New products for machining technicians

NEW

MaxiMill Slot-SX

New side and face milling system with SX inserts from SX grooving system

---

NEW

MaxiMill 242

Update to chamfer milling cutter

NEW

MaxiMill 490

Update to adjustable single angle milling cutter

NEW

CTPX715

New multi-range grade

NEW

MaxiMill 273-08

NEW

MaxiMill 252

Table of contents

CERATIZIT \ Performance

Premium quality tools for high performance.

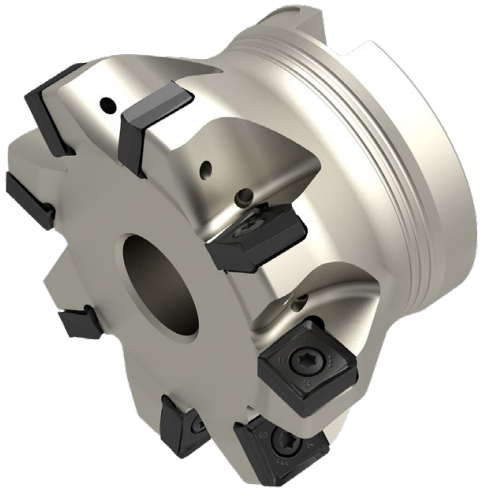
The premium quality tools from the **CERATIZIT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

Symbol explanation


central internal coolant


lateral internal coolant

Cutting edge angle



ZNF = Number of flutes

● = **Main application**

○ = Extended application

Application symbols


Face milling


Angled ramping


Circular drill milling


plunge milling


Slot milling


Shoulder milling


Slot milling (45°)


Chamfer milling


Free form milling


T-slot milling

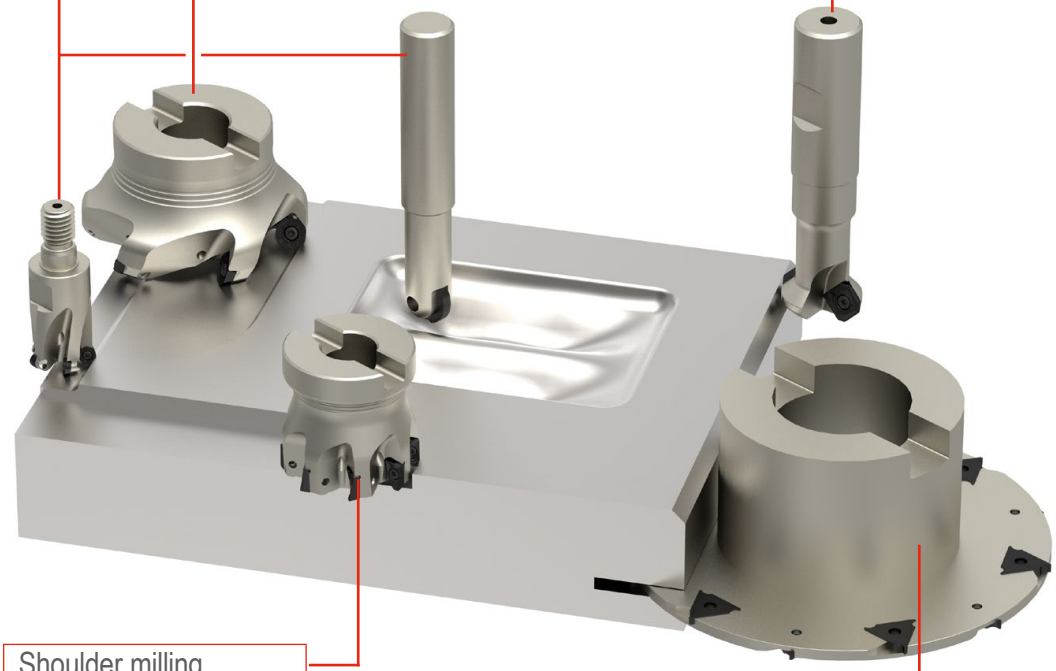
Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

Toolfinder – Application Selection Guide

Form milling
→ System Selection:
10+11

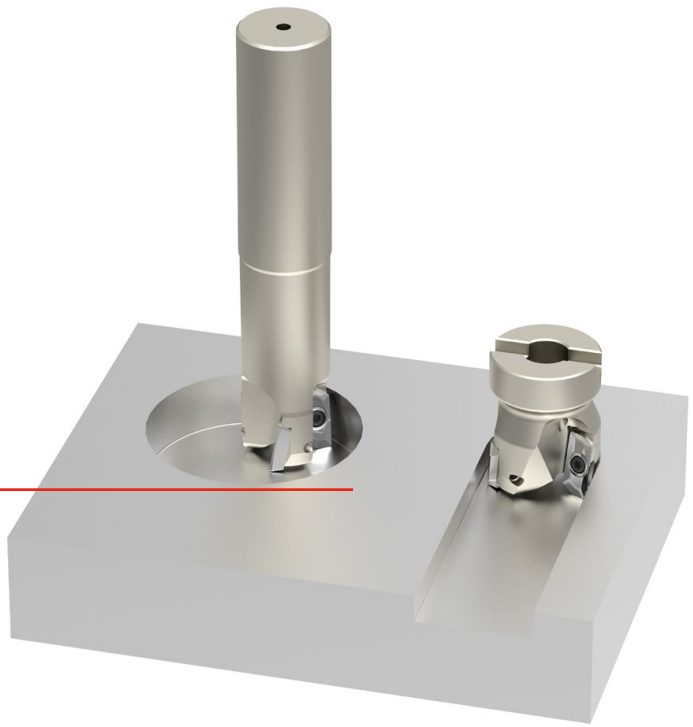
Face milling
→ System Selection:
6+7

Chamfer/Angle milling cutters
→ System Selection:
12



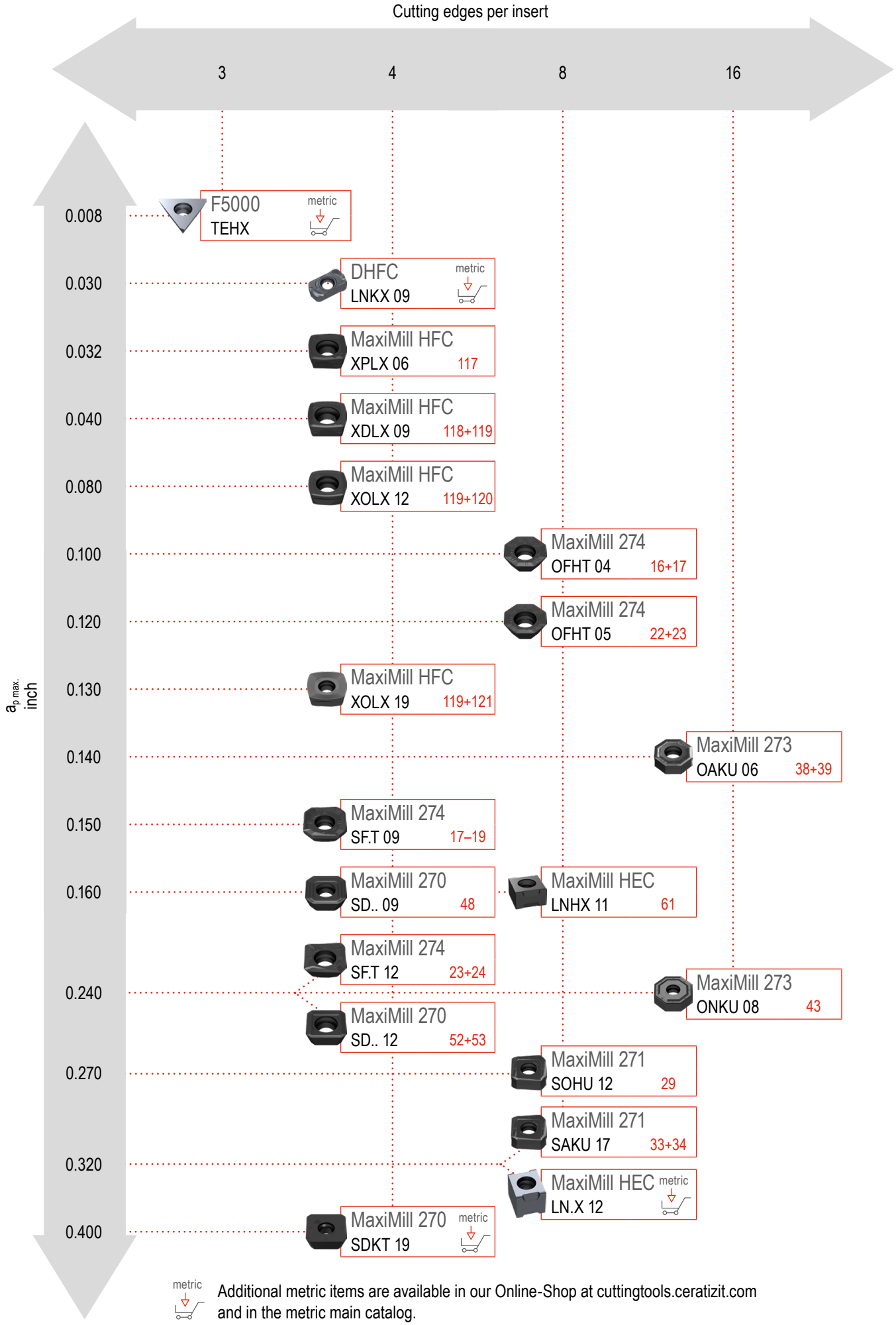
Shoulder milling
→ System Selection:
8+9

Slot milling and saws
metric



High Speed Cutting (HSC) / High Performance Cutting (HPC)
→ System Selection:
8+9

Toolfinder – Face Milling Cutters

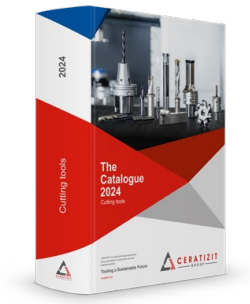


metric Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

Overview – Face Milling Cutters

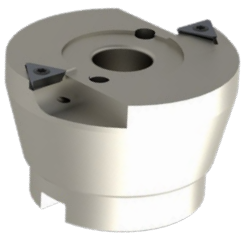
System	Inserts	Cutting edges per insert	$a_{p\,max.}$ inch	Ø-range inch		Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Page No.
MaxiMill 274	**OFH.** 04.. / 05.. | **SF.T** 09.. / 12..	8 | 4	0.100 – 0.240"	Ø 1.000–1.250"	Ø 1.500–6.000"	●	●	●	●	●		○	13–24
MaxiMill 271	**SOHU** 1204.. | **SAKU** 1706..	8	0.270 – 0.330"	Ø 1.250–1.500"	Ø 1.500–10.000"	●	●	●		●			25–34
MaxiMill 273	**OAKU** 0605.. | **ONKU** 0806..	16	0.137 – 0.197"	Ø 1.500–1.500"	Ø 2.000–10.000"	●	●	●		●			35–43
MaxiMill 270	**SD..** 0903.. / 1204.. / 19..	4	0.160 – 0.400"	Ø 0.500–1.500"	Ø 2.000–6.000"	●	●	●	●	●		○	44–57
MaxiMill HEC	**LNHX** 1106..	8	0.160 – 0.320"		Ø 2.000–8.000"	●		●			○		58–61
MaxiMill HFC	**X..X** 06.. / 09.. / 12.. / 19..	4	0.032 – 0.129"	Ø 0.625–1.250"	Ø 0.625–1.500" Ø 1.500–5.000"	●	●	●		●			113–121

Additional diameters are available upon request.



metric

Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

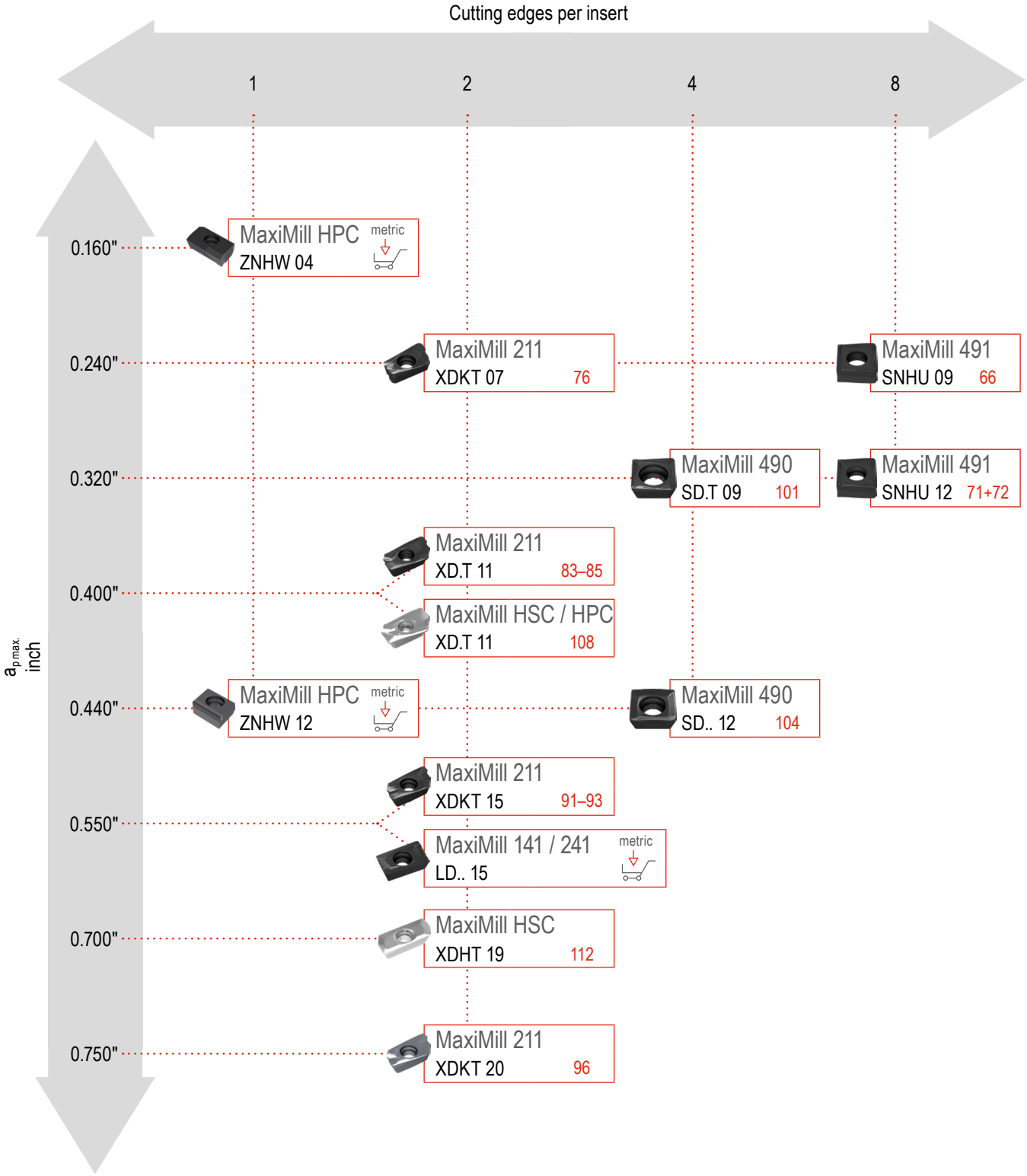


F 5000

DHFC

15

Toolfinder – shoulder milling

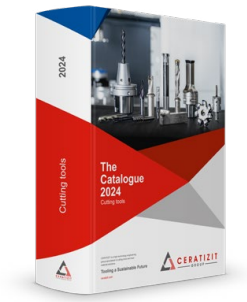


metric Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

Overview – Shoulder Milling Cutters

System	Inserts	Cutting edges per insert	$a_{p\,max.}$ inch	Ø-range inch			Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Page No.
MaxiMill 491	**SNHU** 09T3.. / 1204..	8	0.240 – 0.320"		Ø 1.000–1.250"	Ø 1.500–6.000"	●	●	●	●	●		○	62–72
MaxiMill 211	**XD.T** 0703.. / 11T3.. / 1505.. / 2007..	2	0.240 – 0.750"	Ø 0.625–1.250"	Ø 0.375–1.500"	Ø 1.500–6.000"	●	●	●	●	●	○		74–96
MaxiMill 211KN	**XD.T** 11T3.. / 1505.. / 2007..	2	1.00 – 3.00"		Ø 1.000–1.500"	Ø 2.000–3.000"	●	●	●	●	●			82+90
MaxiMill 490	**SD..** 09T3.. / 1205..	4	0.320 – 0.430"	Ø 1.000–1.250"	Ø 1.000–1.250"	Ø 1.500–6.000"	●	●	●	●	●			97–104
MaxiMill HSC	**XD..** 11T3.. / 1904..	2	0.400 – 0.700"		Ø 0.625–1.500"	Ø 1.500–6.000"		○	●				○	105–112

Additional diameters are available upon request.



metric

Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

MaxiMill 209 / 210

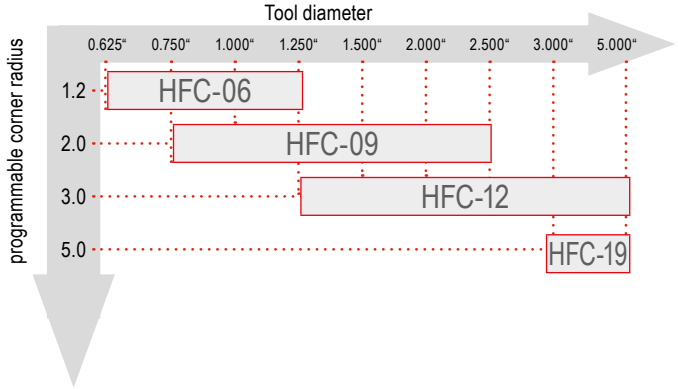
MaxiMill HPC

15

Toolfinder – form milling

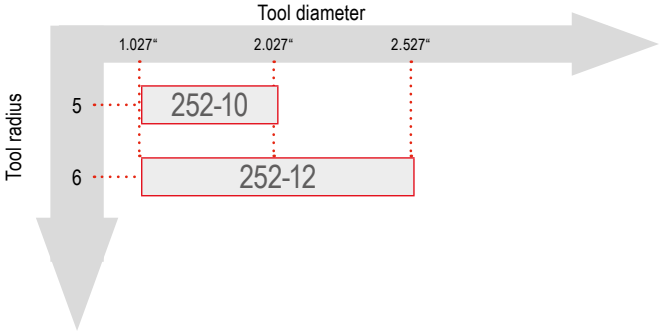
MaxiMill HFC

113–121



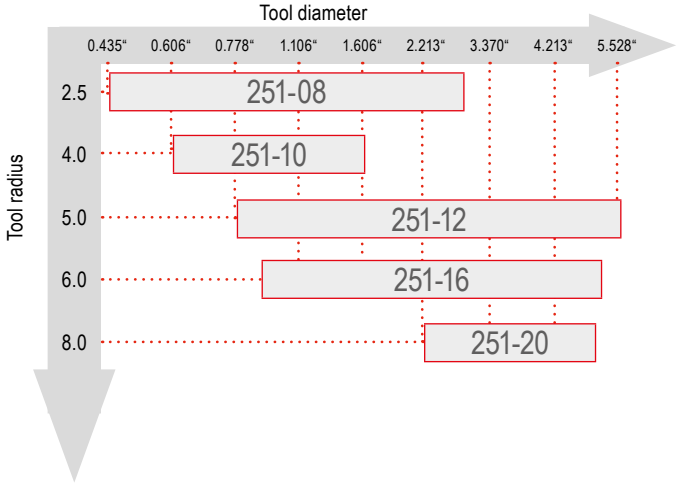
MaxiMill 252

133+135

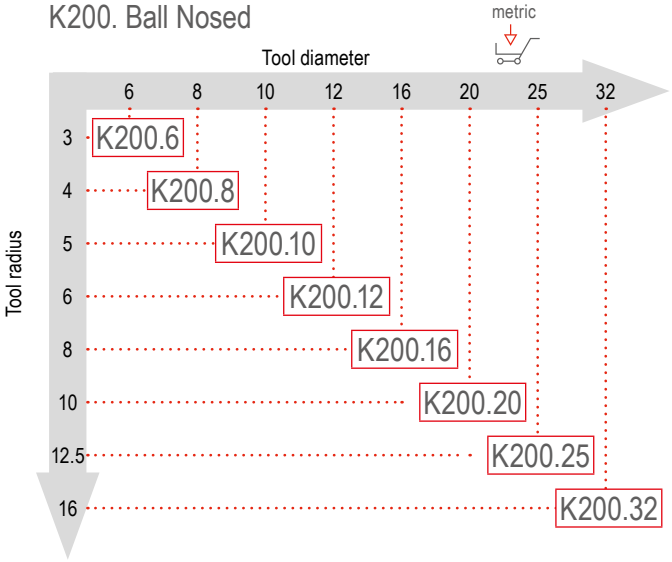


MaxiMill 251 RS

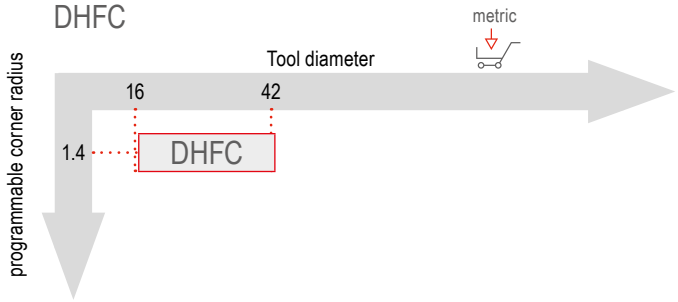
122–132



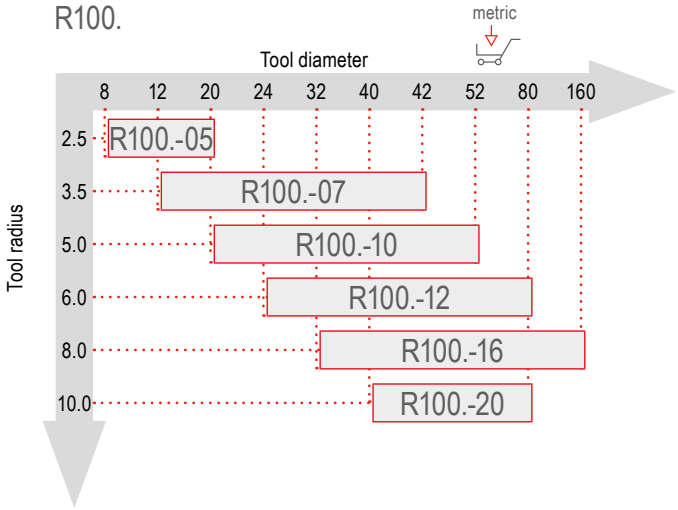
K200. Ball Nosed



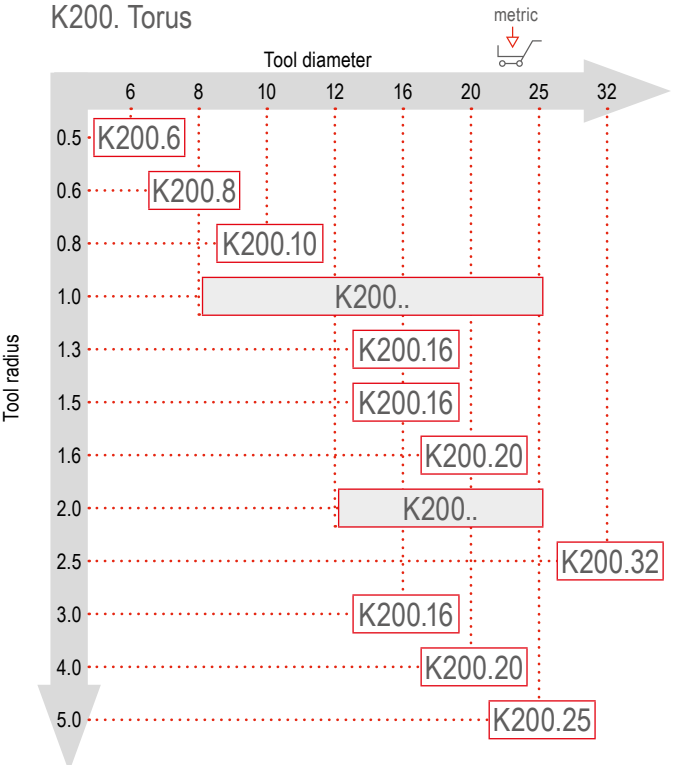
DHFC



R100.



