

action



valid

September - December 2024

Highly productive monolithic mill

Sets of corner mills F9600
at discounted prices



F9600

High-performance mill with 2xD cutting length

unique shape of flute for better chip evacuation

- chrome based PVD coating
- optional version of shank e.g. Weldon
- highest toughness of tool core
- wide material and technological application
- Ap size: 2xD
- range: 3-12mm

P M K H



SET 1

F9600.6.V6.57.13.Z4
F9600.8.V8.63.19.Z4
F9600.10.V10.72.22.Z4
F9600.12.V12.83.26.Z4

90 €

SET 2

F9600.6.W6.57.13.Z4
F9600.8.W8.63.19.Z4
F9600.10.W10.72.22.Z4
F9600.12.W12.83.26.Z4

90 €

SET 3

F9600.3.V6.57.8.Z4
F9600.4.V6.57.11.Z4
F9600.5.V6.57.13.Z4
F9600.6.V6.57.13.Z4

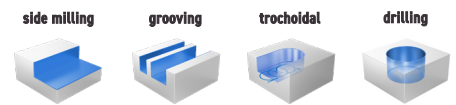
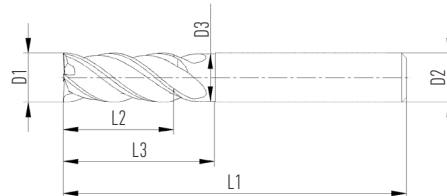
55 €

For a specific offer, please contact a MASAM sales representative

Corner mill F9600

UNIVERSAL / FOUR-BREASTED

- flute angle 38°/40°
- different flute angle
- cutting length 2xD
- deburring 45°
- 2 active cutting edge to centre cut
- different shank possible
- PVD coating



Cylindrical version of shank

| Order number | Size (mm) | | | | | | |
|-----------------------|-----------|----|------|----|----|----|---|
| | D1 | D2 | D3 | L1 | L2 | L3 | Z |
| F9600.3.V6.57.8.Z4 | 3 | 6 | - | 57 | 8 | - | 4 |
| F9600.4.V6.57.11.Z4 | 4 | 6 | 3,8 | 57 | 11 | 16 | 4 |
| F9600.5.V6.57.13.Z4 | 5 | 6 | 4,8 | 57 | 13 | 18 | 4 |
| F9600.6.V6.57.13.Z4 | 6 | 6 | 5,7 | 57 | 13 | 20 | 4 |
| F9600.8.V8.63.19.Z4 | 8 | 8 | 7,7 | 63 | 19 | 25 | 4 |
| F9600.10.V10.72.22.Z4 | 10 | 10 | 9,7 | 72 | 22 | 30 | 4 |
| F9600.12.V12.83.26.Z4 | 12 | 12 | 11,6 | 83 | 26 | 36 | 4 |

Weldon version of shank

| Order number | Size (mm) | | | | | | |
|-----------------------|-----------|----|------|----|----|----|---|
| | D1 | D2 | D3 | L1 | L2 | L3 | Z |
| F9600.6.W6.57.13.Z4 | 6 | 6 | 5,7 | 57 | 13 | 20 | 4 |
| F9600.8.W8.63.19.Z4 | 8 | 8 | 7,7 | 63 | 19 | 25 | 4 |
| F9600.10.W10.72.22.Z4 | 10 | 10 | 9,7 | 72 | 22 | 30 | 4 |
| F9600.12.W12.83.26.Z4 | 12 | 12 | 11,6 | 83 | 26 | 36 | 4 |

Recommended cutting conditions

| ISO | Strength (N/mm ²) Representative mat. | Ap (mm) | Ae (mm) | Vc (m/min.) | Feed rate (mm/zub) according to the cutter diameter | | | | | | |
|-----|---|------------|------------|----------------|--|-------|-------|-------|-------|-------|-------|
| | | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 |
| | | | | | | | | | | | |
| P | < 800 N/mm ² | D×2 | D×0,1 | 150 | 0,040 | 0,060 | 0,090 | 0,110 | 0,180 | 0,220 | 0,240 |
| | | D×2 | D×0,25 | 100 | 0,030 | 0,045 | 0,068 | 0,083 | 0,135 | 0,165 | 0,180 |
| | | D×1 | D×1 | 90 | 0,020 | 0,030 | 0,045 | 0,055 | 0,090 | 0,110 | 0,120 |
| | < 1300 N/mm ² | D×2 | D×0,1 | 135 | 0,040 | 0,070 | 0,090 | 0,110 | 0,180 | 0,200 | 0,240 |
| | | D×2 | D×0,25 | 90 | 0,030 | 0,053 | 0,068 | 0,083 | 0,135 | 0,150 | 0,180 |
| M | Stainless steels | D×1 | D×1 | 80 | 0,020 | 0,035 | 0,045 | 0,055 | 0,090 | 0,100 | 0,120 |
| | | D×2 | D×0,1 | 120 | 0,020 | 0,040 | 0,650 | 0,080 | 0,100 | 0,120 | 0,140 |
| | | D×2 | D×0,25 | 100 | 0,010 | 0,015 | 0,020 | 0,030 | 0,045 | 0,060 | 0,070 |
| K | Gray cast iron < 1000 N/mm ² | D×1 | D×1 | 85 | 0,010 | 0,015 | 0,020 | 0,030 | 0,040 | 0,050 | 0,060 |
| | | D×2 | D×0,1 | 120 | 0,040 | 0,060 | 0,090 | 0,110 | 0,180 | 0,220 | 0,240 |
| | | D×2 | D×0,25 | 70 | 0,030 | 0,045 | 0,068 | 0,083 | 0,135 | 0,165 | 0,180 |
| H | Hardened steels | D×1 | D×1 | 60 | 0,020 | 0,030 | 0,045 | 0,055 | 0,090 | 0,110 | 0,120 |
| | | D×2 | D×0,1 | 90 | 0,020 | 0,040 | 0,050 | 0,060 | 0,080 | 0,100 | 0,120 |
| | | D×2 | D×0,25 | 60 | 0,010 | 0,015 | 0,020 | 0,030 | 0,045 | 0,060 | 0,070 |
| | | D×1 | D×1 | 45 | 0,010 | 0,015 | 0,020 | 0,030 | 0,045 | 0,060 | 0,070 |