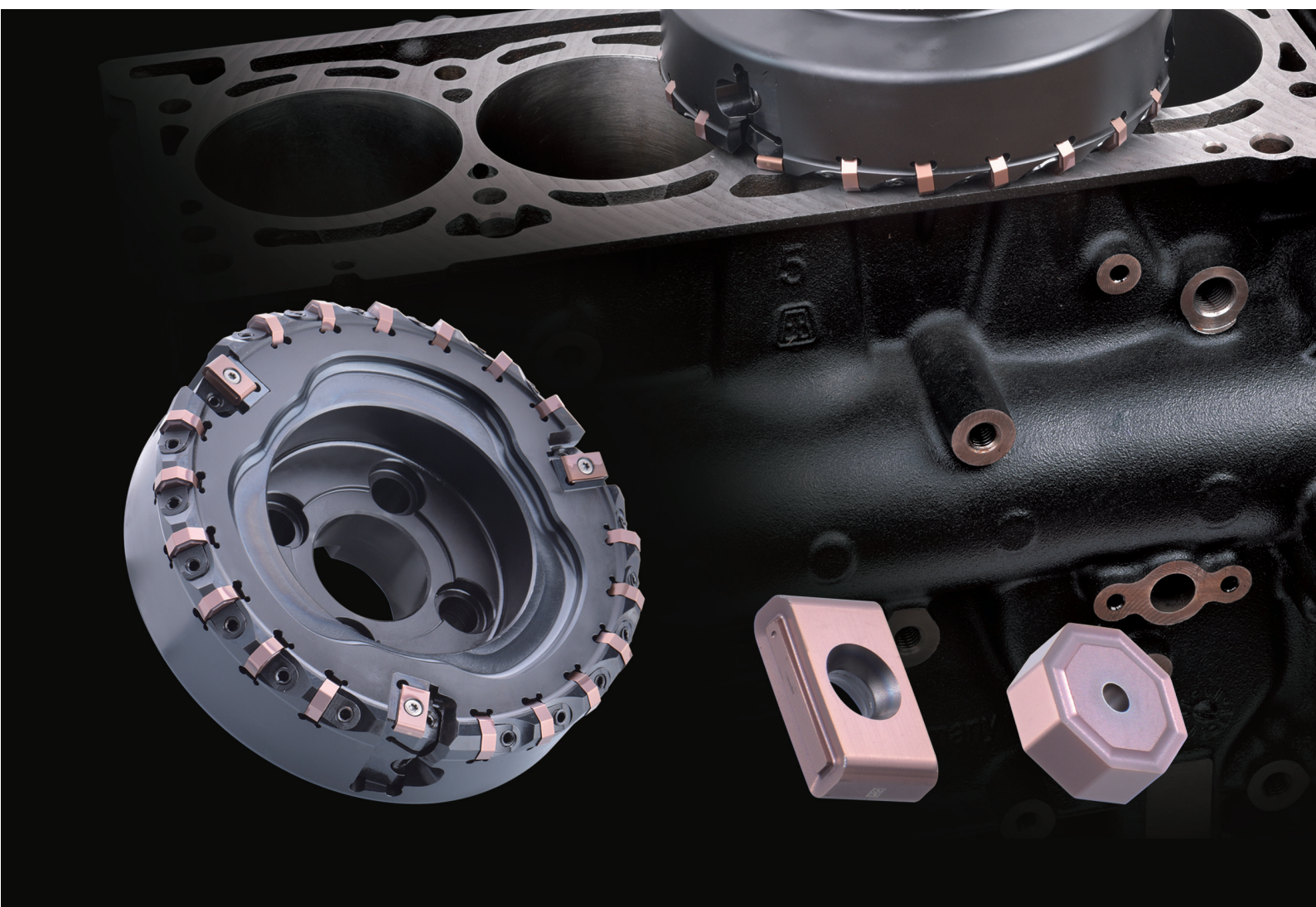


NEW

FMFR-LN12/15

Cast Iron Finishing Milling Cutter



◆ FMFR-LN12/15 Milling cutter

- Close pitch design, approach angle 40°;
- FMFR-LN12, diameter range: $\Phi 80-100\text{mm}$;
- FMFR-LN15, diameter range: $\Phi 125-250\text{mm}$;
accept special tool inquiry;
- Wedge clamping design for roughing insert, easily to install ;
- Wiper cartridge designed with pre-load mounting technology, wiper insert can be easily adjusted and stable accuracy ;
- Tool body surface with blackening treatment;



