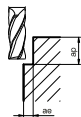


S	Order No	Code	d1h9	d2h6	L1	L2	Corner
	31100	KRSF.4.0150.0500.R0020.0030.0000.0000.00.S04B1A04.01	1,5	4	50	3	R 0.20
	31102	KRSF.4.0150.0500.R0030.0030.0000.0000.00.S04B1A04.01	1,5	4	50	3	R 0.30
	31104	KRSF.4.0150.0500.R0050.0030.0000.0000.00.S04B1A04.01	1,5	4	50	3	R 0.50
	31106	KRSF.4.0200.0500.R0020.0040.0000.0000.00.S04B1A04.01	2	4	50	4	R 0.20
	31108	KRSF.4.0200.0500.R0050.0040.0000.0000.00.S04B1A04.01	2	4	50	4	R 0.50
*	31110	KRSF.4.0300.0500.R0050.0060.0000.0000.00.S03B1A02.01	3	3	50	6	R 0.50
	31112	KRSF.4.0300.0500.R0020.0060.0000.0000.00.S04B1A02.01	3	4	50	6	R 0.20
*	31114	KRSF.4.0300.0500.R0100.0060.0000.0000.00.S03B1A02.01	3	3	50	6	R 1.00
	31116	KRSF.4.0400.0500.R0020.0080.0000.0000.00.S04B1A02.01	4	4	50	8	R 0.20
*	31118	KRSF.4.0400.0500.R0050.0080.0000.0000.00.S04B1A02.01	4	4	50	8	R 0.50
*	31120	KRSF.4.0400.0500.R0100.0080.0000.0000.00.S04B1A02.01	4	4	50	8	R 1.00
*	31122	KRSF.4.0500.0510.R0050.0110.0000.0000.00.S05B1A02.01	5	5	51	11	R 0.50
*	31124	KRSF.4.0500.0510.R0100.0110.0000.0000.00.S05B1A02.01	5	5	51	11	R 1.00
	31126	KRSF.4.0600.0580.R0020.0120.0000.0000.00.S06B1A02.01	6	6	58	12	R 0.20
*	31128	KRSF.4.0600.0580.R0050.0120.0000.0000.00.S06B1A02.01	6	6	58	12	R 0.50
*	31130	KRSF.4.0600.0580.R0100.0120.0000.0000.00.S06B1A02.01	6	6	58	12	R 1.00
*	31132	KRSF.4.0800.0640.R0050.0200.0000.0000.00.S08B1A02.01	8	8	64	20	R 0.50
*	31134	KRSF.4.0800.0640.R0100.0200.0000.0000.00.S08B1A02.01	8	8	64	20	R 1.00
*	31136	KRSF.4.1000.0730.R0050.0210.0000.0000.00.S10B1A02.01	10	10	73	21	R 0.50
*	31138	KRSF.4.1000.0730.R0100.0210.0000.0000.00.S10B1A02.01	10	10	73	21	R 1.00
*	31140	KRSF.4.1200.0820.R0050.0250.0000.0000.00.S12B1A02.01	12	12	82	25	R 0.50
*	31142	KRSF.4.1200.0820.R0100.0250.0000.0000.00.S12B1A02.01	12	12	82	25	R 1.00
*	31144	KRSF.4.0200.0500.R0050.0040.0000.0000.00.S04B1A04.02	2	4	50	4	R 0.5

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
	Tempered 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 Iron	100-130	250-280	280-330
	Alloyed Cast Iron	70-100	150-190	190-240
	Precision Cast Iron	60-90	130-160	160-210

Feed Per Tooth (mm/tooth)

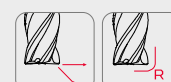
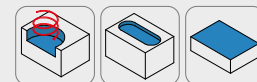
Ø	ap=1.50	ap=10	ap=0.500	ae=0.350	ae=0.300
3	0.007	0.032	0.037	0.039	0.041
4	0.012	0.039	0.043	0.045	0.047
5	0.018	0.042	0.044	0.046	0.048
6	0.023	0.049	0.053	0.055	0.057
8	0.028	0.056	0.060	0.063	0.066
10	0.036	0.064	0.068	0.071	0.074
12	0.045	0.069	0.074	0.077	0.080

ECO+PLUS

KRSF

General Purpose
Corner Radius
Endmill

Z4



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

● Recommended ● Acceptable ○ Not Recommended