K200. Torus



Application range

Tool diameter

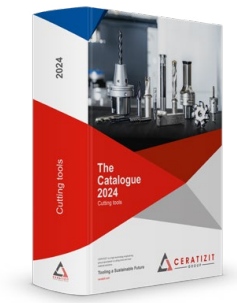
metric

Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

Overview – form milling

System	Inserts	Cutting edges per insert	$a_{p\,max.}$ inch	Ø-range inch			Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Page No.
MaxiMill HFC	**X.LX** 06.. / 09.. / 12.. / 19..	4	0.032–0.130"	Ø 0.625–1.250"	Ø 0.625–1.500"	Ø 1.500–5.000"	●	●	●		●			113–121
MaxiMill 251 RS	**R..X** 05.. / 08.. / 10.. / 12.. / 16.. / 20..	8	0.100–0.400"	Ø 0.606–1.106"	Ø 0.435–1.106"	Ø 1.185–5.213"	●	●	●	●	●	●	○	122–132
MaxiMill 252	**RNHU** 10.. / 12..	8	0.120"			Ø 1.027–2.527"	●	●	○		●			133+135

Additional diameters are available upon request.



metric

Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

K200. Ball Nosed

R100.

DHFC

K200. Torus

15

Overview – Chamfer / Angle Milling Cutters

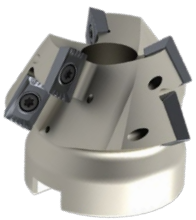
System	Inserts	Cutting edges per insert	$a_{p\ max.}$ inch	Ø-range inch	Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Page No.
MaxiMill 272	**SD..** 0903..	4	0.160"	Ø 0.500"	●	●	○	●	●			46–48
Insert countersink 90°	**TOHX** 090204 / 140305	2		Ø 0.748–1.457"	●	●	●	●	●	○	●	152+153

Additional diameters are available upon request.

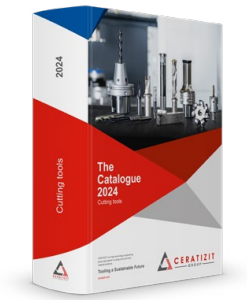
Overview – Saw cutters

System	Inserts	Cutting edges per insert	ap max. mm	Ø-range mm		Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Page No.
MaxiMill Slot-SX	**SX** E...	1	115	Ø 63–100	Ø 80–315	●	●	●	●	●		○	136–151

Additional diameters are available upon request.

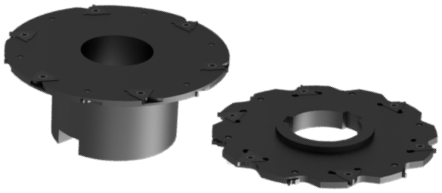


MaxiMill 242



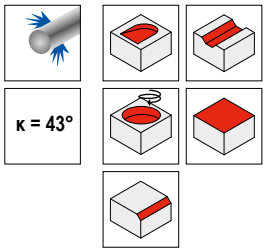
metric

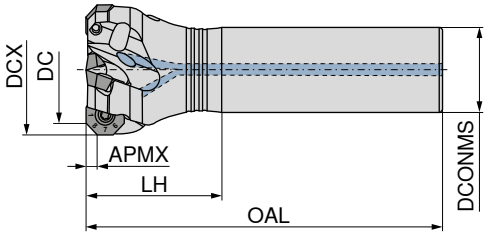
Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.



TX

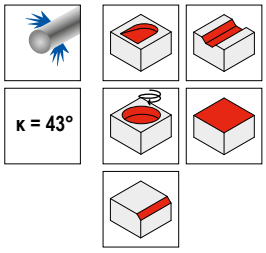
MaxiMill – 274-04/-09 End milling cutter

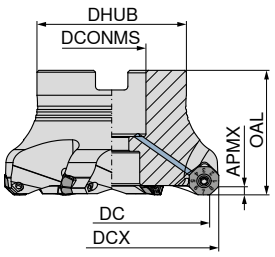




Designation	DC inch	DCX inch	ZNF	OAL inch	LH inch	DCONMS inch	torque moment Nm	Insert	58 743 ...	58 743 ...
C274.100.R.04-09-A075-125-EF	1.000	1.228	4	3.350	1.250	0.750	1.2	OF.. 0403 / SF.. 0903		10004
C274.100.R.04-09-B075-125-EF	1.000	1.228	4	3.350	1.250	0.750	1.2	OF.. 0403 / SF.. 0903	30004	
C274.125.R.05-09-A100-150-EF	1.250	1.479	5	3.900	1.500	1.000	1.2	OF.. 0403 / SF.. 0903		12505
C274.125.R.05-09-B100-150-EF	1.250	1.479	5	3.900	1.500	1.000	1.2	OF.. 0403 / SF.. 0903	32505	

MaxiMill – 274-04/-09 Shell mill





Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert	58 744 ...
A274.150.R.05-09-A050-175-EF	1.500	1.740	5	0.098	1.420	1.420	0.500	29200	1.2	OF.. 0403 / SF.. 0903	15005
A274.200.R.07-09-A075-175-EF	2.000	2.230	7	0.098	1.750	1.750	0.750	25000	1.2	OF.. 0403 / SF.. 0903	20007
A274.300.R.09-09-A100-200-EF	3.000	3.230	9	0.098	2.250	2.250	1.000	20100	1.2	OF.. 0403 / SF.. 0903	30009
A274.400.R.11-09-B125-200-EF	4.000	4.230	11	0.098	2.750	2.750	1.250	17300	1.2	OF.. 0403 / SF.. 0903	40011

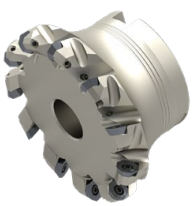

Screwdriver


Molykote


Clamping screw

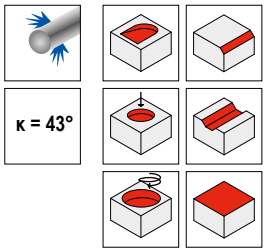
Spare parts DC	80 950 ...	70 950 ...	70 950 ...
1.000	039	303	133
1.250	039	303	133
1.500	039	303	133
2.000	039	303	133
3.000	039	303	133
4.000	039	303	133

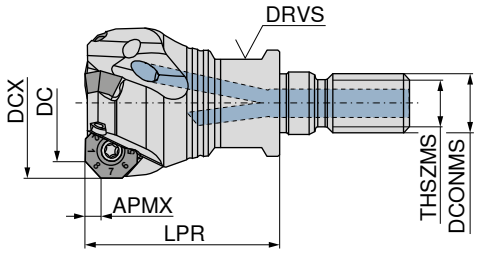
Two insert types – ONE Cutter



15

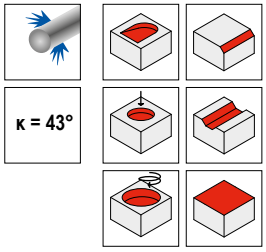
MaxiMill – 274-04/-09 Screw in cutter

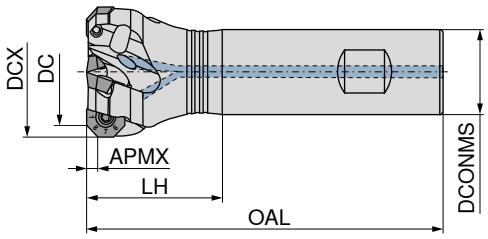




										50 742 ...	
Designation	DC mm	DCX mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	torque moment Nm	Insert	
G274.20.R.03-09	20	25.8	3	3.8	35	M12	12.5	17	1.2	OF.. 0403 / SF.. 0903	**020**
G274.25.R.04-09	25	30.8	4	3.8	35	M12	12.5	17	1.2	OF.. 0403 / SF.. 0903	**025**
G274.32.R.05-09	32	37.9	5	3.8	35	M16	17.0	24	1.2	OF.. 0403 / SF.. 0903	**032**

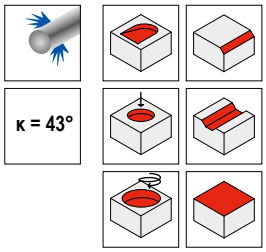
MaxiMill – 274-04/-09 End milling cutter

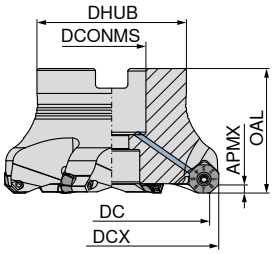


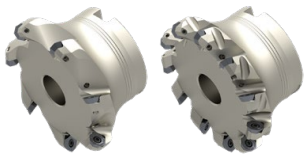



										50 743 ...	50 743 ...
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	torque moment Nm	Insert		
C274.20.R.03-09-A/B20-25	20	25.8	3	3.8	77	25	20	1.2	OF.. 0403 / SF.. 0903	**020**	**120**
C274.25.R.04-09-A/B20-32	25	30.8	4	3.8	84	32	20	1.2	OF.. 0403 / SF.. 0903	**025**	**125**
C274.32.R.05-09-A/B25-40	32	37.9	5	3.8	98	40	25	1.2	OF.. 0403 / SF.. 0903	**032**	**132**

MaxiMill – 274-04/-09 Shell mill



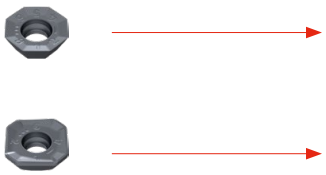


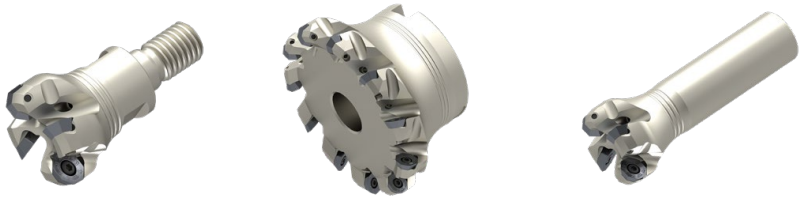


										50 744 ...		50 744 ...	
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	torque moment Nm	Insert				
A274.32.R.05-09	32	37.9	5	3.8	40	38	16	1.6	OF.. 0403 / SF.. 0903				**032**
A274.40.R.04-09	40	46.0	4	3.8	40	38	16	1.6	OF.. 0403 / SF.. 0903		**040**		
A274.40.R.06-09	40	46.0	6	3.8	40	38	16	1.6	OF.. 0403 / SF.. 0903				**140**
A274.50.R.05-09	50	55.9	5	3.8	40	48	22	1.6	OF.. 0403 / SF.. 0903		**050**		
A274.50.R.07-09	50	55.9	7	3.8	40	48	22	1.6	OF.. 0403 / SF.. 0903				**150**
A274.63.R.06-09	63	68.9	6	3.8	40	48	22	1.6	OF.. 0403 / SF.. 0903		**063**		
A274.63.R.09-09	63	68.9	9	3.8	40	48	22	1.6	OF.. 0403 / SF.. 0903				**163**
A274.80.R.07-09	80	85.9	7	3.8	50	58	27	1.6	OF.. 0403 / SF.. 0903		**080**		
A274.80.R.11-09	80	85.9	11	3.8	50	58	27	1.6	OF.. 0403 / SF.. 0903				**180**
A274.100.R.09-09	100	105.9	9	3.8	50	78	32	1.6	OF.. 0403 / SF.. 0903		**100**		
A274.100.R.13-09	100	105.9	13	3.8	50	78	32	1.6	OF.. 0403 / SF.. 0903				**200**
A274.125.R.12-09	125	130.9	12	3.8	63	88	40	1.6	OF.. 0403 / SF.. 0903		**125**		

	TORX® blade	Clamping key – T	Screwdriver	Power Screw	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
20 - 32	**043**		**125**		**303**	**133**	**191**
32 - 40	**043**	**040**	**125**	**151**	**303**	**133**	**191**
50 - 125	**043**		**125**		**303**	**133**	**191**

Two insert types – ONE Cutter

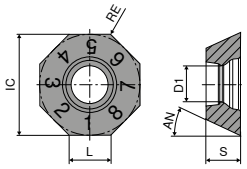




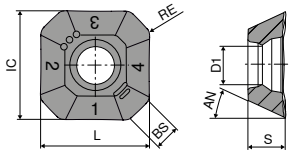
	TORX® blade	Clamping key – T	Screwdriver	Power Screw	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
20 - 32	**043**		**125**		**303**	**133**	**191**
32 - 40	**043**	**040**	**125**	**151**	**303**	**133**	**191**
50 - 125	**043**		**125**		**303**	**133**	**191**

OFHT / OFHW / SFHT / SFKT

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
OFH. 0403..	0.375	0.132	0.155	-	0.125	25
SF.T 0903..	0.386	0.132	0.354	0.089	0.138	25



OF..

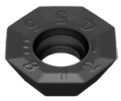
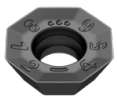


SF.T

OFHT

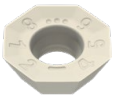
	-F50 CTCP230 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-F50 CTPP235 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN
				
	F	M	F	M
	OFHT	OFHT	OFHT	OFHT
	51 002 ...	51 003 ...	51 002 ...	51 003 ...
ISO / RE inch				
040305SN 0.020	005	005	105	105
P	●	●	●	●
M			○	○
K	○	○	○	○
N				
S				
H				
O				

OFHT / OFHW

	-F50 CTCM235 DRAGONSKIN	-F50 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-F50 CTPM245 DRAGONSKIN	CTPM245 DRAGONSKIN	-F50 CTCM245 DRAGONSKIN	CTCM245 DRAGONSKIN
							
	F	F	M	F	F	F	F
	OFHT	OFHT	OFHT	OFHT	OFHW	OFHT	OFHW
	51 002 ...	51 002 ...	51 003 ...	51 002 ...	51 105 ...	51 002 ...	51 105 ...
ISO / RE inch							
040302EN 0.008					452		90201
040305SN 0.020	305	405	405	455		90501	
P	●	○	○	●	●	●	●
M	●	●	●	●	●	●	●
K							
N							
S						○	○
H							
O							

OFHT / OFHW

NEW

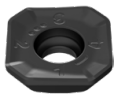
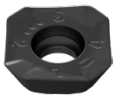
	-M50 CTCK215	-F10 CTPX715	-F10 CTWN215	-F50 CTC5240	CTC5240	-F50 CTCS245
	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	M	F	F	F	F	F
	OFHT	OFHT	OFHT	OFHT	OFHW	OFHT
	51 003 ...	51 122 ...	50 459 ...	51 002 ...	50 457 ...	51 002 ...
ISO / RE inch						
040302EN 0.008					504	
040305FN 0.020		00502	505			
040305SN 0.020	505			15500		555
P		○				
M		○				
K	●	●	○			
N		●	●			
S		○		●	●	●
H						
O		○	○			

SFHT / SFKT

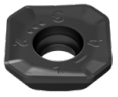
	-F50 CTPP225	-M50 CTPP225
	DRAGONSKIN	DRAGONSKIN
		
	F	M
	SFHT	SFKT
	51 012 ...	51 013 ...
ISO / RE inch		
0903AFSR 0.039	070	070
P	●	●
M		
K		
N		
S		
H		
O		

15

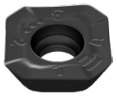
SFHT / SFKT

		-F50 CTCP230 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-F50 CTPP235 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN
					
		F	M	F	M
		SFHT	SFKT	SFHT	SFKT
		51 012 ...	51 013 ...	51 012 ...	51 013 ...
ISO	RE inch				
0903AFSR	0.039	020	020	120	120
P		●	●	●	●
M				○	○
K		○	○	○	○
N					
S					
H					
O					

SFHT / SFKT

		-F50 CTCM235 DRAGONSKIN	-F50 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-F50 CTPM245 DRAGONSKIN	-F50 CTCM245 DRAGONSKIN
						
		F	F	M	F	F
		SFHT	SFHT	SFKT	SFHT	SFHT
		51 012 ...	51 012 ...	51 013 ...	51 012 ...	51 012 ...
ISO	RE inch					
0903AFSR	0.039	320	420	42000	470	92001
P		●	○	○	●	●
M		●	●	●	●	●
K						
N						
S						○
H						
O						

SFKT / SFHT

				NEW					
		-R50 CTCK215		-R50 CTPK220		-F10 CTPX715	-F10 CTWN215	-F40 CTC5240	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
									
		R		R		F	F	F	
		SFKT		SFKT		SFHT	SFHT	SFHT	
		51 065 ...		51 065 ...		51 123 ...	50 514 ...	50 514 ...	
ISO	RE inch								
0903AFFR	0.039					01502	505		
0903AFSR	0.039		520		620				504
P						○			
M						○			
K			●		●	●	○		
N						●	●		
S						○			●
H									
O						○	○		

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 158
Starting Parameter	→ 159	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

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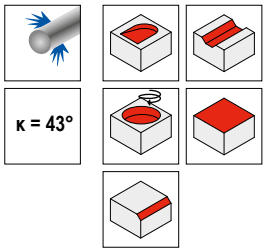
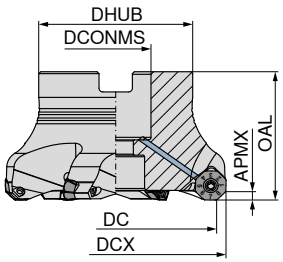
MaxiMill – 274-05/-12 Shell mill





58 772 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert	
A274.200.R.04-12-A075-175-EF	2.000	2.320	4	0.126	1.750	1.750	0.750	18900	3.2	OFHT 0504 / SFKT 1204	**20004**
A274.250.R.05-12-A100-200-EF	2.500	2.820	5	0.126	2.190	2.190	1.000	16700	3.2	OFHT 0504 / SFKT 1204	**25005**
A274.300.R.06-12-A100-200-EF	3.000	3.320	6	0.126	2.190	2.190	1.000	15200	3.2	OFHT 0504 / SFKT 1204	**30006**
A274.400.R.07-12-A125-200-EF	4.000	4.320	7	0.126	2.750	2.750	1.250	13000	3.2	OFHT 0504 / SFKT 1204	**40007**
A274.500.R.08-12-B150-200-EF	5.000	5.320	8	0.126	3.810	3.810	1.500	11600	3.2	OFHT 0504 / SFKT 1204	**50008**
A274.600.R.10-12-B200-200-EF	6.000	6.320	10	0.126	4.880	4.880	2.000	10500	3.2	OFHT 0504 / SFKT 1204	**60010**


Screwdriver

80 950 ...


Molykote

70 950 ...

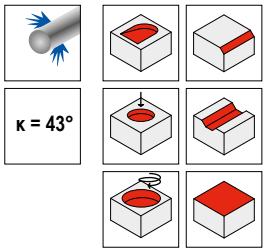

Clamping screw

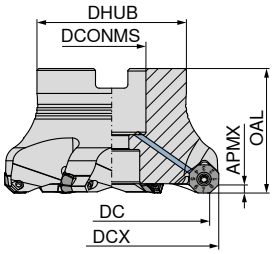
70 950 ...

Spare parts DC			
2.000 - 6.000	**120**	**303**	**340**

Two insert types – ONE Cutter

MaxiMill – 274-05/-12 Shell mill





Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	torque moment Nm	Insert	50 772 ...	50 772 ...
A274.40.R.03-12	40	48.0	3	6	40	38	16	3.2	OFHT 0504 / SFKT 1204	**24000**	
A274.40.R.04-12	40	48.0	4	6	40	38	16	3.2	OFHT 0504 / SFKT 1204		**04000**
A274.50.R.04-12	50	58.0	4	6	40	43	22	3.2	OFHT 0504 / SFKT 1204	**25000**	
A274.50.R.05-12	50	58.0	5	6	40	43	22	3.2	OFHT 0504 / SFKT 1204		**050**
A274.63.R.05-12	63	71.1	5	6	40	48	22	3.2	OFHT 0504 / SFKT 1204	**26300**	
A274.63.R.06-12	63	71.1	6	6	40	48	22	3.2	OFHT 0504 / SFKT 1204		**063**
A274.80.R.06-12	80	88.0	6	6	50	58	27	3.2	OFHT 0504 / SFKT 1204	**28000**	
A274.80.R.08-12	80	88.0	8	6	50	58	27	3.2	OFHT 0504 / SFKT 1204		**080**
A274.100.R.08-12	100	108.0	8	6	50	78	32	3.2	OFHT 0504 / SFKT 1204	**30000**	
A274.100.R.10-12	100	108.0	10	6	50	78	32	3.2	OFHT 0504 / SFKT 1204		**100**
A274.125.R.09-12	125	133.0	9	6	63	88	40	3.2	OFHT 0504 / SFKT 1204	**32500**	
A274.125.R.12-12	125	133.0	12	6	63	88	40	3.2	OFHT 0504 / SFKT 1204		**125**
A274.160.R.11-12	160	168.0	11	6	63	98	40	3.2	OFHT 0504 / SFKT 1204	**36000**[1)]	
A274.160.R.14-12	160	168.0	14	6	63	98	40	3.2	OFHT 0504 / SFKT 1204		**16000**[1)]

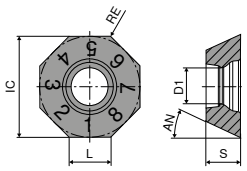
1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

Spare parts DC	TORX® blade	Screwdriver	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
40 - 160	**054**	**128**	**303**	**340**	**193**

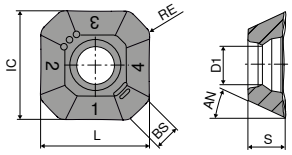
Two insert types – ONE Cutter

OFHT / SFHT / SFKT

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
OFHT 0504..	0.500	0.189	0.177	-	0.187	25
SF.T 1204..	0.500	0.189	0.500	0.056	0.187	25



OF..



