PPTR	X44	◆			7,94	7,94	3,18	Facet	0,1
017657	MPFW 08 03PPTL	X44	◆			7,94	7,94	3,18	Facet	0,1
017297	MPHT 08 03PPTR-42	MP91M				7,94	7,94	3,18	Facet	0,1
017296	MPHT 08 03PPTL-42	MP91M				7,94	7,94	3,18	Facet	0,1
023250	MPHT 08 03PPTR-42	PFZ				7,94	7,94	3,18	Facet	0,1
023249	MPHT 08 03PPTL-42	PFZ				7,94	7,94	3,18	Facet	0,1
015140	MPHT 08 03PPTR-42	X500				7,94	7,94	3,18	Facet	0,1
015138	MPHT 08 03PPTL-42	X500				7,94	7,94	3,18	Facet	0,1
017670	MPMW 08 0304TN	SF30				7,94	7,94	3,18	0,4	0,1

MPEX 08\_ -701

MPFW 08\_

MPHT 08\_ -42

MPMW 08\_

## MP\_08 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	0,12 - 0,18	-	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,10 - 0,15	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,10 - 0,15	-	-	-	-	-	-	-
◆ 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