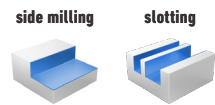
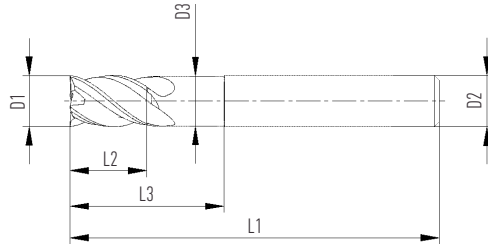


# Mill for superalloys F9740

## UNIVERSAL / 4 FLUTES

- helix angle 38°/41°
- corner radius - Cr
- length of flute 1,5xD
- unequal flute spacing
- coating TiSiN
- relief to 3xD



### Cylindrical shank

Order code	Dimensions (mm)							
	D1	D2	D3	L1	L2	L3	Cr	Z
F9740.6.V6/5,7.57.9/18.R0,5.Z4	6	6	5,7	57	9	18	0,5	4
F9740.8.V8/7,7.63.12/24.R0,5.Z4	8	8	7,7	63	12	24	0,5	4
F9740.10.V10/9,7.72.15/30.R1.Z4	10	10	9,7	72	15	30	1	4
F9740.12.V12/11,6.83.18/36.R1.Z4	12	12	11,6	83	18	36	1	4
F9740.16.V16/15,6.92.24/42.R1.Z4	16	16	15,6	92	24	42	1	4

### Recommended cutting conditions

ISO	Strenght (N/mm <sup>2</sup> ) Material	Ap	Ae	Vc	Feed fz (mm/t)				
		(mm)	(mm)	(m/min.)	by mill diameter				
					6	8	10	12	16
S	Difficult to machine superalloys	Dx1	Dx1	24	0,016	0,021	0,025	0,029	0,035
		Dx1,5	Dx0,25	28	0,018	0,023	0,027	0,031	0,038
	Very difficult to machine superalloys	Dx1,5	Dx0,1	30	0,02	0,026	0,031	0,036	0,044
		Dx1	Dx1	20	0,016	0,021	0,025	0,029	0,035
		Dx1,5	Dx0,1	22	0,02	0,026	0,031	0,036	0,044