SF.T

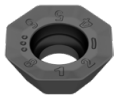
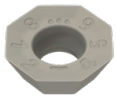
OFHT

	-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	F	M	F	M
	OFHT	OFHT	OFHT	OFHT
	51 002 ...	51 003 ...	51 002 ...	51 003 ...
ISO / RE inch				
050410SN 0.039	010	01000	110	11000
P	●	●	●	●
M			○	○
K	○	○	○	○
N				
S				
H				
O				

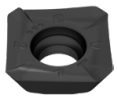
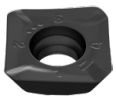
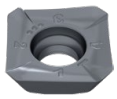
OFHT

	-F50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	F	F	M	F
	OFHT	OFHT	OFHT	OFHT
	51 002 ...	51 002 ...	51 003 ...	51 002 ...
ISO / RE inch				
050410SN 0.039	310	410	41000	460
P	●	○	○	●
M	●	●	●	●
K				
N				
S				
H				
O				

OFHT

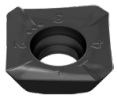
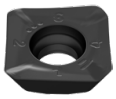
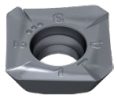
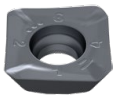
			NEW		
		-F50 CTCM245	-F10 CTPX715	-F10 CTWN215	-F50 CTC5240
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN
					
		F	F	F	F
		OFHT	OFHT	OFHT	OFHT
		51 002 ...	51 122 ...	51 122 ...	51 002 ...
ISO	RE inch				
050410FN	0.039		01002	36000	
050410SN	0.039	91001			16000
P		●	○		
M		●	○		
K			●	○	
N			●	●	
S		○	○		●
H					
O			○	○	

SFHT / SFKT

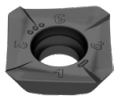
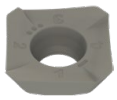
		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		F	M	F	M
		SFHT	SFKT	SFHT	SFKT
		51 012 ...	51 013 ...	51 012 ...	51 013 ...
ISO	RE inch				
1204AFSR	0.039	02500	025	12500	125
P		●	●	●	●
M				○	○
K		○	○	○	○
N					
S					
H					
O					

15

SFHT / SFKT

	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	F	M	F	M
	SFHT	SFKT	SFHT	SFKT
	51 012 ...	51 013 ...	51 012 ...	51 013 ...
ISO / RE inch				
1204AFSR 0.039	325	325	42500	425
P	●	●	○	○
M	●	●	●	●
K				
N				
S				
H				
O				

SFHT

		NEW			
	-F50 CTPM245	-F50 CTCM245	-F10 CTPX715	-F10 CTWN215	-F40 CTC5240
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN
					
	F	F	F	F	F
	SFHT	SFHT	SFHT	SFHT	SFHT
	51 012 ...	51 012 ...	51 123 ...	51 123 ...	50 514 ...
ISO / RE inch					
1204AFER 0.039					50900
1204AFFR 0.039			02502	37000	
1204AFSR 0.039	47500	92501			
P	●	●	○		
M	●	●	○		
K			●	○	
N			●	●	
S		○	○		●
H					
O			○	○	

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 160
Starting Parameter	→ 161	Technical Information	→ 191–197
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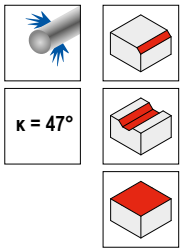
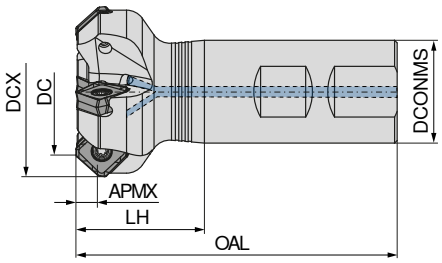
MaxiMill – 271-12 End milling cutter





NEW

58 786 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS $_{h6}$ inch	Insert	
C271.0125.R.03-12-B-150-EF	1.250	1.763	3	0.267	4.000	1.500	1.250	SOHU 1204.. / XOHU 1204..	**01203**
C271.0150.R.04-12-B125-150-EF	1.500	2.013	4	0.267	4.000	1.500	1.250	SOHU 1204.. / XOHU 1204..	**01504**

Screwdriver

80 950 ...

Molykote

70 950 ...

Clamping screw

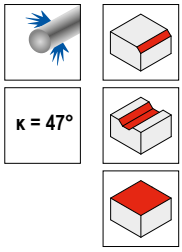
70 950 ...

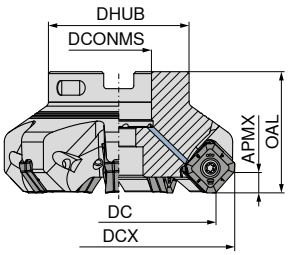
Spare parts DC			
1.250 - 1.500	**128**	**303**	**859**

15

MaxiMill – 271-12 Face mill

▲ 8 cutting edges per insert



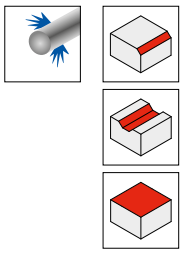


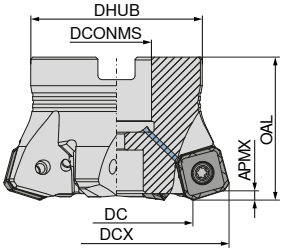
NEW NEW

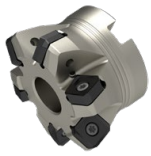
58 787 ... 58 787 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS H6 inch	RPMX 1/min.	torque moment Nm	Insert			
A271.150.R.04-12-A050-175-EF	1.500	2.013	4	0.267	1.750	1.421	0.500	18500	3.2	SOHU 1204.. / XOHU 1204..			**15004**
A271.200.R.05-12-A075-175-EF	2.000	2.512	5	0.267	1.750	1.750	0.750	15100	3.2	SOHU 1204.. / XOHU 1204..			**20005**
A271.250.R.07-12-A100-200-EF	2.500	3.011	7	0.267	2.000	2.250	1.000	13000	3.2	SOHU 1204.. / XOHU 1204..			**25007**
A271.300.R.06-12-A100-200-EF	3.000	3.511	6	0.267	2.000	2.250	1.000	11600	3.2	SOHU 1204.. / XOHU 1204..	**30006**		
A271.300.R.08-12-A100-200-EF	3.000	3.511	8	0.267	2.000	2.250	1.000	9800	3.2	SOHU 1204.. / XOHU 1204..			**30008**
A271.400.R.07-12-A125-200-EF	4.000	4.510	7	0.267	2.000	2.750	1.250	9800	3.2	SOHU 1204.. / XOHU 1204..	**40007**		
A271.400.R.10-12-A125-200-EF	4.000	4.510	10	0.267	2.000	2.750	1.250	9800	3.2	SOHU 1204.. / XOHU 1204..			**40010**
A271.500.R.08-12-B150-200-EF	5.000	5.509	8	0.267	2.000	3.750	1.500	8700	3.2	SOHU 1204.. / XOHU 1204..	**50008**		
A271.500.R.12-12-B150-200-EF	5.000	5.509	12	0.267	2.000	3.750	1.500	8700	3.2	SOHU 1204.. / XOHU 1204..			**50012**
A271.600.R.09-12-B150-200-EF	6.000	6.509	9	0.267	2.000	3.750	1.500	7800	3.2	SOHU 1204.. / XOHU 1204..	**60009**		
A271.600.R.14-12-B150-200-EF	6.000	6.509	14	0.267	2.000	3.750	1.500	7800	3.2	SOHU 1204.. / XOHU 1204..			**60014**

MaxiMill – 271-12 HFC Face mill







NEW

58 787 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS H6 inch	RPMX 1/min.	torque moment Nm	Insert	
A271.200.R.04-12-A075-175-HFC-EF	2.000	2.513	4	0.102	1.750	1.750	0.750	15100	3.2	SOHU 1204..	**20004**
A271.250.R.06-12-A100-200-HFC-EF	2.500	3.013	6	0.102	2.000	2.250	1.000	13000	3.2	SOHU 1204..	**25006**
A271.300.R.07-12-A100-200-HFC-EF	3.000	3.513	7	0.102	2.000	2.250	1.000	11600	3.2	SOHU 1204..	**30007**

Screwdriver

Molykote

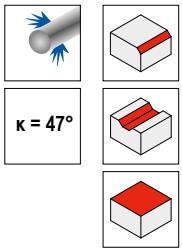
Clamping screw

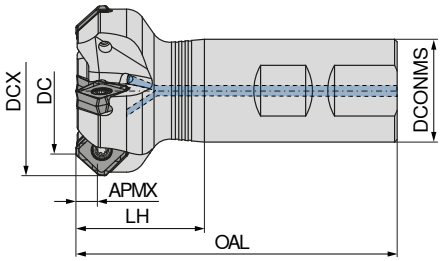
80 950 ... 70 950 ... 70 950 ...

Spare parts

DC			
1.500 - 6.000	**128**	**303**	**859**

MaxiMill – 271-12 End milling cutter





50 786 ...

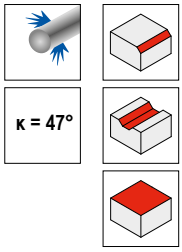
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	torque moment Nm	Insert	
C271.32.R.03-12-B-40	32	45	3	6.8	100	40	32	18400	3.2	SOHU 1204.. / XOHU 1204..	**03203**
C271.40.R.04-12-B32-40	40	53	4	6.8	100	40	32	16800	3.2	SOHU 1204.. / XOHU 1204..	**04004**

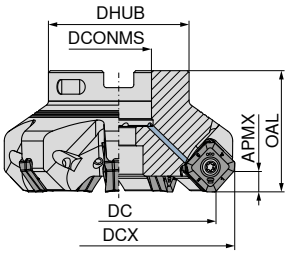
	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts					
DC					
32 - 40	**054**	**120**	**303**	**859**	**193**

15

MaxiMill – 271-12 Face mill

▲ 8 cutting edges per insert

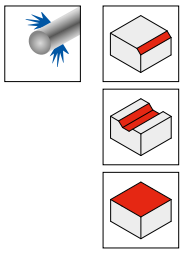


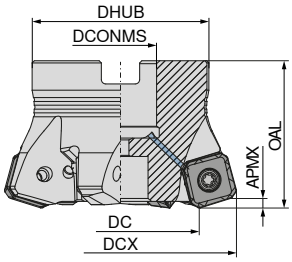


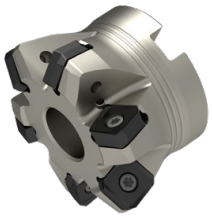
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS H6 mm	RPMX 1/min.	torque moment Nm	Insert	50 787 ...	50 787 ...
A271.40.R.04-12	40	53	4	6.8	40	38	16	17900	3.2	SOHU 1204.. / XOHU 1204..		**04004**
A271.50.R.05-12	50	63	5	6.8	40	43	22	15200	3.2	SOHU 1204.. / XOHU 1204..		**05005**
A271.63.R.07-12	63	76	7	6.8	40	48	22	13100	3.2	SOHU 1204.. / XOHU 1204..		**06307**
A271.80.R.06-12	80	93	6	6.8	50	58	27	11300	3.2	SOHU 1204.. / XOHU 1204..	**08006**	
A271.80.R.08-12	80	93	8	6.8	50	58	27	11300	3.2	SOHU 1204.. / XOHU 1204..		**08008**
A271.100.R.07-12	100	113	7	6.8	63	78	32	9900	3.2	SOHU 1204.. / XOHU 1204..	**10007**	
A271.100.R.10-12	100	113	10	6.8	63	78	32	9900	3.2	SOHU 1204.. / XOHU 1204..		**10010**
A271.125.R.08-12	125	138	8	6.8	63	88	40	8700	3.2	SOHU 1204.. / XOHU 1204..	**12508**	
A271.125.R.12-12	125	138	12	6.8	63	88	40	8700	3.2	SOHU 1204.. / XOHU 1204..		**12512**
A271.160.R.09-12	160	173	9	6.8	63	98	40	7600	3.2	SOHU 1204.. / XOHU 1204..	**16009**[1]	
A271.160.R.14-12	160	173	14	6.8	63	98	40	7600	3.2	SOHU 1204.. / XOHU 1204..		**16014**[1]
A271.200.R.11-12	200	213	11	6.8	63	132	60	6700	3.2	SOHU 1204.. / XOHU 1204..	**20011**[2]	
A271.200.R.17-12	200	213	17	6.8	63	132	60	6700	3.2	SOHU 1204.. / XOHU 1204..		**20017**[2]
A271.250.R.13-12	250	263	13	6.8	63	132	60	6000	3.2	SOHU 1204.. / XOHU 1204..	**25013**[2]	
A271.250.R.21-12	250	263	21	6.8	63	132	60	6000	3.2	SOHU 1204.. / XOHU 1204..		**25021**[2]

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant
2) With threaded holes M16 on the front face, pitch circle diameter = 101.6 mm / Without Through Coolant

MaxiMill – 271-12 HFC Face mill







Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS H6 mm	RPMX 1/min.	torque moment Nm	Insert	50 788 ...
A271.50.R.04-12-HFC	30	50	4	2.6	40	43	22	14600	3.2	SOHU 1204..	**05004**
A271.63.R.06-12-HFC	43	63	6	2.6	40	48	22	12500	3.2	SOHU 1204..	**06306**
A271.80.R.07-12-HFC	60	80	7	2.6	50	58	27	10800	3.2	SOHU 1204..	**08007**

TORX® blade — **80 950 ...**


Clamping key – T — **80 397 ...**


Screwdriver — **80 950 ...**


Power Screw — **70 950 ...**


Molykote — **70 950 ...**


Clamping screw — **70 950 ...**

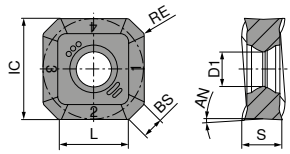

Torque screwdriver — **80 021 ...**


Torque screwdriver — **80 950 ...**

Spare parts DC																	
40 (5078704004)	**054**		**040**		**120**		**151**		**303**		**859**		**030**		**193**		
50 - 250	**054**				**120**				**303**		**859**		**030**		**193**		
50 - 250	**054**				**120**				**303**		**859**				**193**		
50 (5078805004)	**054**		**050**		**120**		**154**		**303**		**859**		**030**		**193**		

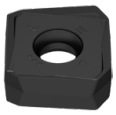
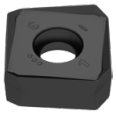
SOHU

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
SOHU 1204..	0.526	0.173	0.346	0.067	0.197	7.4

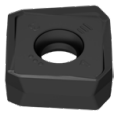
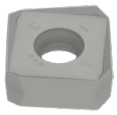


SOHU

SOHU

		-M50 CTCP230	-M50 CTPP235	-M50 CTCM235	-M50 CTPM240	-F50 CTPM245	-F50 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		SOHU	SOHU	SOHU	SOHU	SOHU	SOHU
		51 138 ...	51 138 ...	51 138 ...	51 138 ...	51 140 ...	51 140 ...
ISO	RE inch						
1204ABSR	0.031	02000	12000	32000	42000	47000	92001
P		●	●	●	○	●	●
M			○	●	●	●	●
K		○	○				
N							
S							○
H							
O							

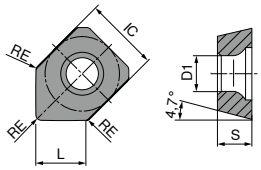
SOHU

		-R50 CTCK215	-R50 CTPK220	-F40 CTC5240	-F50 CTC5240
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SOHU	SOHU	SOHU	SOHU
		51 139 ...	51 139 ...	51 148 ...	51 140 ...
ISO	RE inch				
1204ABSR	0.031	52000	62000	12001	17000
P					
M					
K		●	●		
N					
S				●	●
H					
O					

15

XOHU

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XOHU 1204..	0.526	0.173	0.346	0.072	0.197



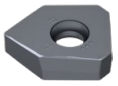
XOHU

XOHU

▲ Masterfinish indexable insert (wiper insert)

-M50
CTPP235

DRAGONSKIN


XOHU

51 141 ...

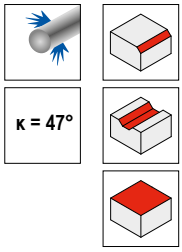
ISO	RE inch	
1204ABSR	0.031	**12000**
P		●
M		○
K		○
N		
S		
H		
O		

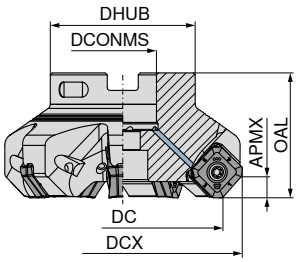
Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 162
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 271-17 Face mill

▲ 8 cutting edges per insert





58 767 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DCONMS inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	
A271.200.R.04-17-A075-175-EF	2.000	2.660	4	0.330	1.750	0.750	1.750	14300	5	SAKU 1706	**20004**
A271.250.R.06-17-A100-200-EF	2.500	3.160	6	0.330	2.250	1.000	2.250	12700	5	SAKU 1706	**25006**
A271.300.R.07-17-A100-200-EF	3.000	3.660	7	0.330	2.250	1.000	2.250	11500	5	SAKU 1706	**30007**
A271.400.R.08-17-B125-200-EF	4.000	4.660	8	0.330	2.750	1.250	2.750	9800	5	SAKU 1706	**40008**
A271.500.R.10-17-B150-200-EF	5.000	5.660	10	0.330	3.750	1.500	3.750	8700	5	SAKU 1706	**50010**
A271-600.R.11-17-B200-250-EF	6.000	6.660	11	0.334	2.500	2.000	3.750	8100	5	SAKU 1706	**60011**
A271.650.R.12-17-C250-250-EF	6.500	7.160	12	0.330	5.120	2.500	5.120	7600	5	SAKU 1706	**65012**

Screwdriver

80 950 ...

Molykote

70 950 ...

Clamping screw

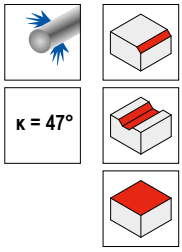
70 950 ...

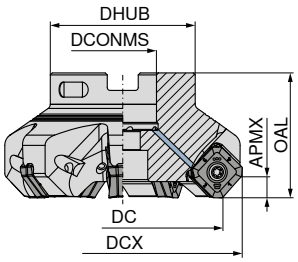
Spare parts DC			
2.000 - 6.500	**106**	**303**	**302**

15

MaxiMill – 271-17 Face mill

▲ 8 cutting edges per insert





50 767 ...

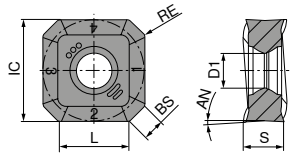
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS mm	DHUB mm	torque moment Nm	Insert	
A271.50.R.04-17	50	66.1	4	8.4	40	22	43	5	SAKU 1706	**050**
A271.63.R.06-17	63	79.1	6	8.4	40	22	48	5	SAKU 1706	**063**
A271.80.R.07-17	80	96.1	7	8.4	50	27	58	5	SAKU 1706	**080**
A271.100.R.08-17	100	116.1	8	8.4	50	32	78	5	SAKU 1706	**100**
A271.125.R.10-17	125	141.1	10	8.4	63	40	88	5	SAKU 1706	**125**
A271.160.R.12-17	160	176.1	12	8.4	63	40	104	5	SAKU 1706	**16000**[1]
A271.200.R.13-17	200	216.1	13	8.4	63	60	134	5	SAKU 1706	**20000**[2]
A271.250.R.15-17	250	266.1	15	8.4	63	60	134	5	SAKU 1706	**25000**[2]

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant
2) With threaded holes M16 on the front face, pitch circle diameter = 101.6 mm / Without Through Coolant

Spare parts DC	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
50 - 250	**037**	**114**	**303**	**302**	**193**

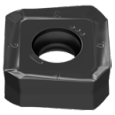
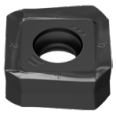
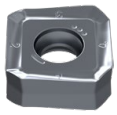
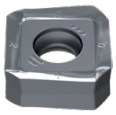
SAKU

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
SAKU 1706..	0.669	0.228	0.467	0.146	0.250	3

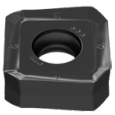
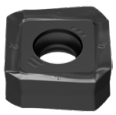
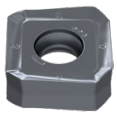


SAKU

SAKU

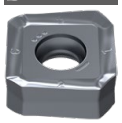
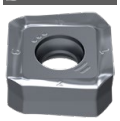
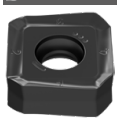
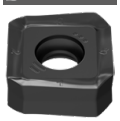
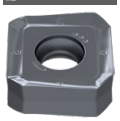
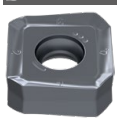
		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SAKU	SAKU	SAKU	SAKU
		51 004 ...	51 005 ...	51 004 ...	51 005 ...
ISO	RE inch				
1706ABSR	0.031	270	270	070	070
P		●	●	●	●
M					
K					
N					
S					
H					
O					

SAKU

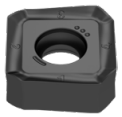
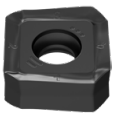
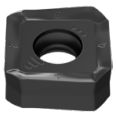
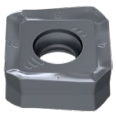
		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SAKU	SAKU	SAKU	SAKU
		51 004 ...	51 005 ...	51 004 ...	51 005 ...
ISO	RE inch				
1706ABSR	0.031	020	020	120	120
P		●	●	●	●
M				○	○
K		○	○	○	○
N					
S					
H					
O					

15

SAKU

	-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	SAKU	SAKU	SAKU	SAKU	SAKU	SAKU	SAKU
	51 004 ...	51 005 ...	51 004 ...	51 005 ...	51 004 ...	51 005 ...	51 004 ...
ISO / RE inch							
1706ABSR 0.031	220	220	320	320	420	420	470
P	●	●	●	●	○	○	●
M	●	●	●	●	●	●	●
K							
N							
S							
H							
O							

SAKU

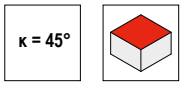
	-F50 CTCM245	-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F50 CTC5240	-F50 CTCS245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	SAKU	SAKU	SAKU	SAKU	SAKU	SAKU	SAKU
	51 004 ...	51 005 ...	51 058 ...	51 005 ...	51 058 ...	50 306 ...	51 004 ...
ISO / RE inch							
1706ABSR 0.031	92001	520	520	620	620	520	570
P	●						
M	●						
K		●	●	●	●		
N							
S	○					●	●
H							
O							

