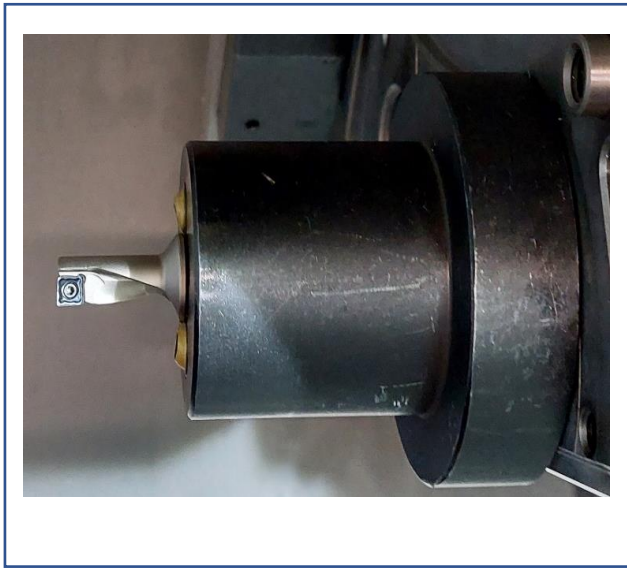
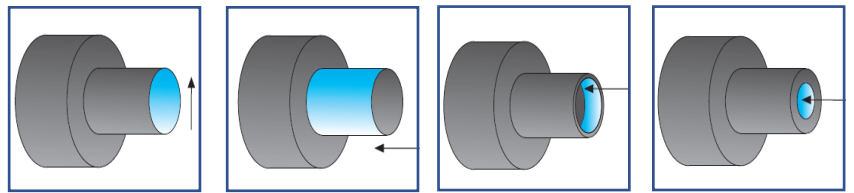


## ECO-CUTLINE | MULTI-OPERATION TOOL



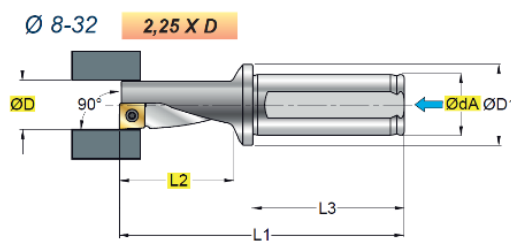
### Product Application

- ECO-CUTLINE: polyvalent tool for turning & drilling operations:
  - Face turning
  - External turning
  - Internal turning
  - Drilling



### Features & Benefit

- One tool for multi-operation to reduce by 30% machining time!
- 100% compatibility with direct competitors (body, insert & spare parts)!
- For all industries!
- Large range of inserts for Steel, Non-Ferrous materials & Stainless Steel!
- Inserts with 2 cutting edges!



- Torx screw to maximize stability, safety & efficiency
- Optimized flute angle to evacuate chips
- Through coolant holes to reduce heat
- Plane on the shank to ease the tool / machine connection



