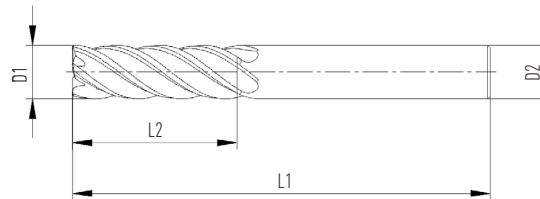


Mill for stainless steel, superalloys F9753

UNIVERSAL / 5 FLUTES

- helix angle 38°
- corner chamfer 45°
- length of flute 3xD
- unequal flute spacing
- coating TiSiN



Cylindrical shank

Order code	Dimensions (mm)				
	D1	D2	L1	L2	Z
F9753.6.V6.66.19.Z5	6	6	66	19	5
F9753.8.V8.70.25.Z5	8	8	70	25	5
F9753.10.V10.78.31.Z5	10	10	78	31	5
F9753.12.V12.92.38.Z5	12	12	92	38	5
F9753.16.V16.110.50.Z5	16	16	110	50	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
M	Ferritic/martensitic steels	Dx3	Dx0,1	130	0,028	0,036	0,043	0,049	0,061
		Dx3,1	Dx0,1	160	0,067	0,086	0,103	0,119	0,147
	Austenitic stainless steels	Dx3	Dx0,1	100	0,028	0,036	0,043	0,049	0,061
		Dx3,1	Dx0,1	120	0,067	0,086	0,103	0,119	0,147
S	Titan	Dx3	Dx0,1	80	0,022	0,029	0,034	0,04	0,049
		Dx3,1	Dx0,1	80	0,059	0,076	0,091	0,105	0,129