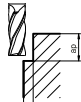
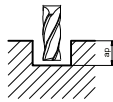


S	Order No	Code	d1h9	d2h6	d3	L1	L2	L3	Corner
*	37100	106E.4.0600.1000.R0100.0120.0580.0240.00.S06B1A02.01	6	6	5,8	100	12	24	R 1.00
*	37102	106E.4.0800.1000.R0100.0160.0780.0320.00.S08B1A02.01	8	8	7,8	100	16	32	R 1.00
*	37104	106E.4.1000.1000.R0100.0200.0970.0400.00.S10B1A02.01	10	10	9,7	100	20	40	R 1.00
*	37106	106E.4.1200.1100.R0100.0250.1170.0500.00.S12B1A02.01	12	12	11,7	110	25	50	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	180-210	210-230
	Steel	90-120	180-210	210-230
	Reclamation steel	80-110	160-190	190-120
	Cold Work Tool Steel	70-90	150-180	170-200
	Hot Work Tool Steel	60-80	140-170	160-190
Stainless Steel	Gray cast	100-130	250-280	280-330
	Alloyed cast	70-100	150-190	190-240
	Precision cast	60-90	130-160	160-210
	<54 hrc	50-70	70-90	75-90
Iron	>54 hrc	40-60	50-70	70-90

Feed Per Tooth (mm/tooth)

Ø	ap=0.0500	ae=0.100	ae=0.300	ae=0.200	ae=0.150	ae=0.100
3	0.005	0.006	0.031	0.036	0.038	0.040
4	0.008	0.011	0.038	0.042	0.044	0.046
5	0.013	0.017	0.041	0.043	0.045	0.047
6	0.016	0.022	0.048	0.052	0.054	0.056
8	0.021	0.027	0.054	0.058	0.061	0.064
10	0.029	0.035	0.062	0.066	0.069	0.072
12	0.038	0.043	0.067	0.072	0.075	0.079
14	0.047	0.052	0.072	0.077	0.080	0.083
16	0.056	0.063	0.076	0.081	0.086	0.090
18	0.068	0.073	0.079	0.085	0.089	0.095
20	0.078	0.084	0.084	0.092	0.097	0.098
25	0.105	0.110	0.088	0.100	0.110	0.110

ECO+PLUS

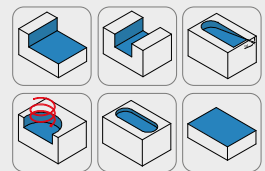
EVO
106General Purpose
Corner Radius
Endmill

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