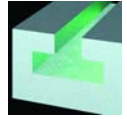
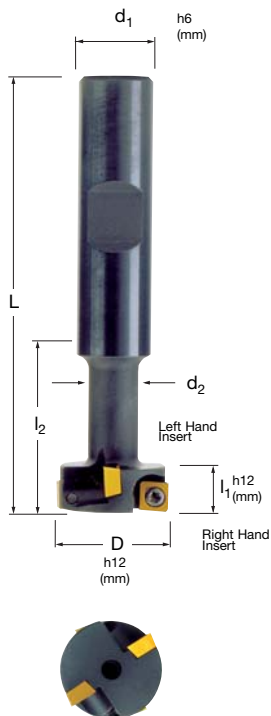


5400 VM 11 T-Slot Milling Cutter



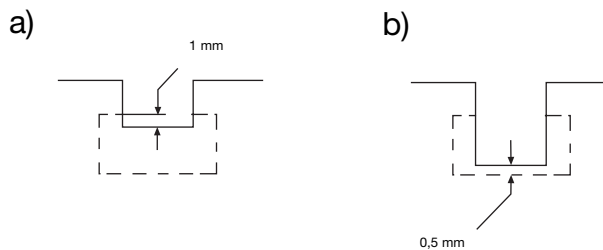
5400 VM 11 Weldon Shank

EDP #	Part Number	Dimensions (mm)						No. of Inserts	Spares			
		D	L	l ₁	l ₂	d ₁	d ₂		EDP#	EDP#	EDP#	
021665	5400VM 11 WA040R	40	106	18	50	25	19	2 x 2	015062	D4010T	015240	T15



5400 VM 11 Technical Advice

Milling Cutter Order Example: **5400VM11WA040R**
 Milling Insert Order Example: **MPFW1104PPTR X44**
MPFW1104PPTL X44
 For complete cutting conditions refer to page: **264**

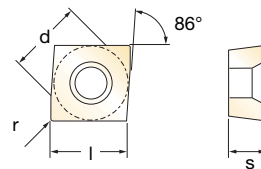


Stellram recommends the use of method a) whenever possible. Compressed air or sufficient coolant is used to ensure adequate chip evacuation.

Weldon Shank



Inserts for 5400 VM 11



EDP#	Part Number	Grade	Application & Material			Dimensions (mm)				
			Roughing	Semi-Finishing	Finishing	d	l	s	r	h _m min
017643	MPEX 11 04PPFR-701	GH1	▼	▼▼	▼▼▼	11,11	11,11	4,76	Facet	0,02
017644	MPEX 11 04PPFL-701	GH1	◆			11,11	11,11	4,76	Facet	0,02



017440	MPFW 11 04PPTR	GH1				11,11	11,11	4,76	Facet	0,15
017439	MPFW 11 04PPTL	GH1				11,11	11,11	4,76	Facet	0,15
018182	MPFW 11 04PPTR	SF30				11,11	11,11	4,76	Facet	0,15
018181	MPFW 11 04PPTL	SF30				11,11	11,11	4,76	Facet	0,15
017660	MPFW 11 04PPTR	SFZ	◆	◆		11,11	11,11	4,76	Facet	0,15
017662	MPFW 11 04PPTL	SFZ	◆	◆		11,11	11,11	4,76	Facet	0,15
017777	MPFW 11 04PPTR	X44	◆			11,11	11,11	4,76	Facet	0,15
017336	MPFW 11 04PPTL	X44	◆			11,11	11,11	4,76	Facet	0,15



017299	MPHT 11 04PPTR-42	MP91M				11,11	11,11	4,76	Facet	0,1
017298	MPHT 11 04PPTL-42	MP91M				11,11	11,11	4,76	Facet	0,1
015142	MPHT 11 04PPTR-42	X500				11,11	11,11	4,76	Facet	0,1
015141	MPHT 11 04PPTL-42	X500				11,11	11,11	4,76	Facet	0,1



MP_11 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	0,15 - 0,20	-	-	-	-	-	-	-
◆ Alloyed Steels	70 - 110	0,15 - 0,18	-	-	-	-	-	-	-
◆ Stainless Steels	-	-	-	-	-	-	-	-	-
◆ PH Stainless	-	-	-	-	-	-	-	-	-
◆ Cast Irons	140 - 280	0,15 - 0,18	-	-	-	-	-	-	-
◆ 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								
	◆	Unalloyed Steels	◆	Stainless Steels	◆	Cast Irons	◆	High Temp. Alloys
	◆	Alloyed Steels	◆	PH Stainless	◆	Aluminium & Alloys	◆	Hard Materials