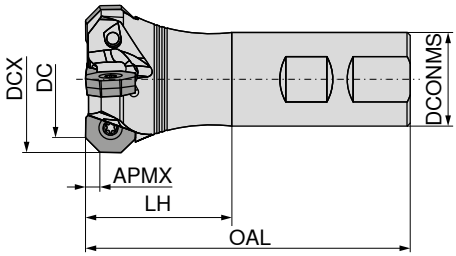
Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 162
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 273-06 End milling cutter

▲ 16 cutting edges per insert

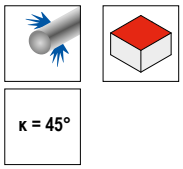


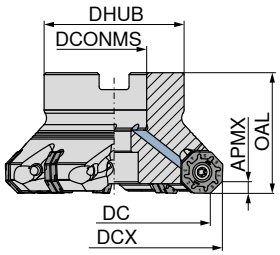


Designation	DC inch	DCX inch	ZNF	APMX inch	DCONMS $_{h6}$ inch	LH inch	OAL inch	torque moment Nm	Insert	58 762 ...
C273.150.R.04-06-B125-125-EF	1.500	1.911	4	0.138	1.250	1.250	3.600	5	OAKU / XAHT 0605	15004
C273.200.R.05-06-B150-125-EF	2.000	2.421	5	0.138	1.500	1.250	4.500	5	OAKU / XAHT 0605	20005

MaxiMill – 273-06 Shell mill

▲ 16 cutting edges per insert





Designation	DC inch	ZNF	APMX inch	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	58 741 ...	58 741 ...
A273.200.R.05-06-A075-175-EF	2.000	5	0.138	1.750	0.750	1.750	14800	5	OAKU / XAHT 0605	20005	
A273.250.R.07-06-A100-200-EF	2.500	7	0.138	2.250	1.000	2.250	13000	5	OAKU / XAHT 0605	25007	
A273.300.R.08-06-A100-200-EF	3.000	8	0.138	2.250	1.000	2.250	11800	5	OAKU / XAHT 0605	30008	
A273.400.R.10-06-B125-200-EF - IC	4.000	10	0.138	2.750	1.250	2.750	10100	5	OAKU / XAHT 0605	40010	
A273.500.R.12-06-B150-200-EF	5.000	12	0.138	3.750	1.500	3.750	8900	5	OAKU / XAHT 0605	50012	
A273.600.R.13-06-B150-250-EF	6.000	13	0.138	3.750	1.500	3.750	7900	5	OAKU / XAHT 0605	60013	
A273.800.R.25-06-C250-250-EF	8.000	25	0.138	6.500	2.500	6.500	2900	5	OAKU / XAHT 0605		80025

Clamping wedge screw

Clamping wedge Face mill

Screwdriver

Molykote

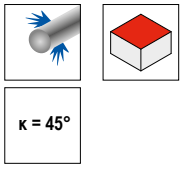
Clamping screw

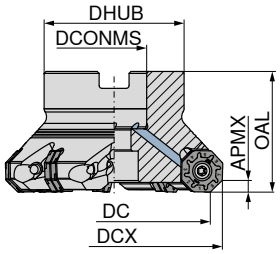
Spare parts DC	70 950 ...	70 950 ...	80 950 ...	70 950 ...	70 950 ...
1.500 - 6.000			106	303	302
8.000	844	845	105	303	

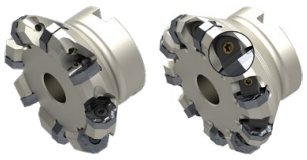
15

MaxiMill – 273-06 Shell mill

▲ 16 cutting edges per insert







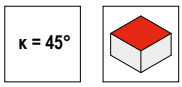
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS mm	DHUB mm	torque moment Nm	Insert	50 741 ...	50 741 ...
A273.40.R.03-06	40	50.2	3	3.5	40	16	38	5	OAKU / XAHT 0605	**040**	
A273.40.R.04-06	40	50.2	4	3.5	40	16	38	5	OAKU / XAHT 0605	**140** [5]	
A273.50.R.05-06	50	60.2	5	3.5	40	22	43	5	OAKU / XAHT 0605	**050**	
A273.63.R.07-06	63	73.2	7	3.5	40	22	48	5	OAKU / XAHT 0605	**063**	
A273.80.R.08-06	80	90.2	8	3.5	50	27	58	5	OAKU / XAHT 0605	**080**	
A273.80.R.10-06	80	90.2	10	3.5	50	27	58	4	OAKU / XAHT 0605		**180** [1]
A273.100.R.10-06	100	110.2	10	3.5	50	32	78	5	OAKU / XAHT 0605	**100**	
A273.100.R.14-06	100	110.2	14	3.5	50	32	78	4	OAKU / XAHT 0605		**200** [1]
A273.125.R.12-06	125	135.2	12	3.5	63	40	88	5	OAKU / XAHT 0605	**125**	
A273.125.R.17-06	125	135.2	17	3.5	63	40	88	4	OAKU / XAHT 0605		**225** [1]
A273.160.R.14-06	160	170.2	14	3.5	63	40	104	5	OAKU / XAHT 0605	**160** [4]	
A273.160.R.20-06	160	170.2	20	3.5	63	40	104	4	OAKU / XAHT 0605		**260** [2]
A273.200.R.25-06	200	210.2	25	3.5	63	60	153	4	OAKU / XAHT 0605		**300** [3]
A273.250.R.31-06	250	260.2	31	3.5	63	60	153	4	OAKU / XAHT 0605		**25031** [3]

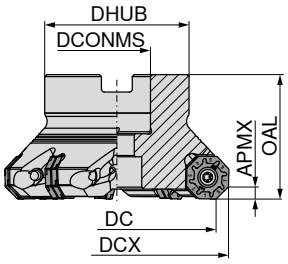
1) Version with Wedge, without internal coolant supply
2) Version with Wedge, without internal coolant supply / With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm
3) Version with Wedge, without internal coolant supply / With threaded holes M16 on the front face, pitch circle diameter = 101.6 mm
4) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant
5) Without Through Coolant

Spare parts DC	TORX® blade 80 950 ...	 Clamping key – T 80 397 ...	 Clamping wedge screw 70 950 ...	 Clamping wedge Face mill 70 950 ...	 Screwdriver 80 950 ...	 Power Screw 70 950 ...	 Clamping screw 70 950 ...	 Torque screwdriver 80 950 ...
40	**037**	**040**			**114**	**151**	**302**	**193**
50	**037**	**050**			**114**	**154**	**302**	**193**
63 - 80	**037**				**114**		**302**	**193**
80 - 100	**036**		**844**	**845**	**113**			**193**
100 - 125	**037**				**114**		**302**	**193**
125	**036**		**844**	**845**	**113**			**193**
160	**037**				**114**		**302**	**193**
160 - 250	**036**		**844**	**845**	**113**			**193**

MaxiMill – 273-06 Shell mill

▲ 16 cutting edges per indexable insert
▲ Axially adjustable





50 777 ...

Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	torque moment Nm	Insert	
A273.80.R.10A10-06	80	90.2	10	3.5	50	27	58	4	OAKU / XAHT 0605	**08010**[1)]
A273.100.R.14A14-06	100	110.2	14	3.5	50	32	78	4	OAKU / XAHT 0605	**10014**[1)]
A273.125.R.17A17-06	125	135.2	17	3.5	63	40	88	4	OAKU / XAHT 0605	**12517**[1)]
A273.160.R.20A20-06	160	170.2	20	3.5	63	40	104	4	OAKU / XAHT 0605	**16020**[2)]
A273.200.R.25A25-06	200	210.2	25	3.5	63	60	153	4	OAKU / XAHT 0605	**20025**[3)]
A273.250.R.31A31-06	250	260.2	31	3.5	63	60	153	4	OAKU / XAHT 0605	**25031**[3)]

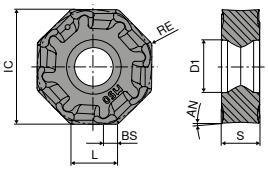
1) Version with Wedge
2) Version with Wedge / With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm
3) Version with Wedge / With threaded holes M16 on the front face, pitch circle diameter = 101.6 mm

	TORX® blade	 Clamping wedge screw	 Clamping wedge Face mill	Screwdriver	 Molykote	 Wedge	 Torque screwdriver
	80 950 ...	**70 950 ...**	**70 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
80 - 250	**036**	**844**	**845**	**113**	**303**	**199**	**193**

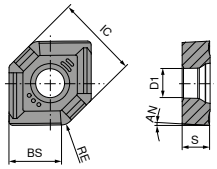
15

OAKU / XAHT

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
XAHT 0605..	0.672	0.236	-	0.470	0.219	3
OAKU 0605..	0.673	0.228	0.236	0.079	0.223	3

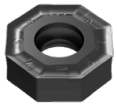
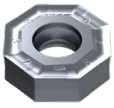


OAKU

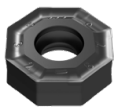
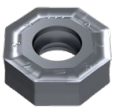


XAHT

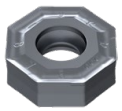
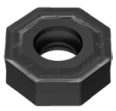
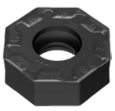
OAKU

	-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	OAKU	OAKU	OAKU	OAKU
	51 000 ...	51 001 ...	51 000 ...	51 001 ...
ISO RE inch				
060508SR 0.031	**258**	**258**	**058**	**058**
P	●	●	●	●
M				
K				
N				
S				
H				
O				

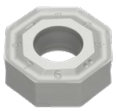
OAKU

	-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	OAKU	OAKU	OAKU	OAKU
	51 000 ...	51 001 ...	51 000 ...	51 001 ...
ISO RE inch				
060508SR 0.031	**008**	**008**	**108**	**108**
P	●	●	●	●
M			○	○
K	○	○	○	○
N				
S				
H				
O				

OAKU

	-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F40 CTPM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	OAKU	OAKU	OAKU	OAKU	OAKU	OAKU	OAKU
	51 000 ...	51 001 ...	51 000 ...	51 001 ...	51 000 ...	51 001 ...	51 104 ...
ISO / RE inch							
060508ER 0.031							458
060508SR 0.031	208	208	308	308	408	408	
P	●	●	●	●	○	○	●
M	●	●	●	●	●	●	●
K							
N							
S							
H							
O							

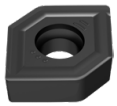
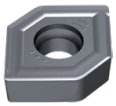
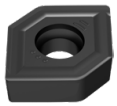
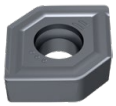
OAKU

	-F40 CTCM245	-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F40 CTC5240	-F40 CTCS245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	OAKU	OAKU	OAKU	OAKU	OAKU	OAKU	OAKU
	51 104 ...	51 001 ...	51 027 ...	51 001 ...	51 027 ...	50 446 ...	51 104 ...
ISO / RE inch							
060508ER 0.031	90801					550	50801
060508SR 0.031		508	508	608	608		
P	●						
M	●						
K		●	●	●	●		
N							
S	○					●	●
H							
O							

15

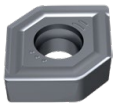
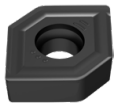
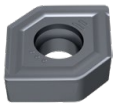
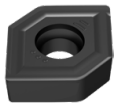
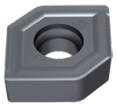
XAHT

▲ Masterfinish indexable insert (wiper insert)

	-M50 CTCP220 DRAGONSKIN	-M50 CTPP225 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN
				
	XAHT	XAHT	XAHT	XAHT
	51 014 ...	51 014 ...	51 014 ...	51 014 ...
ISO / RE inch				
060525SR 0.098	275	075	025	125
P	●	●	●	●
M				○
K			○	○
N				
S				
H				
O				

XAHT

▲ Masterfinish indexable insert (wiper insert)

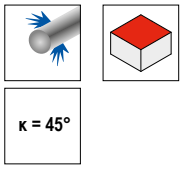
	-M50 CTPM225 DRAGONSKIN	-M50 CTCM235 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-M50 CTCK215 DRAGONSKIN	-M50 CTPK220 DRAGONSKIN
					
	XAHT	XAHT	XAHT	XAHT	XAHT
	51 014 ...	51 014 ...	51 014 ...	51 014 ...	51 014 ...
ISO / RE inch					
060525SR 0.098	225	325	425	525	625
P	●	●	○		
M	●	●	●		
K				●	●
N					
S					
H					
O					

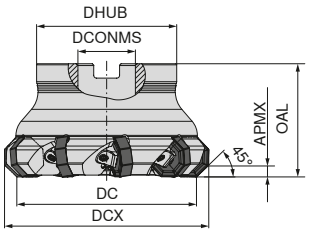
Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 163
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 273-08 Shell mill

▲ 16 cutting edges per insert





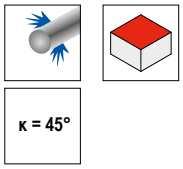
Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	torque moment Nm	Insert	58 783 ...	58 783 ...
A273.250.R.05-08-A100-200-EF	2.500	3.039	5	0.197	2.000	1.000	2.250	5	ONKU 0806	**25005**	
A273.250.R.06-08-A100-200-EF	2.500	3.039	6	0.197	2.000	1.000	2.250	4	ONKU 0806		**25006**
A273.300.R.06-08-A100-200-EF	3.000	3.539	6	0.197	2.000	1.000	2.250	5	ONKU 0806	**30006**	
A273.300.R.08-08-A100-200-EF	3.000	3.539	8	0.197	2.000	1.000	2.250	4	ONKU 0806		**30008**
A273.400.R.07-08-A125-200-EF	4.000	4.539	7	0.197	2.500	1.250	2.750	5	ONKU 0806	**40007**	
A273.400.R.09-08-A125-200-EF	4.000	4.539	9	0.197	2.500	1.250	2.750	4	ONKU 0806		**40009**
A273.500.R.08-08-A150-250-EF	5.000	5.539	8	0.197	2.500	1.500	3.750	5	ONKU 0806	**50008**[1)]	
A273.500.R.11-08-A150-250-EF	5.000	5.539	11	0.197	2.500	1.500	3.750	4	ONKU 0806		**50011**[1)]
A273.600.R.10-08-A150-250-EF	6.000	6.539	10	0.197	2.500	1.500	3.750	5	ONKU 0806	**60010**	
A273.600.R.14-08-A150-250-EF	6.000	6.539	14	0.197	2.500	1.500	3.750	4	ONKU 0806		**60014**

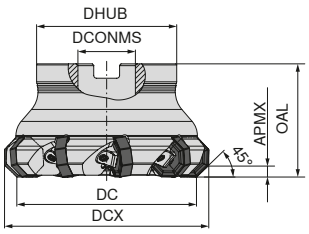
1) Not in stock

Spare parts for Article no.	TORX® blade 80 950 ...	Clamping wedge screw 70 950 ...	Clamping wedge Face mill 70 950 ...	Screwdriver 80 950 ...	Molykote 70 950 ...	Clamping screw 70 950 ...	Torque screwdriver 80 950 ...
58 783 25005	**055**	**844**	**845**	**129**	**303**	**821**	**193**
58 783 25006	**036**	**844**	**845**	**113**	**303**		**193**
58 783 30006	**055**	**844**	**845**	**129**	**303**	**821**	**193**
58 783 30008	**036**	**844**	**845**	**113**	**303**		**193**
58 783 40007	**055**	**844**	**845**	**129**	**303**	**821**	**193**
58 783 40009	**036**	**844**	**845**	**113**	**303**		**193**
58 783 50008	**055**	**844**	**845**	**129**	**303**	**821**	**193**
58 783 50011	**036**	**844**	**845**	**113**	**303**		**193**
58 783 60010	**055**	**844**	**845**	**129**	**303**	**821**	**193**
58 783 60014	**036**	**844**	**845**	**113**	**303**		**193**

MaxiMill – 273-08 Shell mill

▲ 16 cutting edges per insert





NEW NEW

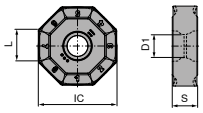
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	torque moment Nm	Insert	50 779 ...	50 779 ...
A273.63.R.05-08	63	76.7	5	5	50	22	48	5	ONKU 0806	**06300**	
A273.63.R.06-08	63	76.7	6	5	50	22	48	5	ONKU 0806		**16300**[1]
A273.80.R.06-08	80	93.7	6	5	50	27	58	5	ONKU 0806	**08000**	
A273.80.R.08-08	80	93.7	8	5	50	27	58	4	ONKU 0806		**18000**[1]
A273.100.R.07-08	100	113.7	7	5	63	32	78	5	ONKU 0806	**10000**	
A273.100.R.09-08	100	113.7	9	5	63	32	78	4	ONKU 0806		**20000**[1]
A273.125.R.08-08	125	138.7	8	5	63	40	88	5	ONKU 0806	**12500**	
A273.125.R.11-08	125	138.7	11	5	63	40	88	4	ONKU 0806		**22500**[1]
A273.160.R.10-08	160	173.7	10	5	63	40	98	5	ONKU 0806	**16000**[3]	
A273.160.R.14-08	160	173.7	14	5	63	40	98	4	ONKU 0806		**26000**[2]

1) Version with Wedge
2) Version with Wedge, without internal coolant supply / With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm
3) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

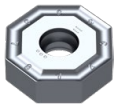
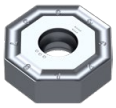
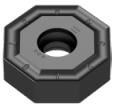
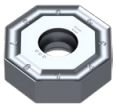
Spare parts for Article no.	TORX® blade	Clamping wedge screw	Clamping wedge Face mill	Screwdriver	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**70 950 ...**	**70 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
50 779 06300	**055**			**129**	**303**	**821**	**193**
50 779 16300	**036**	**844**	**845**	**113**	**303**		**193**
50 779 08000	**055**			**129**	**303**	**821**	**193**
50 779 18000	**036**	**844**	**845**	**113**	**303**		**193**
50 779 10000	**055**			**129**	**303**	**821**	**193**
50 779 20000	**036**	**844**	**845**	**113**	**303**		**193**
50 779 12500	**055**			**129**	**303**	**821**	**193**
50 779 22500	**036**	**844**	**845**	**113**	**303**		**193**
50 779 16000	**055**			**129**	**303**	**821**	**193**
50 779 26000	**036**	**844**	**845**	**113**	**303**		**193**

ONKU

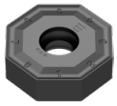
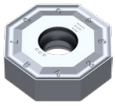
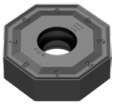
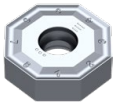
Designation	IC inch	D1 inch	L inch	S inch
ONKU 0806..	0.866	0.228	0.333	0.254



ONKU

		NEW	NEW	NEW	NEW	NEW
		-M50 CTCP230	-M50 CTPP235	-M50 CTPM240	-M50 CTCK215	-M50 CTPK220
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		ONKU	ONKU	ONKU	ONKU	ONKU
		51 163 ...	51 163 ...	51 163 ...	51 163 ...	51 163 ...
ISO	RE inch					
080608SN	0.031	00800	10800	20800	50800	60800
P		●	●	○		
M			○	●		
K		○	○		●	●
N						
S						
H						
O						

ONKU

		NEW	NEW	NEW	NEW
		-R50 CTCP230	-R50 CTPP235	-R50 CTCK215	-R50 CTPK220
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		ONKU	ONKU	ONKU	ONKU
		51 164 ...	51 164 ...	51 164 ...	51 164 ...
ISO	RE inch				
080608SN	0.031	00800	10800	50800	60800
P		●	●		
M			○		
K		○	○	●	●
N					
S					
H					
O					

Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 163
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

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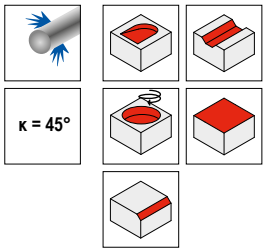
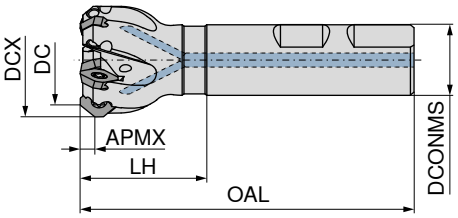
MaxiMill – 270-09 End milling cutter 45°



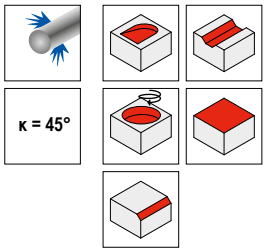


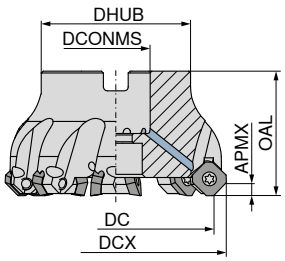
58 666 ...

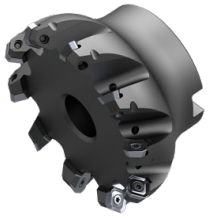
Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	torque moment Nm	Insert	
C270.0500.R.01-09-B0625-125-EF	0.500	0.830	1	0.157	3.250	1.250	0.625	1.2	SD.. 0903..	**05001**
C270.0500.R.01-09-B075-125-EF	0.500	0.830	1	0.157	3.250	1.250	0.750	1.2	SD.. 0903..	**05101**
C270.0750.R.03-09-B075-150-EF	0.750	1.080	3	0.157	3.500	1.500	0.750	1.8	SD.. 0903..	**07503**[1)]
C270.0750.R.03-09-B100-150-EF	0.750	1.080	3	0.157	3.500	1.500	1.000	1.8	SD.. 0903..	**07603**
C270.100.R.04-09-B075-150-EF	1.000	1.330	4	0.157	3.500	1.500	0.750	1.8	SD.. 0903..	**10004**
C270.100.R.04-09-B100-150-EF	1.000	1.330	4	0.157	3.500	1.500	1.000	1.8	SD.. 0903..	**10104**
C270.125.R.05-09-B075-175-EF	1.250	1.580	5	0.157	3.750	1.750	0.750	1.8	SD.. 0903..	**12505**
C270.125.R.05-09-B100-175-EF	1.250	1.580	5	0.157	3.750	1.750	1.000	1.8	SD.. 0903..	**12605**
C270.150.R.05-09-B075-200-EF	1.500	1.830	5	0.157	4.000	2.000	0.750	1.8	SD.. 0903..	**15005**
C270.150.R.05-09-B100-200-EF	1.500	1.830	5	0.157	4.000	2.000	1.000	1.8	SD.. 0903..	**15105**

1) Not in stock

MaxiMill – 270-09 Shell mill 45°







right

58 705 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert	
A270.200.R.06-09-A075-175-EF	2.000	2.330	6	0.157	1.750	1.750	0.750	10700	1.8	SD.. 0903..	**20006**
A270.250.R.08-09-A100-200-EF	2.500	2.830	8	0.157	2.250	2.250	1.000	8500	1.8	SD.. 0903..	**25008**
A270.300.R.10-09-A100-200-EF	3.000	3.330	10	0.157	2.250	2.250	1.000	6700	1.8	SD.. 0903..	**30010**

Screwdriver

80 950 ...

