

CNC Tools data

GRANLUND
Tools



FM - FMK - FMU - PK

● = Excellent

○ = Good

m/min

fz=0,05-0,15

Part No.	Working piece				Free cutting steel	Tool steels alloyed	High alloyed steel	Stainless steels	Titanium alloys	High temp resistant steel and alloys	Grey cast iron	Aluminium
	Size	Chip breaker	Grade	Radius	HB 175-225 <800N/mm	HB 200-300 <1000N/mm	HB 200-300 <1000N/mm	HB 175-245 <700N/mm	HB 215-500 <1000N/mm	HB 200-400 <1200N/mm	HB 175-225 <800N/mm	HB <160
MPHT-N12-D	06	N12	DX6	0,2	● 90-140	● 90-140	● 50-100	● 70-120				
MPHT-N12-P	06	N12	PMK92*	0,2	● 160-300	● 140-220	● 90-150	● 50-180				
MPHT-N13-C	06	N13	CH1	0,2					○ 40-60		● 160-200	● 300-1000
MPHT-N13-K	06	N13	KM22*	0,2					○ 40-70	○ 15-70	● 180-300	● 300-600
MPHT-N14-D	06	N14	DX6	0,2	● 90-140			● 70-120	○ 40-60	○ 15-20		
MPHT-N14-P	06	N14	PMK92*	0,2	● 160-300	● 140-220	● 90-150	● 90-180				
MPHT-N14-P	06	N15	CT50**	0,2	● 250-400	● 200-350	● 180-250	● 150-240		○ 15-70	● 250-400	● 300-1000
MPMT-N12-C	06	N12	CH1	0,4					○ 40-60		● 160-200	● 300-1000
MPMT-N12-D	06	N12	DX6	0,4	● 90-140	● 80-140	● 50-100	● 70-120				
MPMT-N12-P	06	N12	PMK92*	0,4	● 160-300	● 140-220	● 90-150	● 90-180				
MPMT-N12-K	06	N12	KM22*	0,4					○ 40-70	○ 15-70	● 180-300	
MCHT-N12-D	09	N12	DX6	0,4	● 90-140							
MCHT-N12-P	09	N12	PMK92*	0,4	● 160-300	● 140-220	● 90-150	● 90-180				
MCHT-N13-C	09	N13	CH1	0,4					○ 40-60		● 160-300	● 300-1000
MCHT-N13-K	09	N13	KM22*	0,4				● 150-300	○ 40-70	○ 15-70		● 300-600
MCHT-N14-D	09	N14	DX6	0,4	● 90-140	● 90-140	● 50-100	● 70-120				
MCHT-N14-P	09	N14	PMK92*	0,4	● 160-300	● 140-220	● 90-150	● 90-180				
MCHW-N15-C	09	N15	CT50**	0,4	● 250-400	● 200-350	● 180-250	● 150-240			● 250-400	
MCMT-N12-C	09	N12	CH1	0,8					○ 40-70	○ 15-70	● 160-200	● 300-1000
MCMT-N12-P	09	N12	PMK92*	0,8	● 160-300	● 140-220	● 90-150	● 90-180				
MCMT-N12-K	09	N12	KM22*	0,8					○ 40-70	○ 15-70	● 180-300	
MBHT-N12-P	12	N12	PMK92*	0,4	● 160-300	● 140-220	● 90-150	● 90-180		○ 20-60	● 160-200	● 300-1000
MBHT-N13-C	12	N13	CH1	0,4					○ 40-60		● 160-200	● 300-1000
MBHT-N13-K	12	N13	KM22*	0,4				● 150-300	○ 40-70	○ 15-70		● 300-600
MBHT-N14-P	12	N14	PMK92*	0,4	● 160-300	● 140-220	● 90-150	● 90-180				
MBMT-N12-D	12	N12	DX6	0,8	● 90-140	● 90-140	● 50-100	● 70-120				
MBMT-N12-P	12	N12	PMK92*	0,8	● 160-300	● 140-220	● 90-150	● 90-180		○ 20-60		
Chipbreaker for FM-FMK-FMU-PK												
						N12	N13	N14	N15	R16		

*=(TiAlN), **=(Cermet)