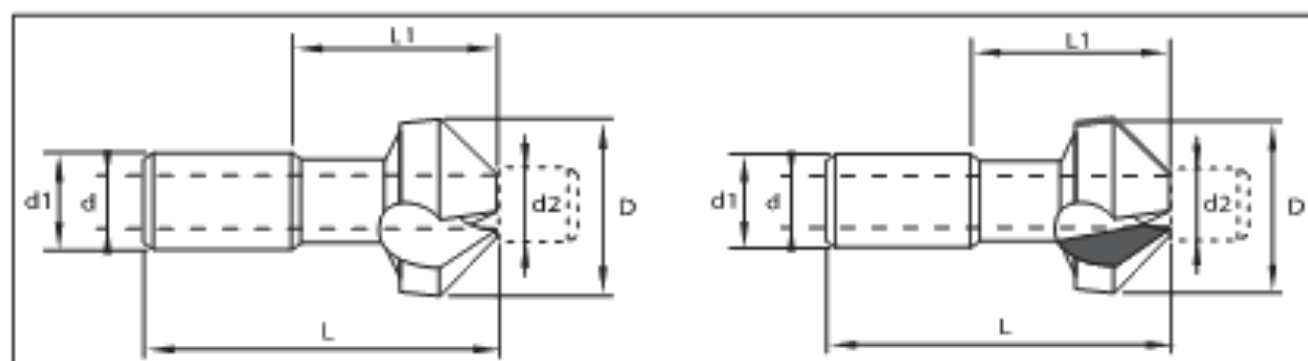


GRANLUND SIZE 1 HSS MODULAR COUNTERSINKING MILLING CUTTERS

ITEM: B8G25



HSS 90° COUNTERSINKING MILLING CUTTERS

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G2516	1T9-16,0	16	6	14	6,6	48	28
B8G2518	1T9-18,0	18					
B8G2520	1T9-20,0	20					

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G2525	1T9-25,0	25	6	14	6,6	48	28
B8G2530	1T9-30,0	30					

HSS countersinking milling cutter allow for both rotating and fixed tips/pilots and guides/drills

HSS 60° COUNTERSINKING MILLING CUTTERS

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G3016	1T6-16,0	16	6	14	6,6	48	28
B8G3018	1T6-18,0	18					
B8G3020	1T6-20,0	20					

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G3025	1T6-25,0	25	6	14	6,6	48	28
B8G3030	1T6-30,0						

HSS countersinking milling cutter allow for both rotating and fixed tips/pilots and guides/drills

HM 90° COUNTERSINKING MILLING CUTTERS

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G3220	1TH9-20,0	20	6	14	10	48	28

Tech. Code	Description	D mm	d mm	d1 mm	d2 min mm	L mm	L1 mm
B8G3230	1TH9-30,0	30	6	14	10	48	28

HM countersinking milling cutters only allow for rotating guides/drills

GRANLUND COUNTERBORING INSERTS

TPMT - 07U



TPMT - 10U



			Description	Grade	Tech. Code	Feed mm/rev	P			M		K		N	S	H
							<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MED. CUT.	UNIVERSAL		TPMT 07U	P30	B8T01TP07015	0,05 0,15 0,25	●	●	●	○	○	●	●	●	○	○
			TPMT 10U		B8T01TP10015		●	●	●	○	○	●	●	●	○	○

Conditions in bold indicate inserts for general machining.

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Degrees Recommended	Cutting speed Vc (m/min.)	Feed fz/mm
Low carbon content steel (C15, etc.)	~ 180	P30	150 - 250	0.08 - 0.25
	~ 180	P30	150 - 250	0.08 - 0.25
	~ 180	P30	150 - 250	0.08 - 0.25
Cast iron (GG25, GG30, GGG40 etc.)	150 ~ 250	4L15	160	0.08 - 0.15 - 0.30
Non ferrous alloys (Si < 13%)	-	HT15	300 - 400	0.05 - 0.10