For Aluminium / Non ferrous material



For Stainless Steel



For Steel

## ECO-CUTLINE | MULTI-OPERATION TOOL

### ➤ ECO-CUTLINE TOOL HOLDER FOR MULTITURNING

RUBIX CODE	EAN	DESCRIPTION*	ØD (DIAMETER) mm	ØdA (SHANK DIAMETER) mm	ØD1 mm (RING)	L1 (TOTAL LENGTH) mm	L2 (CUTTING LENGTH) mm	L3 (SHANK LENGTH) mm	WEIGHT (Kg)	PACKAGING	SCREW CODE	INSERT
891098	3660338437533	REC 08-225.04L D8	8,0	10,0	15,0	60,0	18,0	24,0	0,03	1	891152	0401...L
891099	3660338437540	REC 08-225.04R D8	8,0	10,0	15,0	60,0	18,0	24,0	0,03	1	891152	0401...
891100	3660338437557	REC 10-225.05L D10	10,0	12,0	18,0	69,5	22,5	30,0	0,05	1	891153	0502..
891101	3660338437564	REC 10-225.05R D10	10,0	12,0	18,0	69,5	22,5	30,0	0,05	1	891153	0502..
891102	3660338437571	REC 12-225.06L D12	12,0	16,0	22,0	78,0	27,0	36,0	0,09	1	891154	0602..
891103	3660338437588	REC 12-225.06R D12	12,0	16,0	22,0	78,0	27,0	36,0	0,09	1	891154	0602..
891104	3660338437595	REC 14-225.07L D14	14,0	16,0	23,0	83,5	31,5	42,0	0,10	1	891155	0703..
891105	3660338437601	REC 14-225.07R D14	14,0	16,0	23,0	83,5	31,5	42,0	0,10	1	891155	0703..
891106	3660338437618	REC 16-225.08L D16	16,0	20,0	28,0	94,0	36,0	48,0	0,17	1	891156	0803..
891107	3660338437625	REC 16-225.08R D16	16,0	20,0	28,0	94,0	36,0	48,0	0,17	1	891156	0803..
891108	3660338437632	REC 18-225.09L D18	18,0	25,0	36,0	109,5	40,5	58,0	0,30	1	891156	09T3..
891109	3660338437649	REC 18-225.09R D18	18,0	25,0	36,0	109,5	40,5	58,0	0,30	1	891156	09T3..
891110	3660338437656	REC 20-225.10L D20	20,0	25,0	35,0	110,0	45,0	60,0	0,30	1	891157	10T3..
891111	3660338437663	REC 20-225.10R D20	20,0	25,0	35,0	110,0	45,0	60,0	0,30	1	891157	10T3..
891112	3660338437670	REC 25-225.13L D25	25,0	32,0	44,0	128,8	56,3	75,0	0,56	1	891158	1304..
891113	3660338437687	REC 25-225.13R D25	25,0	32,0	44,0	128,8	56,3	75,0	0,56	1	891158	1304..
891114	3660338437694	REC 32-225.17L D32	32,0	40,0	54,0	158,0	72,0	96,0	1,07	1	891158	1705..
891115	3660338437700	REC 32-225.17R D32	32,0	40,0	54,0	158,0	72,0	96,0	1,07	1	891158	1705..

\* R for Right-Hand tool-holder / L for Left-Hand tool-holder

### ➤ ECO-CUTLINE SPARE PARTS (screw to hold insert on tool-holder)

RUBIX CODE	EAN	DESCRIPTION	MOQ	TOOL HOLDER	TORQUE Nm
891152	3660338438035	SCREW FOR D8	1	REC 08... R/L	0,4 / 0,5
891153	3660338438042	SCREW FOR D10	1	REC 10... R/L	0,5 / 0,6
891154	3660338438059	SCREW FOR D12	1	REC 12... R/L	0,9 / 1,0
891155	3660338438066	SCREW FOR D14	1	REC 14... R/L	1,0 / 1,2
891156	3660338438073	SCREW FOR D16 - D18	1	REC 16/18... R/L	1,2 / 1,5
891157	3660338438080	SCREW FOR D20	1	REC 20... R/L	3,0 / 3,5
891158	3660338438097	SCREW FOR D25 - D32	1	REC 25/32... R/L	4,0 / 5,0