Molykote

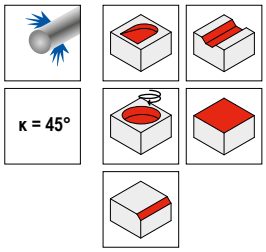
70 950 ...

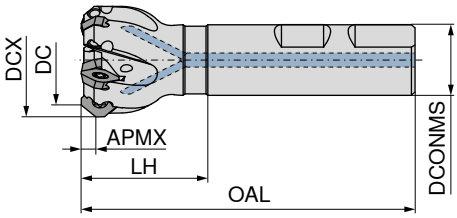
Clamping screw

70 950 ...

Spare parts DC			
0.500	**102**	**303**	**365**
0.750 - 3.000	**102**	**303**	**115**

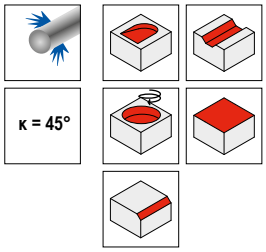
MaxiMill – 270-09 End milling cutter

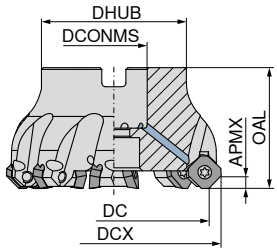




										50 666 ...
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	torque moment Nm	Insert	
C270.06.R.01-09	6	14.4	1	4	80	32	16	1.2	SD.. 0903..	**006**
C270.12.R.01-09	12	20.4	1	4	80	32	16	1.2	SD.. 0903..	**012**
C270.16.R.02-09	16	24.4	2	4	90	40	20	1.8	SD.. 0903..	**016**
C270.20.R.03-09	20	28.4	3	4	90	40	20	1.8	SD.. 0903..	**020**
C270.25.R.04-09	25	33.4	4	4	100	44	25	1.8	SD.. 0903..	**025**
C270.32.R.05-09	32	40.4	5	4	95	36	25	1.8	SD.. 0903..	**032**

MaxiMill – 270-09 Shell mill





										50 705 ...	50 706 ...
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	torque moment Nm	Insert		
A270.32.R.05-09	32	40.4	5	4	40	34	16	1.8	SD../XD.. 0903..		**532**
A270.40.R.04-09	40	48.4	4	4	40	38	16	1.8	SD../XD.. 0903..	**540**	
A270.40.R.06-09	40	48.4	6	4	40	38	16	1.8	SD../XD.. 0903..		**540**
A270.50.R.06-09	50	58.4	6	4	40	43	22	1.8	SD../XD.. 0903..	**550**	
A270.50.R.08-09	50	58.4	8	4	40	43	22	1.8	SD../XD.. 0903..		**550**
A270.63.R.08-09	63	71.4	8	4	40	48	22	1.8	SD../XD.. 0903..	**563**	
A270.63.R.10-09	63	71.4	10	4	40	48	22	1.8	SD../XD.. 0903..		**563**
A270.80.R.10-09	80	88.4	10	4	50	58	27	1.8	SD../XD.. 0903..	**580**	
A270.80.R.12-09	80	88.4	12	4	50	58	27	1.8	SD../XD.. 0903..		**580**
A270.100.R.12-09	100	108.4	12	4	50	78	32	1.8	SD../XD.. 0903..	**600**	
A270.100.R.14-09	100	108.4	14	4	50	78	32	1.8	SD../XD.. 0903..		**600**
A270.125.R.12-09	125	133.4	12	4	63	88	40	1.8	SD../XD.. 0903..	**625**	

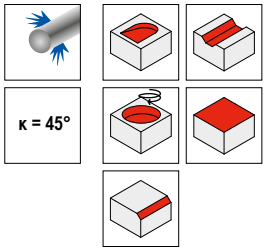
▲ 50 705 ... Normal pitch for a broad spectrum of use on aluminum alloys, non-ferrous metals, and soft steel materials
▲ 50 706 ... Fine pitch for highest feed rates, predominantly used on steel and cast materials

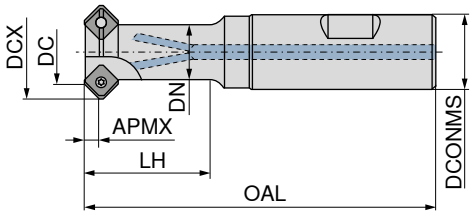
	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts **DC**					
6 - 12	**033**	**110**	**303**	**365**	**191**
16 - 125	**033**	**110**	**303**	**115**	**191**

15

MaxiMill – 272-09 Chamfer milling cutter

▲ Usable on front and rear cutting edges





58 669 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	torque moment Nm	Insert	
C272.0500.R.01-09-B-100-EF	0.500	0.830	1	0.157	3.250	1.000	0.625	1.2	SD.. 0903..	**05001**

Screwdriver

80 950 ...


Molykote

70 950 ...


Clamping screw

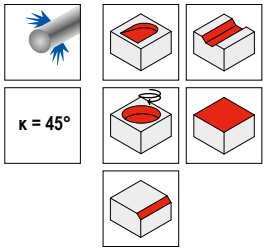
70 950 ...

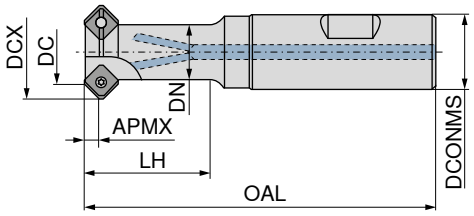
Spare parts

DC			
0.500	**102**	**303**	**365**

MaxiMill – 272-09 Chamfer milling cutter

▲ Usable on front and rear cutting edges





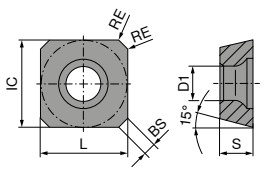
50 669 ...

Designation	DC mm	DCX mm	ZNF	APMX mm	DN mm	OAL mm	LH mm	DCONMS mm	torque moment Nm	Insert	
C272.06.R.01-09	6	14.4	1	4	10	91	24.0	16	1.2	SD.. 0903..	**10600**
C272.08.R.01-09	8	16.4	1	4	10	91	25.5	16	1.2	SD.. 0903..	**008**
C272.12.R.01-09	12	20.4	1	4	12	91	26.0	16	1.2	SD.. 0903..	**012**
C272.16.R.02-09	16	24.4	2	4	15	97	30.0	20	1.8	SD.. 0903..	**016**
C272.18.R.02-09	18	26.4	2	4	16	97	30.0	20	1.8	SD.. 0903..	**018**
C272.25.R.03-09	25	33.4	3	4	21	109	35.0	25	1.8	SD.. 0903..	**025**

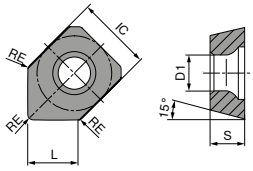
	TORX® blade	Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts DC					
6 - 12	**033**	**110**	**303**	**365**	**191**
16 - 25	**033**	**110**	**303**	**115**	**191**

SDHW / SDNT / SDHT / XDHW

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XDHW 0903..	0.375	0.134	0.217	0.066	0.125
SD.. 0903..	0.375	0.134	0.375	0.066	0.125

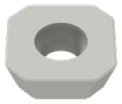
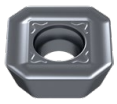
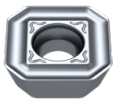
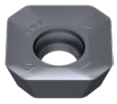


SD..

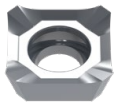
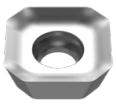


XDHW

SDHW / SDNT / SDHT

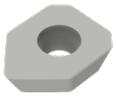
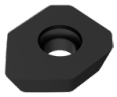
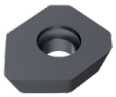
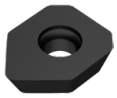
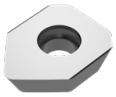
	TCM10	-29 CTCP230	-29 CTPP235	-33 CTPM240	-33P CTPM240	-F50 CTPM245	-F50 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	CERMET						
	SDHW	SDNT	SDNT	SDHT	SDHT	SDHT	SDHT
	50 428 ...	51 011 ...	51 011 ...	51 028 ...	51 086 ...	51 109 ...	51 109 ...
ISO / RE inch							
0903AESN 0.039	898	020	120	420	420	470	92001
P	●	●	●	○	○	●	●
M			○	●	●	●	●
K	○	○	○				
N							
S							○
H							
O							

SDNT / SDHT

			NEW			
	-31 CTCK215	-F10 CTPX715	-27P H216T	-M31 CTC5240	-F50 CTCS245
	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
					
	SDNT	SDHT	SDHT	SDHT	SDHT
	51 029 ...	51 160 ...	50 426 ...	50 421 ...	51 109 ...
ISO / RE inch					
0903AEFN 0.039		02002	548		
0903AESN 0.039	520			509	57100
P		○			
M		○			
K	●	●	○		
N		●	●		
S		○		●	●
H					
O		○	○		

XDHW

▲ Masterfinish indexable insert (wiper insert)

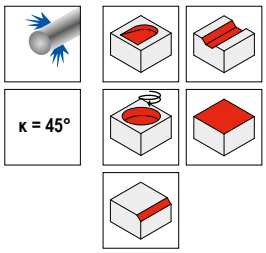
		TCM10	CTCP230 DRAGONSKIN	CTPP235 DRAGONSKIN	CTCK215 DRAGONSKIN	H216T
						
		CERMET XDHW	XDHW	XDHW	XDHW	XDHW
		50 449 ...	51 015 ...	51 015 ...	51 015 ...	50 449 ...
ISO	RE inch					
0903AEEN	0.039				520	
0903AEFN	0.039					548
0903AESN	0.039	898	020	120		
P		●	●	●		
M				○		
K		○	○	○	●	○
N						●
S						
H						
O						○

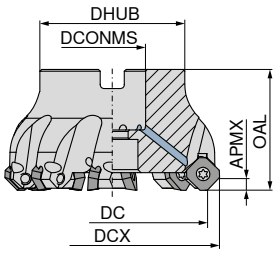
Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 164
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 270-12 Shell mill 45°

▲ 50 705 ... Normal pitch for a broad spectrum of use on aluminum alloys, non-ferrous metals, up to soft steel materials
▲ 50 706 ... Predominantly fine pitch for highest feed rates, use on steel and cast materials





58 705 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	DCONMS $_{H6}$ inch	OAL inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	
A270.200.R.04-12-A075-175-EF	2.000	2.550	4	0.236	0.750	1.750	1.750	10700	5	SD.. 1204..	**20104**
A270.250.R.05-12-A100-200-EF	2.500	3.050	5	0.236	1.000	2.250	2.250	8500	5	SD.. 1204..	**25105**
A270.300.R.06-12-A100-200-EF	3.000	3.550	6	0.236	1.000	2.250	2.250	6700	5	SD.. 1204..	**30106**
A270.400.R.06-12-B125-200-EF	4.000	4.550	6	0.236	1.250	2.750	2.750	5400	5	SD.. 1204..	**40106**
A270.500.R.07-12-B150-200-EF	5.000	5.550	7	0.236	1.500	3.750	3.750	4300	5	SD.. 1204..	**50107**
A270.600.R.08-12-B150-200-EF	6.000	6.660	8	0.236	1.500	3.750	3.750	3500	5	SD.. 1204..	**60108**


Screwdriver


Molykote


Clamping screw

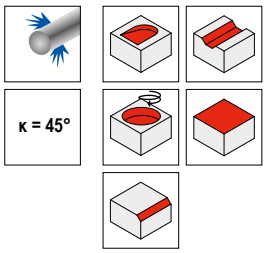
80 950 ... | **70 950 ...** | **70 950 ...**

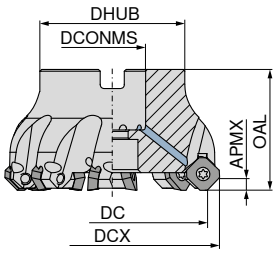
Spare parts

DC			
2.000 - 6.000	**106**	**303**	**01200**

MaxiMill – 270-12 Shell mill

▲ 50 705 ... Normal pitch for a broad spectrum of use on aluminum alloys, non-ferrous metals, up to soft steel materials
▲ 50 706 ... Predominantly fine pitch for highest feed rates, use on steel and cast materials





Designation	DC mm	DCX mm	ZNF	APMX mm	DCONMS H6 mm	OAL mm	DHUB mm	torque moment Nm	Insert	50 705 ...	50 706 ...
A270.40.R.03-12	40	54	3	6	16	40	38	5	SD../XD.. 1204..	**040**	
A270.40.R.04-12	40	54	4	6	16	40	38	5	SD../XD.. 1204..		**040**
A270.50.R.04-12	50	64	4	6	22	40	43	5	SD../XD.. 1204..	**050**	
A270.50.R.05-12	50	64	5	6	22	40	43	5	SD../XD.. 1204..		**050**
A270.63.R.04-12	63	77	4	6	22	40	48	5	SD../XD.. 1204..	**063**	
A270.63.R.06-12	63	77	6	6	22	40	48	5	SD../XD.. 1204..		**063**
A270.80.R.05-12	80	94	5	6	27	50	58	5	SD../XD.. 1204..	**080**	
A270.80.R.08-12	80	94	8	6	27	50	58	5	SD../XD.. 1204..		**080**
A270.100.R.06-12	100	114	6	6	32	50	78	5	SD../XD.. 1204..	**100**	
A270.100.R.10-12	100	114	10	6	32	50	78	5	SD../XD.. 1204..		**100**
A270.125.R.07-12	125	139	7	6	40	63	88	5	SD../XD.. 1204..	**125**	
A270.125.R.12-12	125	139	12	6	40	63	88	5	SD../XD.. 1204..		**125**
A270.160.R.08-12	160	174	8	6	40	63	94	5	SD../XD.. 1204..	**160** [1]	

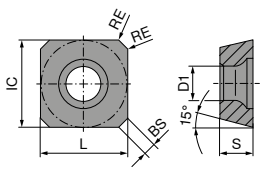
1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

Spare parts DC	TORX® blade **80 950 ...**	 Clamping key – T **80 397 ...**	 Screwdriver **80 950 ...**	 Power Screw **70 950 ...**	 Molykote **70 950 ...**	 Clamping screw **70 950 ...**	 Torque screwdriver **80 950 ...**
40	**037**	**040**	**114**	**151**	**303**	**01200**	**193**
50 - 160	**037**		**114**		**303**	**01200**	**193**

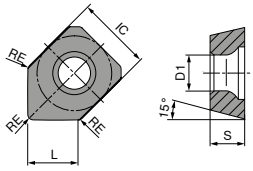
15

SDHT / SDHW / SDMT / XDHW

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XDHW 1204..	0.500	0.217	0.295	0.069	0.187
SD.. 1204..	0.500	0.217	0.500	0.069	0.187



SD..

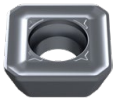


XDHW

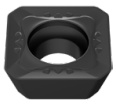
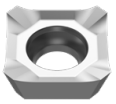
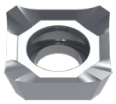
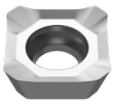
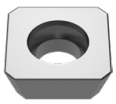
SDHT / SDHW / SDMT

	TCM10	-R TCM10	-29R CTCP230	-R CTCP230	CTCP230
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
	CERMET SDHT	**CERMET** SDHW	SDMT	SDHT	SDHW
	50 426 ...	**50 428 ...**	**51 010 ...**	**51 006 ...**	**51 008 ...**
ISO RE inch					
1204AESN 0.008	**900**				
1204AESN 0.039		**899**	**020**	**020**	**020**
P	●	●	●	●	●
M					
K	○	○	○	○	○
N					
S					
H					
O					

SDMT / SDHT / SDHW

	-29R CTPP235	-R CTPP235	-R CTPP235	-33 CTPM240	-F50 CTPM245	-F50 CTCM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	SDMT	SDHT	SDHW	SDHT	SDHT	SDHT
	51 010 ...	**51 006 ...**	**51 008 ...**	**51 028 ...**	**51 109 ...**	**51 109 ...**
ISO RE inch						
1204AESN 0.039	**120**	**120**	**120**	**425**	**475**	**92501**
P	●	●	●	○	●	●
M	○	○	○	●	●	●
K	○	○	○			
N						
S						○
H						
O						

SDMT / SDHW / SDHT

	-31 CTCK215	-R CTCK215	-27 H216T	NEW -F10 CTPX715	-27P H216T	H216T
	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN		
						
	SDMT	SDHW	SDHT	SDHT	SDHT	SDHW
	51 059 ...	51 008 ...	50 426 ...	51 160 ...	50 426 ...	50 428 ...
ISO / RE inch						
1204AEEN 0.039	520	520				
1204AEFN 0.008			504	02502		
1204AEFN 0.039					554	
1204AESN 0.008						600
P				○		
M				○		
K	●	●	○	●	○	○
N			●	●	●	●
S				○		
H						
O			○	○	○	○

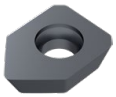
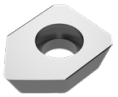
SDHT

	-M31 CTC5240	-F50 CTCS245
	DRAGONSKIN	DRAGONSKIN
		
	SDHT	SDHT
	50 421 ...	51 109 ...
ISO / RE inch		
1204AESN 0.039	512	57600
P		
M		
K		
N		
S	●	●
H		
O		

15

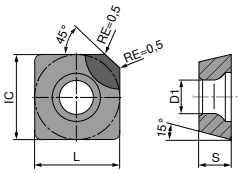
XDHW

▲ Masterfinish indexable insert (wiper insert)

		TCM10	CTCP230 DRAGONSKIN	CTPP235 DRAGONSKIN	CTCK215 DRAGONSKIN	H216T
						
		CERMET XDHW	XDHW	XDHW	XDHW	XDHW
		50 449 ...	**51 015 ...**	**51 015 ...**	**51 015 ...**	**50 449 ...**
ISO	RE inch					
1204AEEN	0.039				**525**	
1204AEFN	0.039					**600**
1204AESN	0.039	**900**	**025**	**125**		
P		●	●	●		
M				○		
K		○	○	○	●	○
N						●
S						
H						
O						○

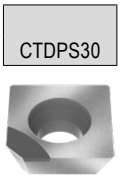
SDHW

Designation	IC inch	D1 inch	L inch	S inch
SDHW 1204..	0.500	0.217	0.500	0.187



SDHW

SDHW


CTDPS30


CTBS10U

DIAMOND SDHW
51 900 ...

CBN SDHW
51 900 ...

ISO		
1204AEFN-2	100 [1]	
1204AEFN-3	102 [2]	
1204AETN-2		300 [1]
P		
M		
K		●
N	●	
S		
H		○
O		

1) $a_{p\,max.}$ = 2.0 mm
2) $a_{p\,max.}$ = 3.5 mm

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 164
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

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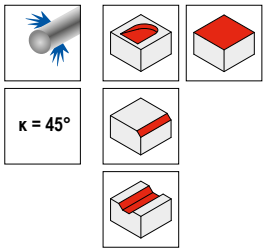
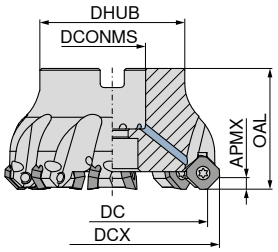
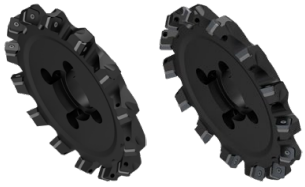
MaxiMill – 270-19 Shell mill







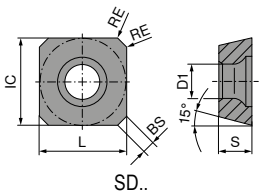
									Left-hand	Right-hand
									50 698 ...	**50 698 ...**
Designation	DC mm	DCX mm	ZNF	APMX mm	DCONMS $_{H6}$ mm	OAL mm	DHUB mm	torque moment Nm	Insert	
A270.125.R.07-19	125	146.4	7	10	40	63	88	5	SD.. 1907..	**12507**
A270.160.R.09-19	160	181.4	9	10	40	63	104	5	SD.. 1907..	**16009**[1)]
A270.200.R.11-19	200	221.1	11	10	60	63	134	5	SD.. 1907..	**20011**[2)]
A270.250.L.14-19	250	271.4	14	10	60	63	134	5	SD.. 1907..	**75014**[2)]
A270.250.R.14-19	250	271.4	14	10	60	63	134	5	SD.. 1907..	**25014**[2)]
A270.315.L.17-19	315	336.4	17	10	60	63	226	5	SD.. 1907..	**81517**[4)]
A270.315.R.17-19	315	336.4	17	10	60	63	226	5	SD.. 1907..	**31517**[3)]

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant
2) With threaded holes M16 on the front face, pitch circle diameter = 101.6 mm / Without Through Coolant
3) With 4 threaded holes M16 on the front face, pitch circle diameter = 101.6 mm and with 4 threaded holes M20 on the front face, pitch circle diameter = 177.8 mm / Without Through Coolant
4) With 4 threaded holes M16 on the front face, pitch circle diameter = 101.6 mm and with 4 threaded holes M20 on the front face, pitch circle diameter = 177.8 mm

	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Solid Carbide support S	 Threaded sleeve	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
125 - 315	**037**	**114**	**303**	**302**	**01500**	**01400**	**193**

SDKT

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
SDKT 1907..	0.754	0.236	0.754	0.059	0.281	15



SD..

SDKT

		-M50 CTCP220	-R50 CTPP225	-R50 CTCP230	-M50 CTPP235	-R50 CTPP235	-R50 CTPM225	-R50 CTCK215
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		SDKT	SDKT	SDKT	SDKT	SDKT	SDKT	SDKT
		51 131 ...	51 132 ...	51 132 ...	51 131 ...	51 132 ...	51 132 ...	51 132 ...
ISO	RE inch							
1907AESN	0.063	22001	07000	02100	12000	12300	22200	52000
P		●	●	●	●	●	●	
M					○	○	●	
K				○	○	○		●
N								
S								
H								
O								

Milling guide

Cutting data standard values	→ 154–157	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

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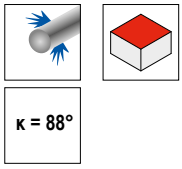
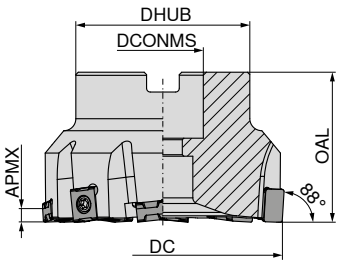
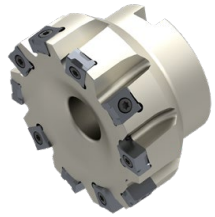
MaxiMill – HEC 11 Shell mill

▲ not adjustable







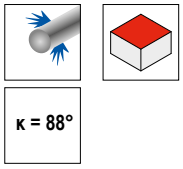
58 725 ...

