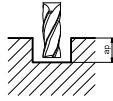
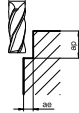


S	Order No	Code	d1h9	d2h6	l1	l2	Corner
	35100	104E.4.0300.0750.C0020.0150.0000.0000.00.S03B1A02.01	3	3	75	15	Ch 0.20
	35102	104E.4.0400.0750.C0020.0200.0000.0000.00.S04B1A02.01	4	4	75	20	Ch 0.20
	35104	104E.4.0500.0750.C0020.0200.0000.0000.00.S05B1A02.01	5	5	75	20	Ch 0.20
	35106	104E.4.0600.1000.C0020.0300.0000.0000.00.S06B1A02.01	6	6	100	30	Ch 0.20
	35108	104E.4.0800.1000.C0020.0350.0000.0000.00.S08B1A02.01	8	8	100	35	Ch 0.20
	35110	104E.4.1000.1100.C0020.0400.0000.0000.00.S10B1A02.01	10	10	110	40	Ch 0.20
	35112	104E.4.1200.1100.C0020.0450.0000.0000.00.S12B1A02.01	12	12	110	45	Ch 0.20
	35114	104E.4.1600.1000.C0020.0450.0000.0000.00.S16B1A02.01	16	16	100	45	Ch 0.20
	35116	104E.4.2000.1500.C0020.0750.0000.0000.00.S20B1A02.01	20	20	150	75	Ch 0.20

Cutting Parameters

Material	Slotting ap=0.5 - 0.10	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
	Tempered 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
Cast Iron	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	50-70	70-90	75-90
	>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

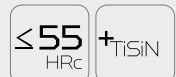
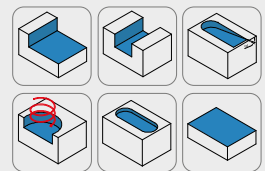
ECO+PLUS

EVO

104

General Purpose
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

104 EVO Eco-Plus