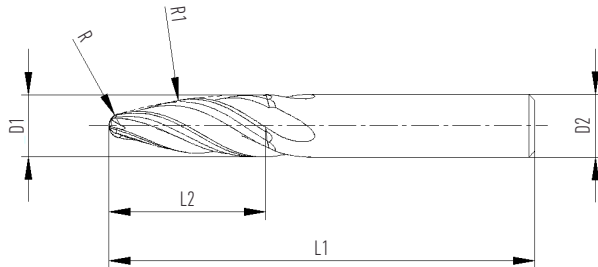


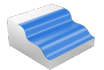
Barell mill F9350

UNIVERSAL / MULTI-FLUTES

- helix angle 30°
- oval shape of flutes
- coating PVD



copying



Cylindrical shank

Order code	Dimensions (mm)						
	D1	D2	L1	L2	R	R1	Z
F9350.6.V6.60.22.R1/R95.Z3	6	6	60	22	R1	R95	3
F9350.8.V8.75.25.R1/R90.Z3	8	8	75	25	R1	R90	3
F9350.10.V10.75.26.R2/R85.Z4	10	10	75	26	R2	R85	4
F9350.12.V12.75.28.R2/R80.Z4	12	12	75	28	R2	R80	4

Recommended cutting conditions

ISO	Strenght (N/mm ²) Material	Allowance (mm)	Vc (m/min.)	Feed fz (mm/t) by mill diameter			
				6	8	10	12
				P	< 800 N/mm ²	0,2 - 0,3 mm	180
	< 1300 N/mm ²	0,2 - 0,3 mm	140	0,030	0,040	0,050	0,060
M	Stainless steel	0,2 - 0,3 mm	100	0,030	0,040	0,050	0,060
K	Grey cast iron < 1000 N/mm ²	0,2 - 0,3 mm	180	0,040	0,050	0,060	0,070
H	High alloyed steel	0,2 - 0,3 mm	130	0,030	0,040	0,050	0,060
N	Aluminium	0,2 - 0,3 mm	380	0,040	0,050	0,060	0,070
S	Titanium alloys	0,2 - 0,3 mm	80	0,030	0,040	0,050	0,060

* If allowance of surface is 0,05-0,1 mm, it is a possibility to increase cutting condition up to 15%