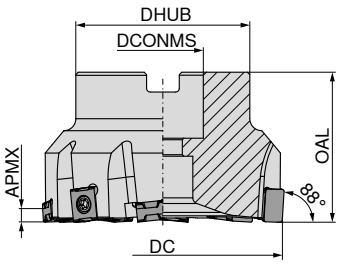
Designation	DC inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	
AHEC.200.R.06-11-A075-175-EF	2.000	6	0.157	1.750	1.750	0.750	12700	3.2	**20006**
AHEC.250.R.08-11-A100-175-EF	2.500	8	0.157	2.250	2.250	1.000	10100	3.2	**25008**
AHEC.300.R.10-11-A100-200-EF	3.000	10	0.157	2.250	2.250	1.000	8000	3.2	**30010**
AHEC.400.R.12-11-B150-200-EF	4.000	12	0.157	3.750	3.750	1.500	6400	3.2	**40012**
AHEC.500.R.16-11-B150-225-EF	5.000	16	0.157	3.750	3.750	1.500	5100	3.2	**50016**
AHEC.600.R.14-11-B150-250-EF	6.000	14	0.157	3.750	3.750	1.500	4000	3.2	**60014**
AHEC.600.R.20-11-A200-250-EF	6.000	20	0.157	2.500	4.882	2.000	4000	3.2	**60020**
AHEC.800.R.20-11-A250-250-EF	8.000	20	0.157	6.890	6.890	2.500	2600	3.2	**80020**

	TORX® blade	 Molykote	 Clamping screw	 Wedge	 Torque screwdriver
	80 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts					
DC					
2.000 - 8.000	**036**	**303**	**113**	**199**	**193**

MaxiMill – HEC 11 Shell mill

▲ not adjustable





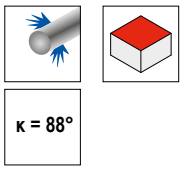
50 725 ...

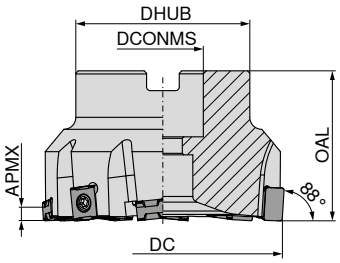
Designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	
AHEC.50.R.06-11	50	6	6	40	48	22	12700	3.2	LNHX 1106	**050**
AHEC.63.R.08-11	63	8	6	40	48	22	10100	3.2	LNHX 1106	**063**
AHEC.80.R.10-11	80	10	6	50	58	27	8000	3.2	LNHX 1106	**080**
AHEC.100.R.12-11	100	12	6	50	78	32	6400	3.2	LNHX 1106	**100**
AHEC.125.R.12-11	125	12	6	63	88	40	5100	3.2	LNHX 1106	**125**
AHEC.125.R.16-11	125	16	6	63	88	40	5100	3.2	LNHX 1106	**12516**
AHEC.160.R.20-11	160	20	6	63	100	40	4000	3.2	LNHX 1106	**160** [1)]

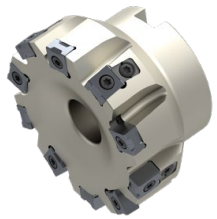
1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

MaxiMill – HEC 11 Shell mill

▲ Axially adjustable with same tooth pitch







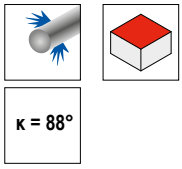
50 733 ...

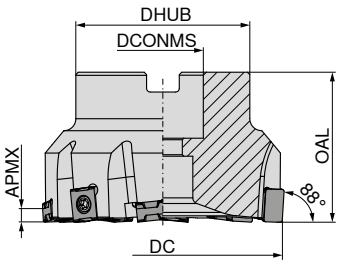
Designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	
AHEC.50.R.06A03-11	50	6	6	40	48	22	12700	3.2	LNHX 1106	**050**
AHEC.63.R.08A04-11	63	8	6	40	48	22	10100	3.2	LNHX 1106	**063**
AHEC.80.R.10A05-11	80	10	6	50	58	27	8000	3.2	LNHX 1106	**080**
AHEC.100.R.12A06-11	100	12	6	50	78	32	6400	3.2	LNHX 1106	**100**
AHEC.125.R.16A08-11	125	16	6	63	88	40	5100	3.2	LNHX 1106	**125**
AHEC.160.R.20A10-11	160	20	6	63	100	40	4000	3.2	LNHX 1106	**160** [1)]

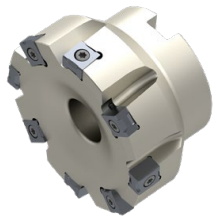
1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

MaxiMill – HEC 11 Shell mill

▲ with irregular pitch, non adjustable







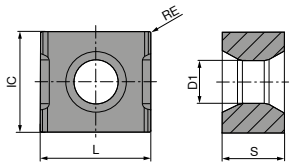
Designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	50 733 ...
AHEC.50.R.04B-11	50	4	6	40	48	22	12700	3.2	LNHX 1106	**550**
AHEC.63.R.06B-11	63	6	6	40	48	22	10100	3.2	LNHX 1106	**563**
AHEC.80.R.08B-11	80	8	6	50	58	27	8000	3.2	LNHX 1106	**580**
AHEC.100.R.10B-11	100	10	6	50	78	32	6400	3.2	LNHX 1106	**600**
AHEC.125.R.12B-11	125	12	6	63	88	40	5100	3.2	LNHX 1106	**625**
AHEC.160.R.14B-11	160	14	6	63	100	40	4000	3.2	LNHX 1106	**660** [1]

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

	TORX® blade	 Molykote	 Coolant Disc	 Clamping screw	 Wedge	 Torque screwdriver
	80 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts for Article no.						
50 725 050 / 50 725 063	**036**	**303**	**852**	**113**		**193**
50 725 080	**036**	**303**	**853**	**113**		**193**
50 725 100 / 50 733 600	**036**	**303**	**854**	**113**		**193**
50 725 125 / 50 725 12516	**036**	**303**	**855**	**113**		**193**
50 725 160 / 50 733 660	**036**	**303**		**113**		**193**
50 733 080 / 50 733 580	**036**	**303**	**853**	**113**	**199**	**193**
50 733 160	**036**	**303**		**113**	**199**	**193**
50 733 063 / 50 733 050	**036**	**303**	**852**	**113**	**199**	**193**
50 733 100	**036**	**303**	**854**	**113**	**199**	**193**
50 733 125	**036**	**303**	**855**	**113**	**199**	**193**
50 733 550 / 50 733 563	**036**	**303**	**852**	**113**		**193**
50 733 625	**036**	**303**	**855**	**113**		**193**

LNHX

Designation	IC inch	D1 inch	L inch	S inch
LNHX 1106..	0.394	0.168	0.433	0.250



LNHX

LNHX

ISO	RE inch	CTEP210 DRAGONSKIN CERMET LNHX 51 046 ...	CTCK215 DRAGONSKIN LNHX 51 046 ...	-R50 CTCK215 DRAGONSKIN LNHX 51 024 ...	-Q CTCK215 DRAGONSKIN LNHX 51 045 ...
1106PNER	0.020		520	520	
1106ZZER	0.020				520 1)
1106PNER	0.031	820			
110616EN	0.063		51600		
P		●			
M					
K		●	●	●	●
N					
S					
H					
O					

1) -Q = trailing edge insert

LNHX

ISO	RE inch	CTPK220 DRAGONSKIN LNHX 51 046 ...	-R50 CTPK220 DRAGONSKIN LNHX 51 024 ...	CTN3105 CERAMIC LNHX 50 500 ...	CTL3215 CBN LNHX 51 046 ...	-Q CTL3215 CBN LNHX 51 045 ...
110608EN	0.031		608			
1106PNER	0.020	620	620			
1106PNSR	0.020			904	87200	
1106ZZER	0.020					87000 1)
P						
M						
K		●	●	●	●	●
N						
S						
H					○	○
O						

1) -Q = trailing edge insert

Milling guide

Cutting data standard values	→ 154–157	Assembly instructions	→ 165
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

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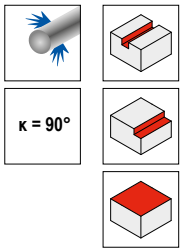
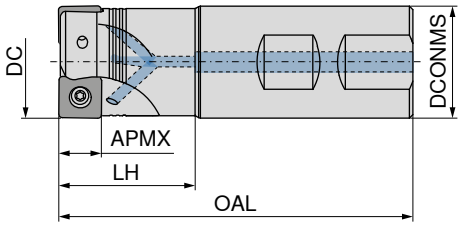
MaxiMill – 491-09 End milling cutter





Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS h6 inch	RPMX 1/min.	torque moment Nm	Insert	58 774 ...	58 774 ...
C491.100.R.03-09-B-125-EF	1.000	3	0.236	3.600	1.250	1.000	17125	2	SNHU 09T3		**30003**
C491.100.R.03-09-A-200-EF-800	1.000	3	0.236	8.000	2.000	1.000	17125	2	SNHU 09T3	**10003**	
C491.125.R.03-09-B-150-EF	1.250	3	0.236	4.000	1.500	1.250	13700	2	SNHU 09T3		**32503**
C491.125.R.04-09-B-150-EF	1.250	4	0.236	4.000	1.500	1.250	13700	2	SNHU 09T3		**32504**
C491.125.R.03-09-A-250-EF-1000	1.250	3	0.236	10.000	2.500	1.250	13700	2	SNHU 09T3	**12503**	
C491.125.R.04-09-A-250-EF-1000	1.250	4	0.236	10.000	2.500	1.250	13700	2	SNHU 09T3	**12504**	

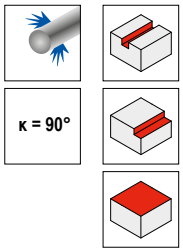

Screwdriver

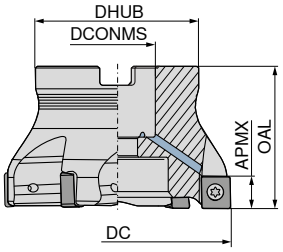

Molykote


Clamping screw

Spare parts DC	80 950 ...	70 950 ...	70 950 ...
1.000 - 1.250	**127**	**303**	**710**

MaxiMill – 491-09 Shell mill





										58 776 ...		58 775 ...	
Designation	DC inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert				
A491.150.R.03-09-A050-175-EF	1.500	3	0.236	1.750	1.421	0.500	11900	2	SNHU 09T3		**15003**		
A491.150.R.05-09-A050-175-EF	1.500	5	0.236	1.750	1.421	0.500	11900	2	SNHU 09T3				**15005**
A491.200.R.04.09-A075-175-EF	2.000	4	0.236	1.750	1.750	0.750	9700	2	SNHU 09T3		**20004**		
A491.200.R.06-09-A075-175-EF	2.000	6	0.236	1.750	1.750	0.750	9700	2	SNHU 09T3				**20006**
A491.250.R.05-09-A100-200-EF	2.500	5	0.236	2.000	2.250	1.000	8500	2	SNHU 09T3		**25005**		
A491.250.R.08-09-A100-200-EF	2.500	8	0.236	2.000	2.250	1.000	8500	2	SNHU 09T3				**25008**
	3.000	6	0.236	2.000	2.250	1.000	7600	2	SNHU 09T3		**30006**		
A491.300.R.10-09-A100-200-EF	3.000	10	0.236	2.000	2.250	1.000	7600	2	SNHU 09T3				**30010**
A491.400.R.07-09-A125-200-EF	4.000	7	0.236	2.000	2.750	1.250	6400	2	SNHU 09T3		**40007**		
A491.400.R.12-09-A125-200-EF	4.000	12	0.236	2.000	2.750	1.250	6400	2	SNHU 09T3				**40012**
A491.500.R.08-09-B150-200-EF	5.000	8	0.236	2.000	3.750	1.500	5700	2	SNHU 09T3		**50008**		
A491.500.R.15-09-B150-200-EF	5.000	15	0.236	2.000	3.750	1.500	5700	2	SNHU 09T3				**50015**

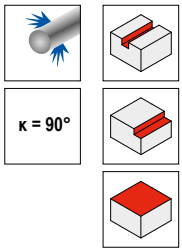

Screwdriver

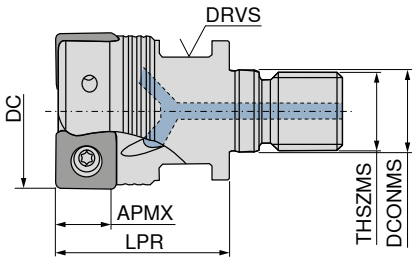

Molykote


Clamping screw

	80 950 ...		70 950 ...		70 950 ...	
Spare parts **DC**						
1.500 - 5.000		**119**		**303**		**710**

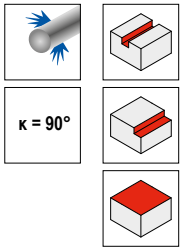
MaxiMill – 491-09 Screw in cutter

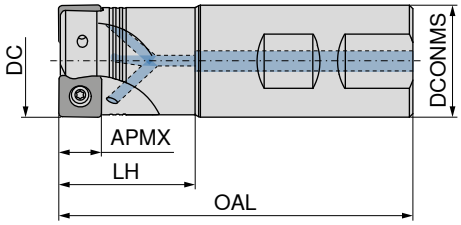




										50 773 ...
Designation	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	
G491.25.R.03-09	25	3	6	35	M12	12.5	17	23500	2	SNHU 09T3	**125**
G491.32.R.03-09	32	3	6	35	M16	17.0	24	19600	2	SNHU 09T3	**132**
G491.32.R.04-09	32	4	6	35	M16	17.0	24	19600	2	SNHU 09T3	**232**

MaxiMill – 491-09 End milling cutter

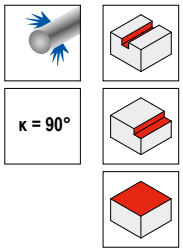


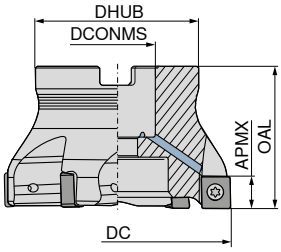


										50 774 ...	50 774 ...
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	torque moment Nm	Insert		
C491.25.R.03-09-B-32	25	3	6	89	32	25	23500	2	SNHU 09T3		**425**
C491.25.R.03-09-A-50-225	25	3	6	225	50	25	23500	2	SNHU 09T3	**325**	
C491.32.R.03-09-B-40	32	3	6	101	40	32	19600	2	SNHU 09T3		**632**
C491.32.R.04-09-B-40	32	4	6	101	40	32	19600	2	SNHU 09T3		**432**
C491.32.R.03-09-A-63-250	32	3	6	250	63	32	19600	2	SNHU 09T3	**532**	
C491.32.R.04-09-A-63-250	32	4	6	250	63	32	19600	2	SNHU 09T3	**332**	

	 TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts **DC**					
25 - 32	**053**	**119**	**303**	**710**	**193**

MaxiMill – 491-09 Shell mill





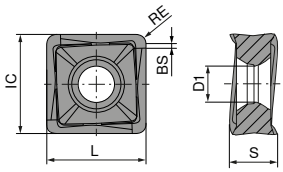
Designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	50 776 ...	50 775 ...
A491.40.R.03-09	40	3	6	40	38	16	16800	2	SNHU 09T3		**240**
A491.40.R.05-09	40	5	6	40	38	16	16800	2	SNHU 09T3	**240**	
A491.50.R.04-09	50	4	6	40	43	22	14600	2	SNHU 09T3		**250**
A491.50.R.06-09	50	6	6	40	43	22	14600	2	SNHU 09T3	**250**	
A491.63.R.05-09	63	5	6	40	48	22	12700	2	SNHU 09T3		**263**
A491.63.R.08-09	63	8	6	40	48	22	12700	2	SNHU 09T3	**263**	
A491.80.R.06-09	80	6	6	50	58	27	11100	2	SNHU 09T3		**280**
A491.80.R.10-09	80	10	6	50	58	27	11100	2	SNHU 09T3	**280**	
A491.100.R.07-09	100	7	6	50	78	32	9800	2	SNHU 09T3		**300**
A491.100.R.12-09	100	12	6	50	78	32	9800	2	SNHU 09T3	**300**	
A491.125.R.08-09	125	8	6	63	88	40	8700	2	SNHU 09T3		**325**
A491.125.R.15-09	125	15	6	63	88	40	8700	2	SNHU 09T3	**325**	

Spare parts DC	TORX® blade 80 950 ...	 Clamping key – T 80 397 ...	 Screwdriver 80 950 ...	 Power Screw 70 950 ...	 Molykote 70 950 ...	 Clamping screw 70 950 ...	 Torque screwdriver 80 950 ...
40	**053**	**040**	**119**	**151**	**303**	**710**	**193**
50 - 125	**053**		**119**		**303**	**710**	**193**

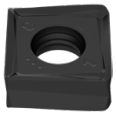
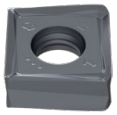
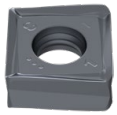
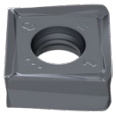
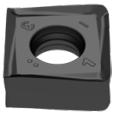
15

SNHU

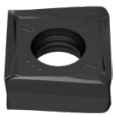
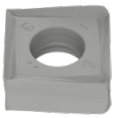
Designation	IC inch	L inch	S inch	D1 inch
SNHU 09T3..	0.360	0.360	0.146	0.152



SNHU

		-M50 CTCP230	-M50 CTPP235	-F50 CTPM240	-M50 CTPM240	-F40 CTPM245	-F40 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		SNHU	SNHU	SNHU	SNHU	SNHU	SNHU
		51 120 ...	51 120 ...	51 119 ...	51 120 ...	51 126 ...	51 126 ...
ISO	RE inch						
09T308ER	0.031					45800	90801
09T308SR	0.031	008	108	408	408		
09T312SR	0.047	01200	11200	41200	41200		
09T316SR	0.063	01600	11600	41600	41600		
P		●	●	○	○	●	●
M			○	●	●	●	●
K		○	○				
N							
S							○
H							
O							

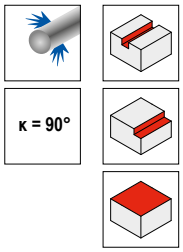
SNHU

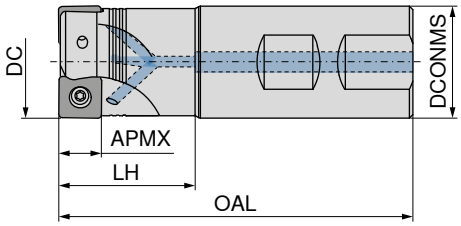
				NEW			
		-R50 CTCK215	-R50 CTPK220	-F10 CTPX715	-F10 CTWN215	-F40 CTC5240	-F40 CTCS245
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
							
		SNHU	SNHU	SNHU	SNHU	SNHU	SNHU
		51 121 ...	51 121 ...	51 118 ...	51 118 ...	51 126 ...	51 126 ...
ISO	RE inch						
09T308ER	0.031					15800	55800
09T308FR	0.031			00802	358		
09T308SR	0.031	508	60800				
09T312FR	0.047				36200		
09T312SR	0.047	51200					
09T316FR	0.063				36600		
09T316SR	0.063	51600					
P				○			
M				○			
K		●	●	●	○		
N				●	●		
S				○		●	●
H							
O				○	○		

Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 167
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 491-12 End milling cutter





Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS $_{h6}$ inch	RPMX 1/min.	torque moment Nm	Insert	58 774 ...	58 774 ...
C491.125.R.02-12-B-150-EF	1.250	2	0.315	4.000	1.500	1.250	13700	3.2	SNHU 1204		**52502**
C491.125.R.02-12-A-250-EF-1000	1.250	2	0.315	10.000	2.500	1.250	13700	3.2	SNHU 1204	**42502**	


Screwdriver


Molykote


Clamping screw

Spare parts DC	80 950 ...	70 950 ...	70 950 ...
1.250	**128**	**303**	**859**

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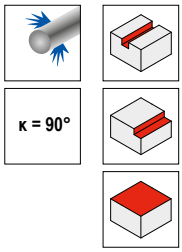
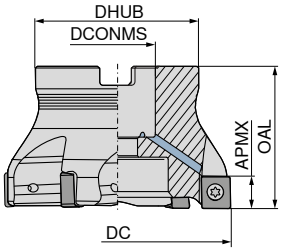
MaxiMill – 491-12 Shell mill





										58 776 ...		58 775 ...	
Designation	DC inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert				
A491.150.R.03-12-A050-175-EF	1.500	3	0.315	1.420	1.420	0.500	11900	3.2	SNHU 1204		**15103**		
A491.200.R.04-12-A075-175-EF	2.000	4	0.315	1.750	1.750	0.750	9700	3.2	SNHU 1204		**20104**		
A491.200.R.05-12-A075-175-EF	2.000	5	0.315	1.750	1.750	0.750	9700	3.2	SNHU 1204				**20105**
A491.250.R.05-12-A100-200-EF	2.500	5	0.315	2.250	2.250	1.000	8500	3.2	SNHU 1204		**25105**		
A491.250.R.06-12-A100-200-EF	2.500	6	0.315	2.250	2.250	1.000	8500	3.2	SNHU 1204				**25106**
A491.300.R.06-12-A100-200-EF	3.000	6	0.315	2.250	2.250	1.000	7600	3.2	SNHU 1204		**30106**		
A491.300.R.08-12-A100-200-EF	3.000	8	0.315	2.250	2.250	1.000	7600	3.2	SNHU 1204				**30108**
A491.400.R.07-12-A125-200-EF	4.000	7	0.315	2.750	2.750	1.250	6400	3.2	SNHU 1204		**40107**		
A491.400.R.10-12-A125-200-EF	4.000	10	0.315	2.750	2.750	1.250	6400	3.2	SNHU 1204				**40110**
A491.500.R.08-12-B150-200-EF	5.000	8	0.315	3.750	3.750	1.500	5700	3.2	SNHU 1204		**50108**		
A491.500.R.12-12-B150-200-EF	5.000	12	0.315	3.750	3.750	1.500	5700	3.2	SNHU 1204				**50112**
A491.600.R.09-12-B150-200-EF	6.000	9	0.315	3.750	3.750	1.500	5100	3.2	SNHU 1204		**60109**		
A491.600.R.13-12-B150-200-EF	6.000	13	0.315	3.750	3.750	1.500	5100	3.2	SNHU 1204				**60113**

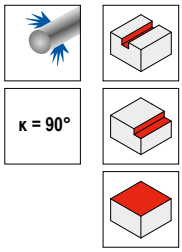

Screwdriver

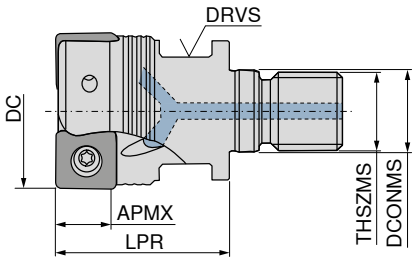

Molykote


Clamping screw

	80 950 ...	70 950 ...	70 950 ...
Spare parts			
DC			
1.500 - 6.000	**128**	**303**	**859**

