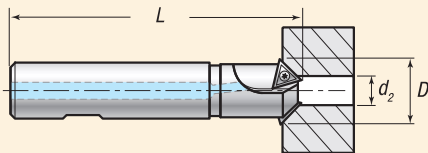




### FV 90°, Chamfer and face milling tool

D mm	Part No.	Weldon Shank mm	d <sub>2</sub> min mm	L mm	Chamfers maximum depth mm	No. of inserts
12,0	FV9-12,0	16	6,0	90	5,0	1
12,4	FV9-12,4	16	6,0	90	5,0	1
16,0	FV9-16,0	16	8,0	90	7,5	1
16,5	FV9-16,5	16	8,0	90	7,5	1
20,0	FV9-20,0	20	8,5	100	10,0	2
20,5	FV9-20,5	20	8,5	100	10,0	2
25,0	FV9-25,0	20	13,0	100	12,0	2
30,0	FV9-30,0	20	18,0	100	12,0	2



### Inserts for FV / Transformaster

Type of insert			Radius mm	Suitable for	
Type of tool D mm	Size of insert	Part No.	Part No.	Radius mm	Suitable for
FV9 12,0-16,5 Transformaster	07	TPMT-07T	TPMR-07T	0,4	Universal
	07		TPGR-07T	0,4	Universal
	07		TPMR-07H	0,4	HARDOX
	07	TPMT-07M		0,4	Stainless
	07	TPMT-07K		0,4	Aluminium
FV 20,0 - 30,0	10	TPMT-10T	TPMR-10T	0,4	Universal
	10		TPGR-10T	0,4	Universal
	10		TPMR-10H	0,4	HARDOX
	10	TPMT-10M		0,4	Stainless
	10	TPMT-10K		0,4	Aluminium

- Carbide quality PK40. All inserts are coated in several layers (TiCN-TiC-TiN).
- The GRANLUND inserts have special chipbreaker angle for optimum chip control.

### Cutting data for Chamfering

Material	Speed	Feed	Material	Speed	Feed
Steel <450 N/mm <sup>2</sup>	75 -120 m/min	0,1 - 0,5 mm/rev.	Cast Iron	80 - 110 m/min	0,1-0,5 mm/rev.
Steel <600 N/mm <sup>2</sup>	65 -110 m/min	0,1 - 0,4 mm/rev.	Cast Aluminium	80 - 150 m/min	0,1-1,0 mm/rev.
Steel <1000 N/mm <sup>2</sup>	55 -100 m/min	0,1 - 0,3 mm/rev.			

Cutting data for face milling = 1,5 x Cutting data for Chamfering.