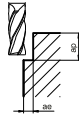
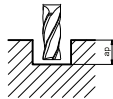


S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner
*	36100	105E.4.0300.0600.R0020.0080.0280.0120.00.S03B1A02.01	3	3	2,8	60	8	12	R 0.20
*	36102	105E.4.0400.0600.R0050.0110.0380.0150.00.S04B1A02.01	4	4	3,8	60	11	15	R 0.50
*	36104	105E.4.0600.0580.R0100.0120.0550.0240.00.S06B1A02.01	6	6	5,5	58	12	24	R 1.00
*	36106	105E.4.0800.0640.R0100.0120.0750.0240.00.S08B1A02.01	8	8	7,5	64	12	24	R 1.00
*	36108	105E.4.1000.0730.R0100.0150.0960.0300.00.S10B1A02.01	10	10	9,6	73	15	30	R 1.00
*	36110	105E.4.1200.0820.R0100.0250.1170.0370.00.S12B1A02.01	12	12	11,7	82	25	37	R 1.00
*	36112	105E.4.1400.0820.R0100.0320.1360.0390.00.S14B1A02.01	14	14	13,6	82	32	39	R 1.00
*	36114	105E.4.1600.0930.R0100.0320.1555.0500.00.S16B1A02.01	16	16	15,55	93	32	50	R 1.00
*	36116	105E.4.2000.1050.R0100.0420.1960.0590.00.S20B1A02.01	20	20	19,6	105	42	59	R 1.00

Cutting Parameters

Material	Slotting ap=0.50	Shoulder Milling ap=1.50 / ae=0.30 - 0.200	Finish Milling ap=1.50 / ae=0.20 - 0.100
	Vc (m/min)	Vc (m/min)	Vc (m/min)



Steel	Unalloyed Steel	95-125	150-180	180-210
	Steel	90-120	140-170	170-200
	Reclamation steel	80-110	130-160	160-190
	Cold Work Tool Steel	70-90	120-150	150-180
Stainless Steel	Hot Work Tool Steel	60-80	120-150	150-180
	AISI 304 - 416 - 420	70-90	80-110	110-150
	AISI 316 - 440	65-85	70-100	100-130
	17-4 PH 15-5 PH	60-80	70-100	100-130
Cast Iron	Chrome-Cobalt alloy	50-70	60-90	90-120
	Gray cast	100-130	250-280	280-330
	Alloyed cast	70-100	150-190	190-240
	Precision cast	60-90	130-160	160-210
Hardened Steel	>54 HRC	40-60	50-70	70-90

Feed Per Tooth (mm/tooth)

Ø	ap=1.50	ap=10	ap=0.500	ae=0.350	ae=0.300
3	0.007	0.032	0.037	0.039	0.041
4	0.012	0.039	0.043	0.045	0.047
5	0.018	0.042	0.044	0.046	0.048
6	0.023	0.049	0.053	0.055	0.057
8	0.028	0.056	0.060	0.063	0.066
10	0.036	0.064	0.068	0.071	0.074
12	0.045	0.069	0.074	0.077	0.080
14	0.054	0.074	0.079	0.083	0.086
16	0.065	0.079	0.084	0.089	0.093
18	0.076	0.082	0.088	0.093	0.097
20	0.087	0.087	0.095	0.100	0.105
25	0.115	0.092	0.105	0.110	0.119

ECO⁺PLUSEVO
105General Purpose
Corner Radius
Endmill

Z4

≤55
HRC

+TiSiN

FORM
HA DIN
6535

Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	●

● Recommended ● Acceptable ○ Not Recommended

*Marked products can be delivered
quickly from stock.