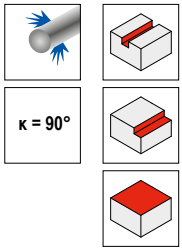
MaxiMill – 491-12 Screw in cutter

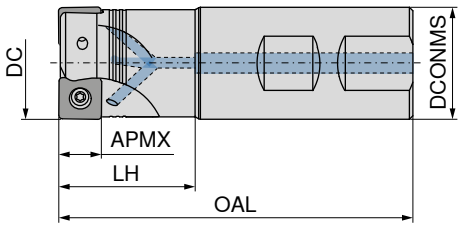




										50 773 ...
Designation	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	
G491.32.R.02-12	32	2	8	35	M16	17	24	13600	3.2	SNHU 1204	**032**

MaxiMill – 491-12 End milling cutter





										50 774 ...	50 774 ...
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	torque moment Nm	Insert		
C491.32.R.02-12-B-40	32	2	8	102	40	32	13600	3.2	SNHU 1204		**032**
C491.32.R.02-12-A-63-250	32	2	8	250	63	32	10200	3.2	SNHU 1204	**232**	

TORX® blade


Screwdriver

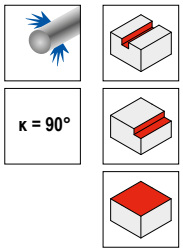

Molykote

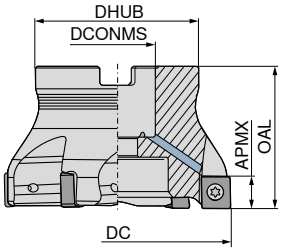

Clamping screw


Torque screwdriver

	TORX® blade	Screwdriver	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts					
DC					
32	**054**	**128**	**303**	**859**	**193**

MaxiMill – 491-12 Shell mill





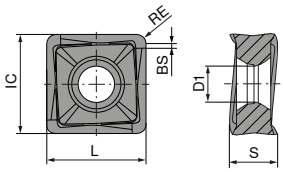
Designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	50 776 ...	50 775 ...
A491.40.R.03-12	40	3	8	40	38	16	11500	3.2	SNHU 1204		**040**
A491.40.R.04-12	40	4	8	40	38	16	11500	3.2	SNHU 1204	**040**	
A491.50.R.04-12	50	4	8	40	43	22	9800	3.2	SNHU 1204		**050**
A491.50.R.05-12	50	5	8	40	43	22	9800	3.2	SNHU 1204	**050**	
A491.63.R.05-12	63	5	8	40	48	22	8500	3.2	SNHU 1204		**063**
A491.63.R.06-12	63	6	8	40	48	22	8500	3.2	SNHU 1204	**063**	
A491.80.R.06-12	80	6	8	50	58	27	7400	3.2	SNHU 1204		**080**
A491.80.R.08-12	80	8	8	50	58	27	7400	3.2	SNHU 1204	**080**	
A491.100.R.07-12	100	7	8	50	78	32	6500	3.2	SNHU 1204		**100**
A491.100.R.10-12	100	10	8	50	78	32	6500	3.2	SNHU 1204	**100**	
A491.125.R.08-12	125	8	8	63	88	40	5700	3.2	SNHU 1204		**125**
A491.125.R.12-12	125	12	8	63	88	40	5700	3.2	SNHU 1204	**125**	
A491.160.R.09-12	160	9	8	63	98	40	5000	3.2	SNHU 1204		**160** [1]
A491.160.R.14-12	160	14	8	63	98	40	5000	3.2	SNHU 1204	**160** [1]	

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

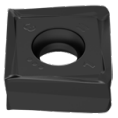
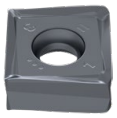
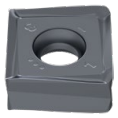
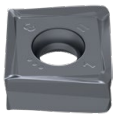
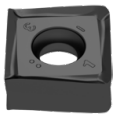
Spare parts DC	TORX® blade	 Clamping key – T	 Screwdriver	 Power Screw	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
40	**054**	**040**	**128**	**151**	**303**	**859**	**193**
50 - 160	**054**		**128**		**303**	**859**	**193**

SNHU

Designation	IC inch	L inch	S inch	D1 inch
SNHU 1204..	0.480	0.480	0.197	0.173

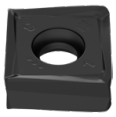
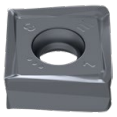
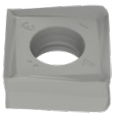


SNHU

		-M50 CTCP230	-M50 CTPP235	-F50 CTPM240	-M50 CTPM240	-F40 CTPM245	-F40 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		SNHU	SNHU	SNHU	SNHU	SNHU	SNHU
		51 100 ...	51 100 ...	51 102 ...	51 100 ...	51 128 ...	51 128 ...
ISO	RE inch						
120408ER	0.031					45800	90801
120408SR	0.031	008	108	408	408		
120412SR	0.047		112	412			
120416SR	0.063		116	416			
120420SR	0.079		120	420			
P		●	●	○	○	●	●
M			○	●	●	●	●
K		○	○				
N							
S							○
H							
O							

15

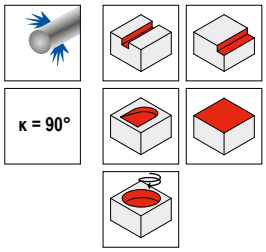
SNHU

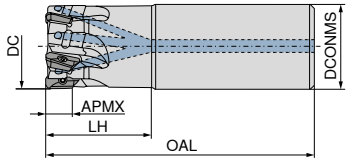
				NEW			
		-R50 CTCK215	-R50 CTPK220	-F10 CTPX715	-F10 CTWN215	-F40 CTC5240	-F40 CTCS245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
							
		SNHU	SNHU	SNHU	SNHU	SNHU	SNHU
		51 103 ...	51 103 ...	51 101 ...	51 101 ...	51 128 ...	51 128 ...
ISO	RE inch						
120408ER	0.031					15800	55800
120408FR	0.031			00802	358		
120408SR	0.031	508	608				
120412FR	0.047				362		
120412SR	0.047	512					
120416FR	0.063				366		
120416SR	0.063	516					
120420FR	0.079				370		
120420SR	0.079	520					
P				○			
M				○			
K		●	●	●	○		
N				●	●		
S				○		●	●
H							
O				○	○		

Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 167
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 211-07 End milling cutter

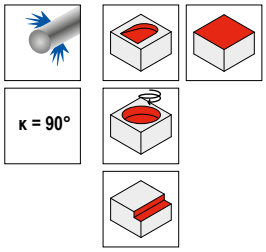


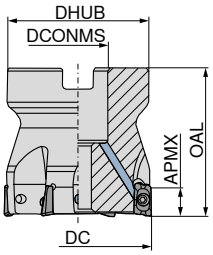


58 752 ...

Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	RPMX 1/min.	torque moment Nm	Insert	
C211.0375.R.01-07-A-0750-EF	0.375	1	0.236	3.000	0.750	0.375	68000	1	XD.T 0703	**03701**
C211.0500.R.02-07-A-0750-EF	0.500	2	0.236	3.000	0.750	0.500	66600	1	XD.T 0703	**05002**
C211.0625.R.03-07-A-125-EF-650	0.625	3	0.236	6.500	1.250	0.625	17760	1	XD.T 0703	**06203**
C211.0750.R.04-07-A-150-EF-800	0.750	4	0.236	8.000	1.500	0.750	12600	1	XD.T 0703	**07504**
C211.100.R.06-07-A0875-125-EF	1.000	6	0.236	3.500	1.250	0.875	39840	1	XD.T 0703	**10006**
C211.125.R.08-07-A100-150-EF	1.250	8	0.236	3.500	1.500	1.000	36240	1	XD.T 0703	**12508**

MaxiMill – 211-07 Shell mill





58 753 ...

Designation	DC inch	ZNF	APMX inch	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	Insert	
A211.150.R.08-07-A050-175-EF	1.500	8	0.236	1.420	0.500	1.420	33240	XD.T 0703	**15008**
A211.200.R.10-07-A075-175-EF	2.000	10	0.236	1.750	0.750	1.750	30480	XD.T 0703	**20010**

Screwdriver

80 950 ...

Molykote

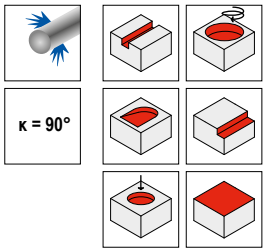
70 950 ...

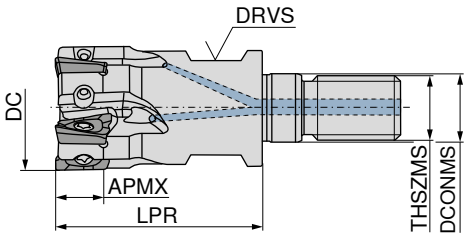
Clamping screw

70 950 ...

Spare parts DC			
0.375 - 2.000	**117**	**303**	**137**

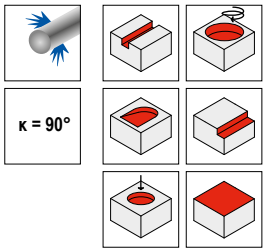
MaxiMill – 211-07 Screw in cutter

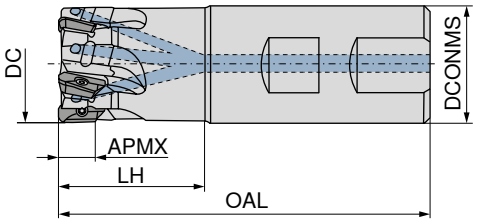




										50 751 ...
Designation	DC mm	ZNF	APMX mm	LPR mm	DCONMS mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	
G211.16.R.04-07	16	4	6	27	8.5	M8	10	50400	1	XD.T 0703	**016**
G211.20.R.05-07	20	5	6	33	10.5	M10	15	44280	1	XD.T 0703	**020**
G211.25.R.06-07	25	6	6	35	12.5	M12	17	39480	1	XD.T 0703	**025**
G211.32.R.08-07	32	8	6	35	17.0	M16	24	36240	1	XD.T 0703	**032**

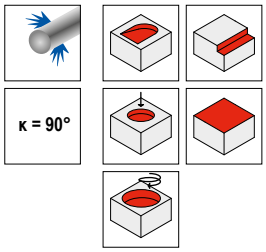
MaxiMill – 211-07 End milling cutter

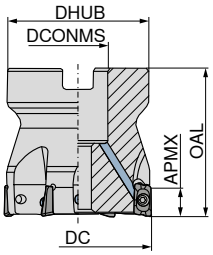


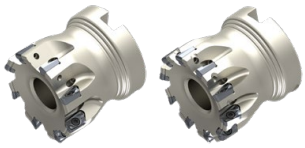


										50 752 ...	50 752 ...
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	RPMX 1/min.	torque moment Nm	Insert		
C211.10.R.01-07-A-20	10	1	6	61.0	20	10	72000	1	XD.T 0703	**010**	
C211.12.R.02-07-A-20	12	2	6	66.5	20	12	66600	1	XD.T 0703	**012**	
C211.16.R.04-07-A/B-25	16	4	6	74.5	25	16	50400	1	XD.T 0703	**016**	**216**
C211.16.R.03-07-A-32-165	16	3	6	165.0	32	16	17760	1	XD.T 0703	**116**	
C211.20.R.05-07-A/B-25	20	5	6	77.0	25	20	44280	1	XD.T 0703	**020**	**220**
C211.20.R.04-07-A-40-200	20	4	6	200.0	40	20	12600	1	XD.T 0703	**120**	
C211.25.R.06-07-A/B20-32	25	6	6	84.0	32	20	39840	1	XD.T 0703	**025**	**225**
C211.25.R.05-07-A20-50-225	25	5	6	225.0	50	20	11280	1	XD.T 0703	**125**	
C211.32.R.08-07-A/B25-40	32	8	6	98.0	40	25	36240	1	XD.T 0703	**032**	**232**

MaxiMill – 211-07 Shell mill





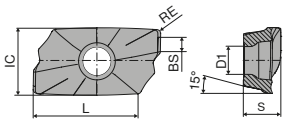


										50 753 ...		50 754 ...	
Designation	DC mm	ZNF	APMX mm	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert				
A211.32.R.06-07	32	6	6	40	16	38	36240	1	XD.T 0703		**032**		
A211.32.R.08-07	32	8	6	40	16	38	36240	1	XD.T 0703				**032**
A211.40.R.08-07	40	8	6	40	16	38	33240	1	XD.T 0703		**040**		
A211.40.R.10-07	40	10	6	40	16	38	33240	1	XD.T 0703				**040**
A211.50.R.10-07	50	10	6	40	22	43	30480	1	XD.T 0703		**050**		
A211.50.R.12-07	50	12	6	40	22	43	30480	1	XD.T 0703				**050**

	TORX® blade	Clamping key – T	Screwdriver	Power Screw	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts **DC**							
10 - 25	**051**		**124**		**303**	**137**	**191**
32	**051**	**040**	**124**	**151**	**303**	**137**	**191**
32 - 50	**051**		**124**		**303**	**137**	**191**

XDKT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XDKT 0703..	0.193	0.098	0.307	0.047	0.125



XDKT

XDKT

ISO	RE inch	-F50 CTCP230 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-F50 CTPP235 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN
		F XDKT	M XDKT	F XDKT	M XDKT
		51 033 ...	51 036 ...	51 033 ...	51 036 ...
070304SR	0.016	004	004	104	104
070308SR	0.031	008	008	108	108
P		●	●	●	●
M				○	○
K		○	○	○	○
N					
S					
H					
O					

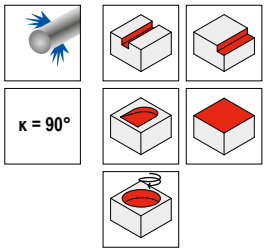
XDKT

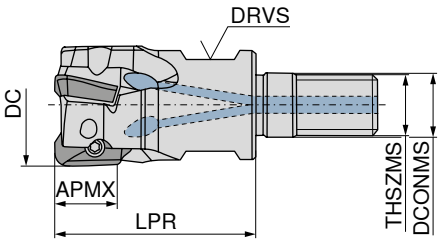
ISO	RE inch	-F50 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-F40 CTPM245 DRAGONSKIN	-F40 CTCM245 DRAGONSKIN	-F20 CTWN215	-F40 CTC5240 DRAGONSKIN	-F40 CTCS245 DRAGONSKIN
		F XDKT	M XDKT	F XDKT	F XDKT	F XDKT	F XDKT	F XDKT
		51 033 ...	51 036 ...	51 112 ...	51 112 ...	50 507 ...	50 498 ...	51 112 ...
070304ER	0.016			454	90401		544	
070304FR	0.016					504		
070304SR	0.016	404	404					
070308ER	0.031			458	90801		548	558
070308FR	0.031					508		
070308SR	0.031	408	408					
P		○	○	●	●			
M		●	●	●	●			
K						○		
N						●		
S					○		●	●
H								
O						○		

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 168
Starting Parameter	→ 168	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – 211-11 Screw in cutter



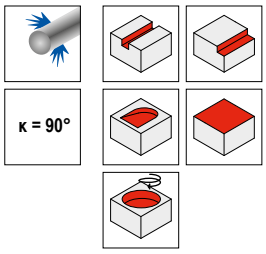


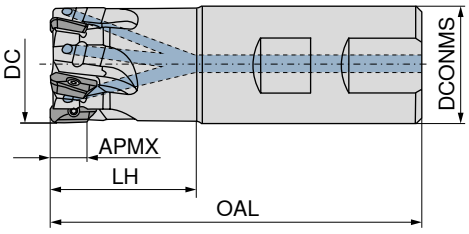
										58 736 ...
Designation	DC inch	ZNF	APMX inch	LPR inch	DCONMS inch	THSZMS	RPMX 1/min.	torque moment Nm	Insert	
G211.0625.R.02-11-125-F	0.625	2	0.394	1.250	0.335	M8	42000	1.6	XD.T 11T3	**06202**[1)]
G211.0750.R.03-11-118-F	0.750	3	0.394	1.118	0.492	M10	36900	1.6	XD.T 11T3	**07503**
G211.100.R.04-11-150-F	1.000	4	0.394	1.500	0.492	M12	33200	1.6	XD.T 11T3	**10004**
G211.125.R.05-11-150-F	1.250	5	0.394	1.500	0.669	M16	30200	1.6	XD.T 11T3	**12505**

1) Not in stock

MaxiMill – 211-11 End milling cutter

▲ Insert radius > 0.063": Modify cutter body



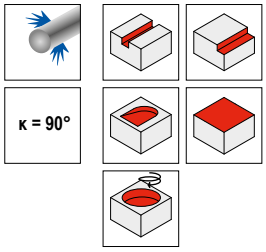


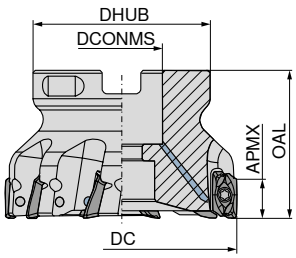
										58 737 ...	58 737 ...
Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS $_{h6}$ inch	RPMX 1/min.	torque moment Nm	Insert		
C211.0625.R.02-11-B-100-EF	0.625	2	0.394	3.250	1.000	0.625	42000	1.6	XD.T 11T3		**26202**
C211.0625.R.02-11-A-125-EF-650	0.625	2	0.394	6.500	1.250	0.625	14800	1.6	XD.T 11T3	**06202**	
C211.0750.R.03-11-B-100-EF	0.750	3	0.394	3.500	1.000	0.750	36900	1.6	XD.T 11T3		**27503**
C211.0750.R.03-11-A-125-EF-650	0.750	3	0.394	6.500	1.250	0.750	15800	1.6	XD.T 11T3	**07503**	
C211.100.R.04-11-B-125-EF	1.000	4	0.394	3.500	1.250	1.000	33200	1.6	XD.T 11T3		**30004**
C211.100.R.04-11-A-150-EF-650	1.000	4	0.394	6.500	1.500	1.000	19900	1.6	XD.T 11T3	**10004**	
C211.125.R.05-11-B100-150-EF	1.250	5	0.394	3.750	1.500	1.000	30200	1.6	XD.T 11T3		**32505**
C211.125.R.05-11-A100-200-EF-650	1.250	5	0.394	6.500	2.000	1.000	20900	1.6	XD.T 11T3	**12505**	
C211.150.R.06-11-B-200-EF	1.500	6	0.394	4.000	2.000	1.250	27700	1.6	XD.T 11T3		**35006**

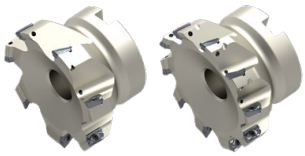
	 Screwdriver	 Molykote	 Clamping screw
	80 950 ...	**70 950 ...**	**70 950 ...**
Spare parts			
DC			
0.625 - 1.250	**039**	**303**	**128**
1.500	**039**	**303**	**131**

MaxiMill – 211-11 Shell mill

▲ Insert radius > 0.063": Modify cutter body







Designation	DC inch	ZNF	APMX inch	OAL inch	DCONMS H6 inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	58 738 ...		58 739 ...	
A211.150.R.04-11-A050-175-EF	1.500	4	0.394	1.420	0.500	1.420	27700	1.6	XD.T 11T3	**15004**			
A211.150.R.06-11-A050-175-EF	1.500	6	0.394	1.420	0.500	1.420	27700	1.6	XD.T 11T3				**15006**
A211.200.R.05-11-A075-175-EF	2.000	5	0.394	1.750	0.750	1.750	25400	1.6	XD.T 11T3	**20005**			
A211.200.R.08-11-A075-175-EF	2.000	8	0.394	1.750	0.750	1.750	25400	1.6	XD.T 11T3				**20008**
A211.250.R.06-11-A100-200-EF	2.500	6	0.394	2.250	1.000	2.250	23300	1.6	XD.T 11T3	**25006**			
A211.250.R.10-11-A100-200-EF	2.500	10	0.394	2.250	1.000	2.250	23300	1.6	XD.T 11T3				**25010**
A211.300.R.07-11-A100-200-EF	3.000	7	0.394	2.250	1.000	2.250	21300	1.6	XD.T 11T3	**30007**			
A211.300.R.12-11-A100-200-EF	3.000	12	0.394	2.250	1.000	2.250	21300	1.6	XD.T 11T3				**30012**
A211.400.R.08-11-B125-200-EF	4.000	8	0.394	2.750	1.250	2.750	19600	1.6	XD.T 11T3	**40008**			
A211.400.R.14-11-B125-200-EF	4.000	14	0.394	2.750	1.250	2.750	19600	1.6	XD.T 11T3				**40014**
A211.500.R.10-11-B150-200-EF	5.000	10	0.394	3.750	1.500	3.750	17900	1.6	XD.T 11T3	**50010**			
A211.600.R.12-11-B150-200-EF	6.000	12	0.394	3.750	1.500	3.750	16500	1.6	XD.T 11T3	**60012**			

Screwdriver

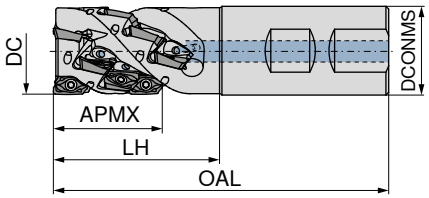
Molykote

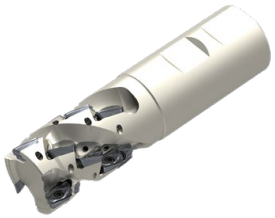
Clamping screw

Spare parts DC	80 950 ...		70 950 ...		70 950 ...	
0.625 - 1.250	**039**		**303**			**128**
1.500 - 6.000	**039**		**303**			**131**

MaxiMill – 211-11K Extended flute cutter

▲ ZEFP = Number of inserts
▲ ZNP = Number of teeth





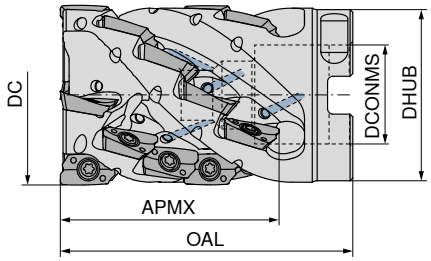
58 758 ...

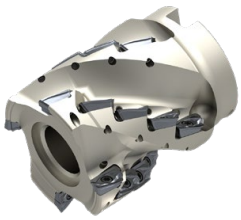
Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	ZEFP	ZNP	torque moment Nm	
C211.100.R.02K3-11-B-150-EF	1.000	2	1.060	3.750	1.500	1.000	6	3	1.6	**10002**
C211.125.R.02K4-11-B-200-EF	1.250	2	1.430	4.500	2.000	1.250	8	4	1.6	**12502**
C211.150.R.03K4-11-A-225-EF	1.500	3	1.420	5.100	2.250	1.500	12	4	1.6	**15003**[1)]

1) DIN 1835 A Shank

MaxiMill – 211-11K Extended flute cutter

▲ ZEFP = Number of inserts
▲ ZNP = Number of teeth





58 757 ...

