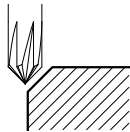


S	Order No	Code	d1h6	d2h6	l1	l2	α	Z
*	39100	MCX.4.0400.0500.A090.0100.0000.0000.00.S04A1A01.01	4	4	50	10	90	4
*	39102	MCX.4.0600.0580.A090.0120.0000.0000.00.S06A1A01.01	6	6	58	12	90	4
*	39104	MCX.5.0800.0640.A090.0150.0000.0000.00.S08A1A01.01	8	8	64	15	90	5
*	39106	MCX.6.1000.0730.A090.0140.0000.0000.00.S10A1A01.01	10	10	73	14	90	6
*	39108	MCX.6.1200.0820.A090.0140.0000.0000.00.S12A1A01.01	12	12	82	14	90	6

Cutting Parameters	
Material	Quarter Circle
	Vc (m/min)



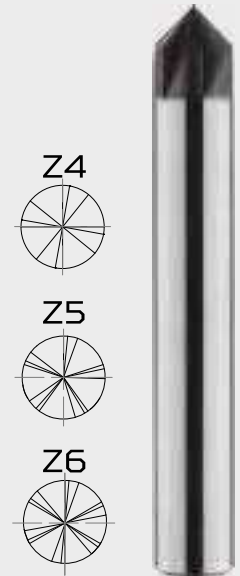
Feed Per Tooth (mm/tooth)	
ϕ	$a_e=0,1 \times \phi$ $a_p=0,1 \times \phi$
4	0,05-0,11
6	0,06-0,15
8	0,08-0,2
10	0,1-0,26
12	0,1-0,26
14	0,1-0,26
16	0,12-0,26
20	0,16-0,44

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	Copper Alloys	650-680
	Iron-Based Super Alloys	40-50
	Nickel-Based Super Alloys	40-50
	Titanium-Based Super Alloys	70-90

ECO+PLUS

MCX

Chamfering Endmill



α
90°

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

● Recommended ● Acceptable ○ Not Recommended