## ECO-CUTLINE | MULTI-OPERATION TOOL

### ➤ ECO-CUTLINE INSERTS

RUBIX CODE	EAN	DESCRIPTION	PACKAGING	TOOL HOLDER*	MATERIAL APPLICATION	CUTLINE GRADE	CUTTING EDGE LENGTH (MM)	RADIUS (MM)	THICKNESS (MM)	CUTTING ANGLE (DEGREE)
891117	3660338437717	XCGT 040104FR-TF37P CU15	10	REC 08-225.04R	ALUMINIUM	CU15	4	0,4	1,80	88
891118	3660338437724	XCGT 050204FN-TF37P CU15	10	REC 10-225.05R/L			5	0,4	2,10	88
891119	3660338437731	XCGT 060204FN-TF37P CU15	10	REC 12-225.06R/L			6	0,4	2,38	88
891120	3660338437748	XCGT 070304FN-TF37P CU15	10	REC 14-225.07R/L			7	0,4	3,18	88
891121	3660338437755	XCGT 080304FN-TF37P CU15	10	REC 16-225.08R/L			8	0,4	3,18	88
891122	3660338437762	XCGT 09T304FN-TF37P CU15	10	REC 18-225.09R/L			9	0,4	3,97	88
891123	3660338437779	XCGT 10T304FN-TF37P CU15	10	REC 20-225.10R/L			10	0,4	3,97	88
891124	3660338437786	XCGT 130408FN-TF37P CU15	10	REC 25-225.13R/L			13	0,8	4,76	88
891125	3660338437793	XCGT 170508FN-TF37P CU15	10	REC 32-225.17R/L			17	0,8	5,56	88
891127	3660338437809	XCGT 040104ER-TF69 CU41	10	REC 08-225.04R	STAINLESS STEEL	CU41	4	0,4	1,80	88
891128	3660338437816	XCGT 050204EN-TF69 CU41	10	REC 10-225.05R/L			5	0,4	2,10	88
891129	3660338437823	XCGT 060204EN-TF69 CU41	10	REC 12-225.06R/L			6	0,4	2,38	88
891130	3660338437830	XCGT 070304EN-TF69 CU41	10	REC 14-225.07R/L			7	0,4	3,18	88
891131	3660338437847	XCGT 080304EN-TF69 CU41	10	REC 16-225.08R/L			8	0,4	3,18	88
891132	3660338437854	XCGT 09T304EN-TF69 CU41	10	REC 18-225.09R/L			9	0,4	3,97	88
891133	3660338437861	XCGT 10T304EN-TF69 CU41	10	REC 20-225.10R/L			10	0,4	3,97	88
891134	3660338437878	XCGT 130408EN-TF69 CU41	10	REC 25-225.13R/L			13	0,8	4,76	88
891135	3660338437885	XCGT 170508EN-TF69 CU41	10	REC 32-225.17R/L			17	0,8	5,56	88
891137	3660338437892	XCNT 040102ER-TF18 CU30	10	REC 08-225.04R	STEEL	CU30	4	0,2	1,80	88
891138	3660338437908	XCNT 040104ER-TF18 CU30	10	REC 08-225.04R			4	0,4	1,80	88
891139	3660338437915	XCNT 050202EN-TF18 CU30	10	REC 10-225.05R/L			5	0,2	2,10	88
891140	3660338437922	XCNT 050204EN-TF18 CU30	10	REC 10-225.05R/L			5	0,4	2,10	88
891141	3660338437939	XCNT 060202EN-TF18 CU30	10	REC 12-225.06R/L			6	0,2	2,38	88
891142	3660338437946	XCNT 060204EN-TF18 CU30	10	REC 12-225.06R/L			6	0,4	2,38	88
891143	3660338437953	XCNT 070304EN-TF18 CU30	10	REC 14-225.07R/L			7	0,4	3,18	88
891144	3660338437960	XCNT 080304EN-TF18 CU30	10	REC 16-225.08R/L			8	0,4	3,18	88
891145	3660338437977	XCNT 09T304EN-TF18 CU30	10	REC 18-225.09R/L			9	0,4	3,97	88
891146	3660338437984	XCNT 10T304EN-TF18 CU30	10	REC 20-225.10R/L			10	0,4	3,97	88
891147	3660338437991	XCNT 10T308EN-TF18 CU30	10	REC 20-225.10R/L			10	0,8	3,97	88
891148	3660338438004	XCNT 130404EN-TF18 CU30	10	REC 25-225.13R/L			12,5	0,4	4,76	88
891149	3660338438011	XCNT 130408EN-TF18 CU30	10	REC 25-225.13R/L			12,5	0,8	4,76	88
891150	3660338438028	XCNT 170508EN-TF18 CU30	10	REC 32-225.17R/L	17	0,8	5,56	88		
891689	3660338443305	XCNT 040104EL-TF72 CU17 LEFT HAND INSERT	10	REC 08-225.04L	MULTI MATERIAL	CU17	4	0,4	1,80	88

