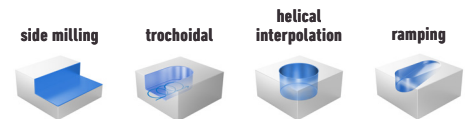
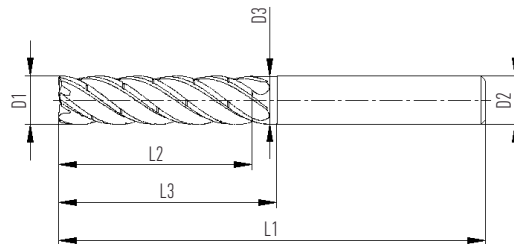


Adaptive roughing mill F9564

5 FLUTES / LONG

- helix angle 38°
- corner radius - Cr
- length of flute 4xD
- unequal flute spacing
- chrome-based coating
- chip splitter



Cylindrical shank

Order code	Dimensions (mm)							
	D1	D2	D3	L1	L2	L3	Cr	Z
F9564.6.V6/5,7.66.24/29.R0,5.Z5	6	6	5,7	66	24	29	0,5	5
F9564.8.V8/7,7.74.32/37.R0,5.Z5	8	8	7,7	74	32	37	0,5	5

Weldon shank

Order code	Dimensions (mm)							
	D1	D2	D3	L1	L2	L3	Cr	Z
F9564.10.W10/9,7.88.40/45.R0,5.Z5	10	10	9,7	88	40	45	0,5	5
F9564.12.W12/11,6.105.48/54.R0,5.Z5	12	12	11,6	105	48	54	0,5	5
F9564.16.W16/15,6.124.64/72.R1.Z5	16	16	15,6	124	64	72	1	5

Recommended cutting conditions

ISO	Strenght (N/mm ²) Material	Ap (mm)	Ae (mm)	Vc (m/min.)	Feed fz (mm/t) by mill diameter				
					6	8	10	12	16
					P	< 800 N/mm ²	Dx4	Dx0,08	265
Dx4	Dx0,06	265	0,0675	0,09			0,1125	0,1350	0,17
< 1300 N/mm ²	Dx4	Dx0,08	165	0,055		0,075	0,093	0,110	0,15
	Dx4	Dx0,06	165	0,068		0,09	0,113	0,135	0,17
K	Grey cast iron < 1000 N/mm ²	Dx4	Dx0,08	215	0,055	0,075	0,093	0,110	0,15
		Dx4	Dx0,06	215	0,068	0,09	0,113	0,135	0,17

* recommended ramp angle up to 3°