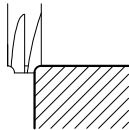




S	Order No	Code	d1h11	d2h6	l1	l2	Corner	Z
	42100	MCV.3.0450.0580.R0050.0070.0000.0000.00.S06A1A01.01	4,5	6	58	7	R 0.50	3
	42102	MCV.3.0450.0580.R0075.0070.0000.0000.00.S06A1A01.01	4,5	6	58	7	R 0.75	3
	42104	MCV.4.0600.0640.R0100.0100.0000.0000.00.S08A1A01.01	6	8	64	10	R 1.00	4
	42106	MCV.4.0500.0640.R0150.0100.0000.0000.00.S08A1A01.01	5	8	64	10	R 1.50	4
	42108	MCV.4.0550.0730.R0200.0120.0000.0000.00.S10A1A01.01	5,5	10	73	12	R 2.00	4
	42110	MCV.4.0350.0730.R0250.0120.0000.0000.00.S10A1A01.01	3,5	10	73	12	R 2.50	4
	42112	MCV.4.0350.0820.R0300.0140.0000.0000.00.S12A1A01.01	3,5	12	82	14	R 3.00	4
	42114	MCV.4.0550.0830.R0400.0160.0000.0000.00.S14A1A01.01	5,5	14	83	16	R 4.00	4
	42116	MCV.4.0600.0930.R0500.0200.0000.0000.00.S16A1A01.01	6	16	93	20	R 5.00	4
	42118	MCV.4.0800.1050.R0600.0200.0000.0000.00.S20A1A01.01	8	20	105	20	R 6.00	4

Cutting Parameters	
Material	Quarter Circle
	Vc (m/min)



Feed Per Tooth (mm/tooth)	
Ø	ae=0,1xØ ap=0,1xØ
4	0,05-0,11
6	0,06-0,15
8	0,08-0,2
10	0,1-0,26
12	0,1-0,26
14	0,1-0,26
16	0,12-0,26
20	0,16-0,44

Steel	Unalloyed Steel	280-320
	Steel	220-250
	Tempered Steel	190-220
	Cold Work Tool Steel	100-130
	Hot Work Tool Steel	100-130
Stainless Steel	AISI 304 - 416 - 420	80-110
	AISI 316 - 440	80-110
	17-4 PH 15-5 PH	60-90
	Chrome-Cobalt Alloy	60-90
	Duplex F51	50-70
Cast Iron	Super Duplex F55	50-70
	Gray Cast Iron	200-240
	Alloyed Cast Iron	200-240
	Precision Cast Iron	180-215
	Aluminum Alloys	230-370
Non Ferrous Material	Copper Alloys	650-680
	Iron-Based Super Alloys	40-50
	Nickel-Based Super Alloys	40-50
Titanium	Titanium-Based Super Alloys	70-90

ECO⁺PLUS

MCV

Edge Preparation



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.

MCV Eco-Plus