◆ FMFR-LN12/15 Insert

- Rough insert

Octagonal negative roughing insert with 16 indexes, economic choice

Insert description ONHX 050408-LP

Insert grade SM7415

- Wiper Insert

With 4 indexes

Insert description

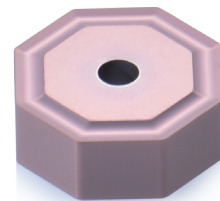
LNHX 120908-W

LNHX 150916-W

Insert grade SM7415

SM7415 with high hardness substrate and high wear resistance coating

Roughing and wiper insert are fine ground insert



◆ Application

Used for cast iron materials, example: gray cast iron, nodular cast iron, CGI material;

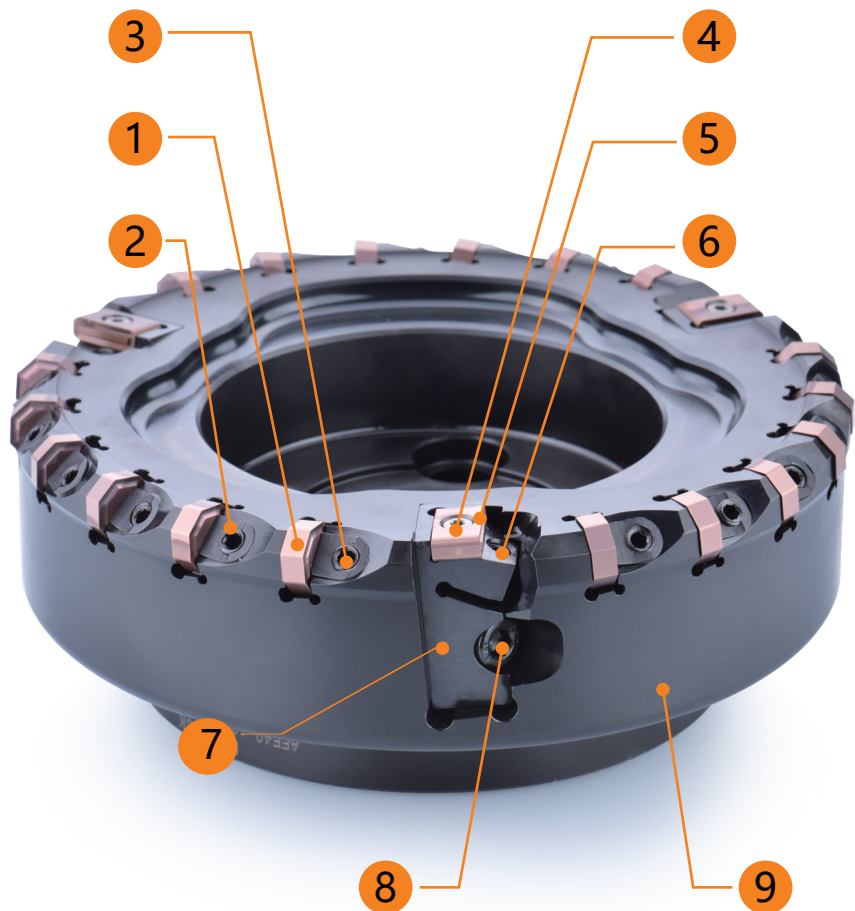
Used for finish milling of high-precision box parts such as engine cylinder block and cylinder head, hydraulic pump body and valve body ;

● **Installation and adjustment method on cast iron finishing machining cutter:**