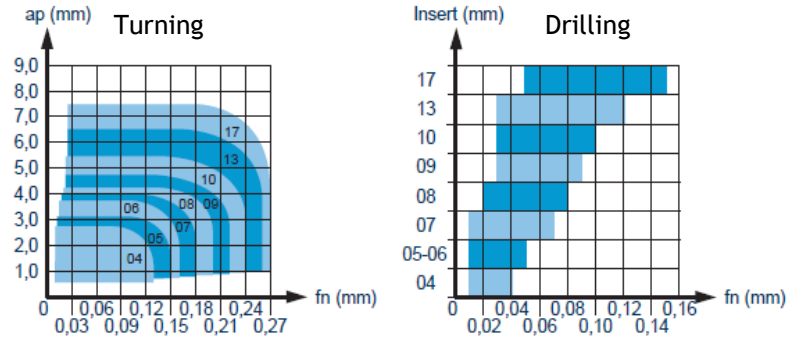
\* R for Right-Hand tool-holder / L for Left-Hand tool-holder

## ECO-CUTLINE | MULTI-OPERATION TOOL

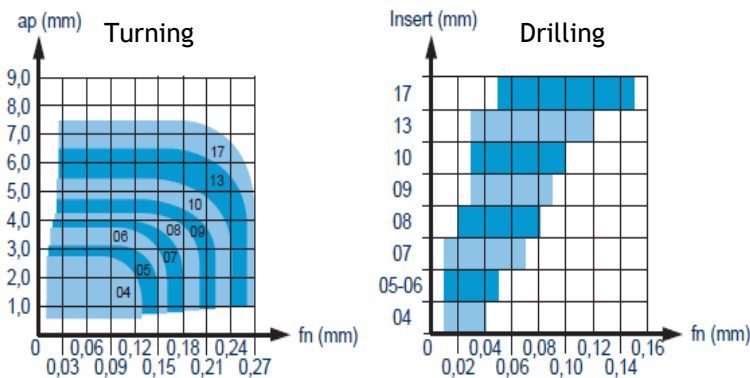
### ➤ ECO-CUTLINE CUTTING PARAMETERS

Grade	MATERIAL	Vc (m/min)
CU15	Aluminium	300
	Aluminium >8% Si	250
	Copper / Bronze / Brass	150
	Thermoplastics	200
CU41	Stainless Steel <700 N/mm <sup>2</sup> (<205 HB)	80
	Stainless Steel >700 N/mm <sup>2</sup> (>205 HB)	50
CU30	Steel <500 N/mm <sup>2</sup> (<150 HB)	120
	Steel <700 N/mm <sup>2</sup> (<205 HB)	120
	Steel <850 N/mm <sup>2</sup> (<265 HB)	80
	Steel <1000 N/mm <sup>2</sup> (<30 HRC)	60
	Steel <1400 N/mm <sup>2</sup> (<44 HRC)	50

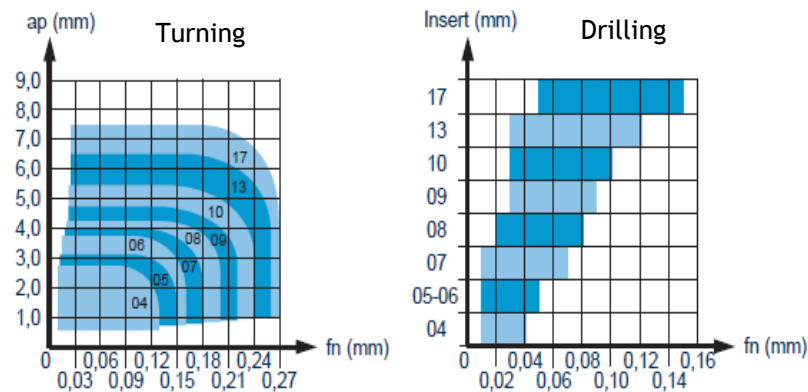
#### CU15 - Non Ferrous Material



#### CU41 - Stainless Steel



#### CU30 - Steel



### ➤ ECO-CUTLINE SET-UP

#### CAREFUL!

The tool-holders Ø8 mm need a specific insert: left-hand or right-hand inserts depending on the tool-holder hand.

- Left hand tool-holder code **891098** - REC 08-225.04<sub>L</sub> D8 →  
Left hand insert code **891689** - XCNT 040104E<sub>L</sub>-TF72 CU17
- Right hand tool-holder code **891099** - REC 08-225.04<sub>R</sub> D8 →  
Right hand insert code depending on the material



Other diameters (from Ø10 to Ø32 mm), neutral inserts are used.