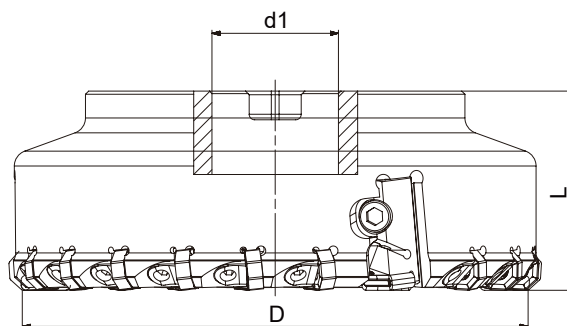
- 1.Clean wiper cartridge (7),completely release adjusting screw(6);
- 2.Clean each inserts pocket, cartridge pocket, clean inserts and cartridges,
- 3.Install roughing inserts(1), wiper cartridges(7) and use finger to push them to the locating surface and lock the bolt;
- 4.Install wiper inserts(5);
- 5.Measure the axial runout of each roughing and wiper insert;
- 6.Adjusting wiper inserts height through adjusting screw(6),Wiper inserts Max. runout value should be higher than roughing inserts, height range 0.03-0.06;

● **Corresponding items of each serial number:**

- 1.Roughing inserts(ON..05..)
- 2.Locking wedge
- 3.Double-headed wedge Locking bolts
- 4.Wiper inserts clamping screw
- 5.Wiper inserts (LN12/15)
- 6.Adjusting screw
- 7.Wiper inserts cartridge
- 8.Locking bolt for wiper cartridge
- 9.Cutter



FMFR-LN12/15 Tool body



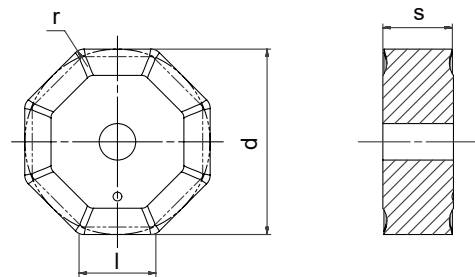
Model	Size				With coolant	Teeth	Teeth of wiper inserts	Inserts
	D	d1	L	apmax				
FMFR-080-A27-LN12-02	80	27	50	0.5		8+2	2	ONHX 050408-LP SM7415
FMFR-100-A32-LN12-02	100	32	50	0.5		10+2	2	LNHX 120908-W SM7415
FMFR-125-A40-LN15-03	125	40	63	0.5		15+3	3	ONHX 050408-LP SM7415 LNHX 150916-W SM7415
FMFR-160-A40-LN15-03	160	40	63	0.5		18+3	3	
FMFR-200-A60-LN15-03	200	60	63	0.5		24+3	3	
FMFR-250-A60-LN15-03	250	60	63	0.5		30+3	3	

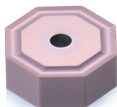
Dimension(mm)	Spare parts				
Cutter diameter	wedge type	wedge clamping screw	wiper inserts locking screw	wiper inserts adjusting screw	wiper inserts cartridge locking screw
φ80-250					
	A WG-6H-13B	WD060200	SP040085H	AH050100F	SH060250

Dimension(mm)	Spare parts				
Cutter diameter	wedge screw wrench	wiper inserts screw wrench	wiper inserts adjusting screw wrench	wiper cartridge locking screw wrench	wiper cartridge
φ80-250					
	LT-H3	DT-TP10	LT-H2.5	LT-H5	φ80-100
					C-LN1235-2545
					φ125-250
					C-LN1535-2545

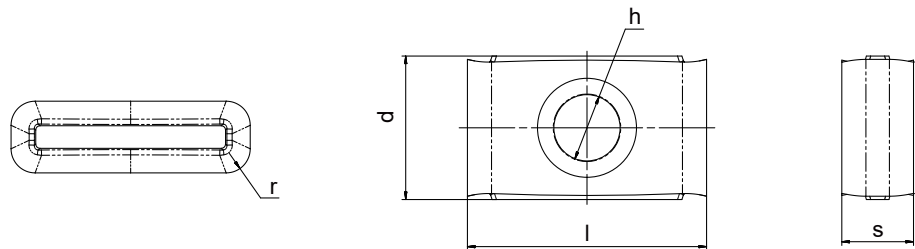
FMFR-LN12/15 Insert


ONHX



Inserts	Model	Size				Grades
						PVD coating
		l	d	s	r	SM7415
	ONHX 050408-LP	5.3	12.7	4.76	0.8	●

LNHX



Inserts	Model	Size					Grades
							PVD coating
		l	d	s	r	h	SM7415
	LNHX 120908-W	12.7	9.525	4.76	0.8	4.4	●
	LNHX 150916-W	15.875	9.525	4.76	1.6	4.4	●

● Stands for standard stock