Designation	DC inch	ZNF	APMX inch	ZEFP	ZNP	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	torque moment Nm	Insert	
A211.200.R.04K5-11-A075-EF	2.000	4	1.800	20	5	2.500	0.750	1.750	1.6	XD.T 11T3	**20004**
A211.250.R.05K7-11-A100-EF	2.500	5	2.500	35	7	3.250	1.000	2.250	1.6	XD.T 11T3	**25005**
A211.300.R.06K9-11-A125-EF	3.000	6	3.200	54	9	4.000	1.250	2.750	1.6	XD.T 11T3	**30006**


Cap screw


Screwdriver


Molykote

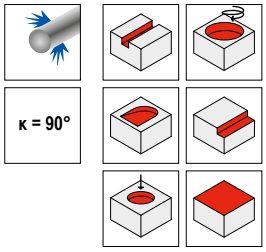

Clamping screw

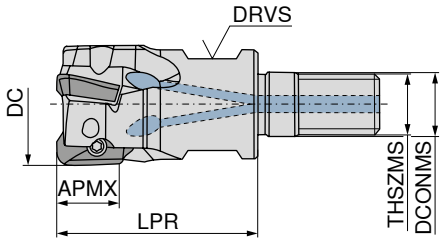
Spare parts DC				
	70 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**
1.000 - 1.500		**039**	**303**	**131**
2.000	**002**	**039**	**303**	**131**
2.500	**003**	**039**	**303**	**131**
3.000	**004**	**039**	**303**	**131**

15

MaxiMill – 211-11 Screw in cutter

▲ Insert radius >1.6 mm: Modify cutter body

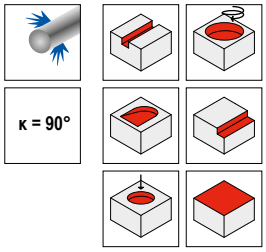


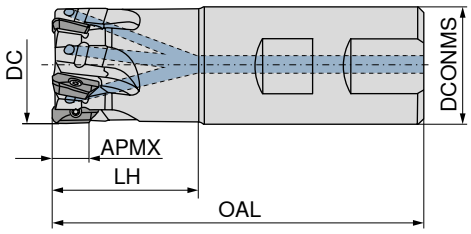


Designation	DC mm	ZNF	APMX mm	LPR mm	DCONMS mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	50 736 ...
G211.16.R.02-11	16	2	10	27	8.5	M8	10	42000	1.6	XD.T 11T3	**016**
G211.20.R.03-11	20	3	10	33	10.5	M10	15	36900	1.6	XD.T 11T3	**020**
G211.25.R.03-11	25	3	10	35	12.5	M12	17	33200	1.6	XD.T 11T3	**12500**
G211.25.R.04-11	25	4	10	35	12.5	M12	17	33200	1.6	XD.T 11T3	**025**
G211.32.R.04-11	32	4	10	35	17.0	M16	24	30200	1.6	XD.T 11T3	**13200**
G211.32.R.05-11	32	5	10	35	17.0	M16	24	30200	1.6	XD.T 11T3	**032**
G211.40.R.06-11	40	6	10	35	17.0	M16	27	27700	1.6	XD.T 11T3	**040**

MaxiMill – 211-11 End milling cutter

▲ Insert radius >1.6 mm: Modify cutter body

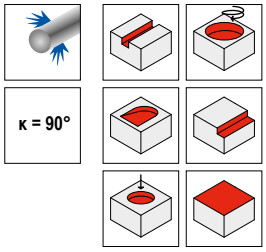


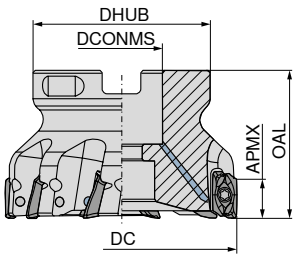


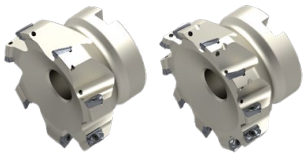
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	torque moment Nm	Insert	50 737 ...	50 737 ...
C211.12.R.01-11-B-20	12	1	10	75	20	16	55000	1.6	XD.T 11T3		**012**
C211.16.R.02-11-A/B-25	16	2	10	75	25	16	42000	1.6	XD.T 11T3	**116**	**016**
C211.16.R.02-11-A15-32-165	16	2	10	165	32	15	14800	1.6	XD.T 11T3	**316**	
C211.16.R.02-11-A-32-165	16	2	10	165	32	16	14800	1.6	XD.T 11T3	**216**	
C211.20.R.03-11-A-25	20	3	10	77	25	20	36900	1.6	XD.T 11T3	**120**	
C211.20.R.03-11-B-25	20	3	10	77	25	20	36900	1.6	XD.T 11T3		**020**
C211.20.R.02-11-B-25	20	2	10	77	25	20	36900	1.6	XD.T 11T3		**02002**
C211.20.R.02-11-A-25	20	2	10	77	25	20	36900	1.6	XD.T 11T3	**12002**	
C211.20.R.03-11-A-32-165	20	3	10	165	32	20	15800	1.6	XD.T 11T3	**320**	
C211.20.R.02-11-A-40-200	20	2	10	200	40	20	10500	1.6	XD.T 11T3	**420**	
C211.20.R.02-11-A19-40-200	20	2	10	200	40	19	10500	1.6	XD.T 11T3	**620**	
C211.25.R.03-11-A/B-32	25	3	10	90	32	25	33200	1.6	XD.T 11T3	**625**	**725**
C211.25.R.04-11-A/B-32	25	4	10	90	32	25	33200	1.6	XD.T 11T3	**125**	**025**
C211.25.R.04-11-A-40-165	25	4	10	165	40	25	19900	1.6	XD.T 11T3	**325**	
C211.25.R.03-11-A-50-225	25	3	10	225	50	25	9400	1.6	XD.T 11T3	**425**	
C211.25.R.03-11-A24-50-225	25	3	10	225	50	24	9400	1.6	XD.T 11T3	**825**	
C211.25.R.02-11-A-50-225	25	2	10	225	50	25	9400	1.6	XD.T 11T3	**02502**	
C211.32.R.04-11-A-40	32	4	10	102	40	32	30200	1.6	XD.T 11T3	**13204**	
C211.32.R.05-11-A/B-40	32	5	10	102	40	32	30200	1.6	XD.T 11T3	**132**	**032**
C211.32.R.04-11-B-25	32	4	10	102	40	32	30200	1.6	XD.T 11T3		**83200**
C211.32.R.05-11-B25-40	32	5	10	102	40	25	30200	1.6	XD.T 11T3		**73200**
C211.32.R.04-11-A25-40	32	4	10	102	40	25	30200	1.6	XD.T 11T3	**53204**	
C211.32.R.05-11-A-50-165	32	5	10	165	50	32	20900	1.6	XD.T 11T3	**332**	
C211.32.R.04-11-A-64-250	32	4	10	250	64	32	8500	1.6	XD.T 11T3	**432**	
C211.40.R.06-11-B32-50	40	6	10	110	50	32	27700	1.6	XD.T 11T3		**04000**
C211.40.R.06-11-B-50	40	6	10	122	50	40	27700	1.6	XD.T 11T3		**14000**

MaxiMill – 211-11 Shell mill

▲ Insert radius >1.6 mm: Modify cutter body





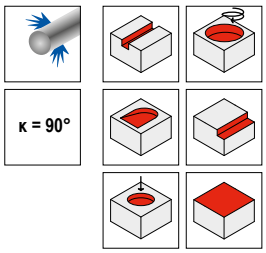


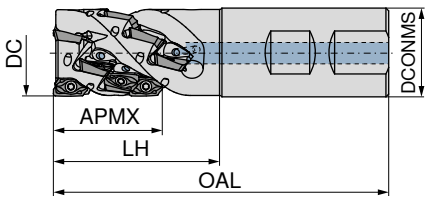
										50 738 ...		50 739 ...
Designation	DC mm	ZNF	APMX mm	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert			
A211.40.R.04-11	40	4	10	40	16	38	27700	1.6	XD.T 11T3	**040**		
A211.40.R.06-11	40	6	10	40	16	38	27700	1.6	XD.T 11T3			**040**
A211.50.R.05-11	50	5	10	40	22	43	25400	1.6	XD.T 11T3	**050**		
A211.50.R.08-11	50	8	10	40	22	43	25400	1.6	XD.T 11T3			**050**
A211.63.R.06-11	63	6	10	40	22	48	23300	1.6	XD.T 11T3	**063**		
A211.63.R.10-11	63	10	10	40	22	48	23300	1.6	XD.T 11T3			**063**
A211.80.R.07-11	80	7	10	50	27	58	21300	1.6	XD.T 11T3	**080**		
A211.80.R.10-11	80	10	10	50	27	58	21300	1.6	XD.T 11T3			**180**
A211.80.R.12-11	80	12	10	50	27	58	21300	1.6	XD.T 11T3			**08012**
A211.100.R.08-11	100	8	10	50	32	78	19600	1.6	XD.T 11T3	**10000**		
A211.100.R.14-11	100	14	10	50	32	78	19600	1.6	XD.T 11T3			**10014**
A211.125.R.10-11	125	10	10	63	40	88	17900	1.6	XD.T 11T3	**12500**		

	TORX® blade		Clamping key – T		Screwdriver		Power Screw		Molykote		Clamping screw		Torque screwdriver	
	80 950 ...		**80 397 ...**		**80 950 ...**		**70 950 ...**		**70 950 ...**		**70 950 ...**		**80 950 ...**	
Spare parts **DC**														
12		**043**				**125**				**303**				**191**
16 - 32		**043**				**125**				**303**		**128**		**191**
40		**043**		**040**		**125**		**151**		**303**		**131**		**191**
50		**043**		**050**		**125**		**154**		**303**		**131**		**191**
63 - 125		**043**				**125**				**303**		**131**		**191**

MaxiMill – 211-11KN shell end mill shank

▲ ZEFP = Number of inserts
▲ ZNP = Number of teeth



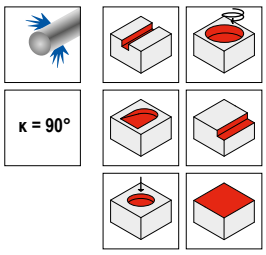


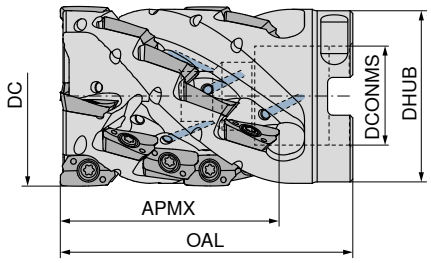
50 784 ...

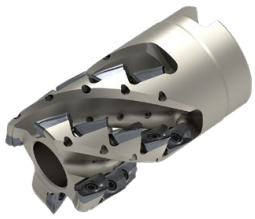
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	RPMX 1/min.	torque moment Nm	Insert	
C211.25.R.02KN3-11-B-40	25	2	28	97	40	25	6	3	19800	1.6	XD.T 11T3	**02523**
C211.25.R.02KN4-11-B-50	25	2	37	107	50	25	8	4	19800	1.6	XD.T 11T3	**02524**
C211.25.R.02KN5-11-B-60	25	2	46	117	60	25	10	5	19800	1.6	XD.T 11T3	**02525**
C211.32.R.02KN4-11-B-50	32	2	37	111	50	32	8	4	19200	1.6	XD.T 11T3	**03224**
C211.32.R.03KN5-11-B-60	32	3	46	121	60	32	15	5	19200	1.6	XD.T 11T3	**03235**
C211.40.R.03KN4-11-B32-50	40	3	37	111	50	32	12	4	18300	1.6	XD.T 11T3	**04034**
C211.40.R.04KN5-11-B32-60	40	4	46	121	60	32	20	5	18300	1.6	XD.T 11T3	**04045**

MaxiMill – 211-11KN shell end face mill

▲ ZEFP = Number of inserts
▲ ZNP = Number of teeth







50 794 ...

Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert	
A211.40.R.03KN4-11	40	3	37	12	4	65	22	38	18300	1.6	XD.T 11T3	**04034**
A211.40.R.04KN4-11	40	4	37	16	4	65	22	38	18300	1.6	XD.T 11T3	**04044**
A211.40.R.04KN5-11	40	4	46	20	5	74	22	38	18300	1.6	XD.T 11T3	**04045**
A211.50.R.04KN5-11	50	4	46	20	5	75	27	48	17100	1.6	XD.T 11T3	**05045**
A211.50.R.05KN5-11	50	5	46	25	5	75	27	48	17100	1.6	XD.T 11T3	**05055**
A211.50.R.05KN6-11	50	5	55	30	6	85	27	48	17100	1.6	XD.T 11T3	**05056**


Cap screw

TORX® blade


Screwdriver


Molykote


Clamping screw

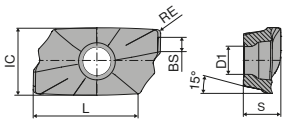

Socket head screw


Torque screwdriver

	70 950 ...	**80 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts Designation							
A211.40.R.03KN4-11		**043**	**125**	**303**	**20400**	**20900**	**191**
A211.40.R.04KN4-11		**043**	**125**	**303**	**20400**	**20900**	**191**
A211.40.R.04KN5-11		**043**	**125**	**303**	**20400**	**21000**	**191**
A211.50.R.04KN5-11	**002**	**043**	**125**	**303**	**20400**	**181**	**191**
A211.50.R.05KN5-11	**002**	**043**	**125**	**303**	**20400**	**181**	**191**
A211.50.R.05KN6-11	**002**	**043**	**125**	**303**	**20400**	**181**	**191**
C211.25.R.02KN3-11-B-40		**043**	**125**	**303**	**20700**		**191**
C211.25.R.02KN4-11-B-50		**043**	**125**	**303**	**20700**		**191**
C211.25.R.02KN5-11-B-60		**043**	**125**	**303**	**20700**		**191**
C211.32.R.02KN4-11-B-50		**043**	**125**	**303**	**20700**		**191**
C211.32.R.03KN5-11-B-60		**043**	**125**	**303**	**20700**		**191**
C211.40.R.03KN4-11-B32-50		**043**	**125**	**303**	**20400**		**191**
C211.40.R.04KN5-11-B32-60		**043**	**125**	**303**	**20400**		**191**

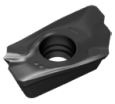
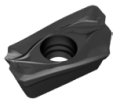
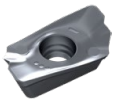
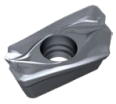
XDKT / XDHT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XD.T 11T302..	0.268	0.110	0.417	0.079	0.150
XD.T 11T304..	0.268	0.110	0.417	0.071	0.150
XD.T 11T308..	0.268	0.110	0.417	0.055	0.150
XD.T 11T312..	0.268	0.110	0.417	0.055	0.150
XD.T 11T316..	0.268	0.110	0.417	0.055	0.150
XD.T 11T320..	0.268	0.110	0.417	0.055	0.150
XD.T 11T325..	0.268	0.110	0.417	0.055	0.150
XD.T 11T332..	0.268	0.110	0.417	0.031	0.150
XD.T 11T340..	0.268	0.110	0.417	-	0.150
XDHT 11T350..	0.268	0.110	0.417	-	0.150
XDKT 11T332..	0.268	0.110	0.417	0.055	0.150

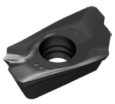
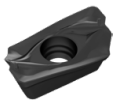
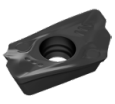
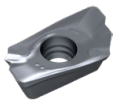
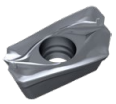
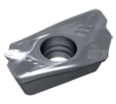


XDKT

XDKT

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		F	M	F	M
		XDKT	XDKT	XDKT	XDKT
		51 034 ...	51 037 ...	51 034 ...	51 037 ...
ISO	RE inch				
11T308SR	0.031	258	258	058	058
P		●	●	●	●
M					
K					
N					
S					
H					
O					

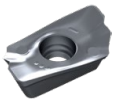
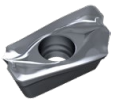
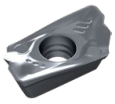
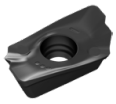
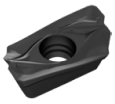
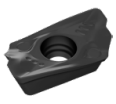
XDKT

		-F50 CTCP230	-M50 CTCP230	-R50 CTCP230	-F50 CTPP235	-M50 CTPP235	-R50 CTPP235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		F	M	R	F	M	R
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		51 034 ...	51 037 ...	51 039 ...	51 034 ...	51 037 ...	51 039 ...
ISO	RE inch						
11T304SR	0.016	004	004	004	104	104	104
11T308SR	0.031	008	008	008	108	108	108
11T312SR	0.047		012			112	
11T320SR	0.079	020 1)	020 1)	020 1)	120 1)	120 1)	120 1)
11T325SR	0.098	025 1)	025 1)	025 1)	125 1)	125 1)	125 1)
P		●	●	●	●	●	●
M					○	○	○
K		○	○	○	○	○	○
N							
S							
H							
O							

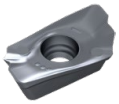
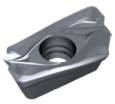
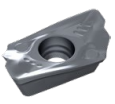
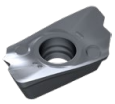
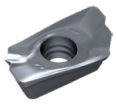
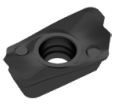
1) Insert radius > 0.063": Modify cutter body

15

XDKT

		-F50 CTPM225 DRAGONSKIN	-M50 CTPM225 DRAGONSKIN	-R50 CTPM225 DRAGONSKIN	-F50 CTCM235 DRAGONSKIN	-M50 CTCM235 DRAGONSKIN	-R50 CTCM235 DRAGONSKIN
							
		F	M	R	F	M	R
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		51 034 ...	51 037 ...	51 039 ...	51 034 ...	51 037 ...	51 039 ...
ISO	RE inch						
11T308SR	0.031	208	208	208	308	308	308
P		●	●	●	●	●	●
M		●	●	●	●	●	●
K							
N							
S							
H							
O							

XDKT

		-F50 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-R50 CTPM240 DRAGONSKIN	-F40 CTPM245 DRAGONSKIN	-F50 CTPM245 DRAGONSKIN	-F40 CTCM245 DRAGONSKIN	-F50 CTCM245 DRAGONSKIN
								
		F	M	R	F	F	F	F
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		51 034 ...	51 037 ...	51 039 ...	51 113 ...	51 034 ...	51 113 ...	51 034 ...
ISO	RE inch							
11T304ER	0.016				454		90401	
11T304SR	0.016		404					
11T308ER	0.031				458		90801	
11T308SR	0.031	408	408	408		458		90801
11T312ER	0.047				462		91201	
11T312SR	0.047	412	412	412				
11T316ER	0.063				466		91601	
11T320ER	0.079				470 [1)]		92001 [1)]	
11T320SR	0.079	420 [1)]	420 [1)]	420 [1)]				
11T325ER	0.098				475 [1)]		92501 [1)]	
11T332ER	0.126				482 [1)]		93201 [1)]	
11T332SR	0.126	432 [1)]	432 [1)]	432 [1)]				
11T340ER	0.157				490 [1)]		94001 [1)]	
P		○	○	○	●	●	●	●
M		●	●	●	●	●	●	●
K								
N								
S							○	○
H								
O								

1) Insert radius > 0.063": Modify cutter body

XDKT / XDHT

ISO	RE inch	-M50 CTCK215 DRAGONSKIN M XDKT 51 037 ...	-R50 CTCK215 DRAGONSKIN R XDKT 51 039 ...	-M50 CTPK220 DRAGONSKIN M XDKT 51 037 ...	-F20 CTWN215 F XDKT 50 478 ...	NEW -F10 CTPX715 DRAGONSKIN F XDHT 51 155 ...	-27P H216T F XDHT 50 477 ...
11T302FR	0.008				502	00202	502
11T304FR	0.016				504	00402	504
11T304SR	0.016	504					
11T308FR	0.031				508	00802	508
11T308SR	0.031	508	508	608			
11T312FR	0.047					01202	512
11T316FR	0.063					01602	516
11T320FR	0.079				520 [1]	02002[1]	520 [1]
11T325FR	0.098				525 [1]	02502[1]	525 [1]
11T332FR	0.126					03202[1]	532 [1]
11T340FR	0.157					04002[1]	540 [1]
11T350FR	0.197					05002[1]	550 [1]
P						○	
M						○	
K		●	●	●	○	●	○
N					●	●	●
S						○	
H							
O					○	○	○

1) Insert radius > 0.063": Modify cutter body

XDKT

ISO	RE inch	-F40 CTC5240 DRAGONSKIN F XDKT 50 463 ...	-F40 CTCS245 DRAGONSKIN F XDKT 51 113 ...	-R60 CTP6215 R XDKT 50 464 ...
11T304ER	0.016	504		
11T308ER	0.031	500	558	
11T308SR	0.031			300
11T312ER	0.047	512	562	
11T316ER	0.063	516	566	
11T320ER	0.079	520 [1]	570 [1]	
11T325ER	0.098	525 [1]	57500[1]	
11T332ER	0.126	532 [1]	582 [1]	
11T340ER	0.157	540 [1]	59000[1]	
P				
M				
K				●
N				
S		●	●	
H				●
O				

1) Insert radius > 0.063": Modify cutter body

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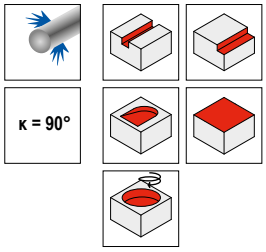
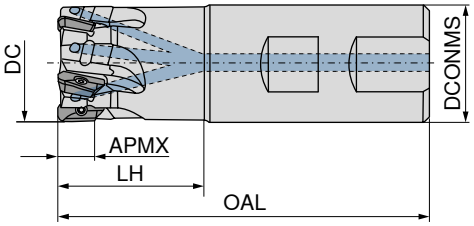
Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 169
Starting parameters	→ 169	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – 211-15 End milling cutter

▲ Insert radius > 0.098": Modify cutter body

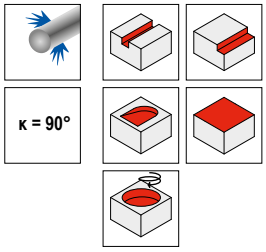


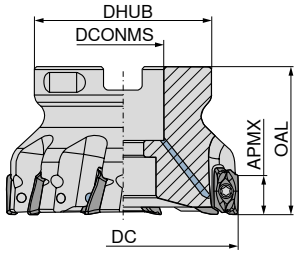


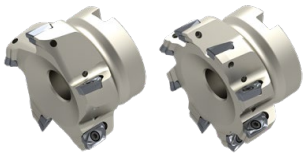
Designation	DC inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	RPMX 1/min.	torque moment Nm	Insert	58 747 ...	58 747 ...
C211.100.R.02-15-A-200-EF-800	1.000	2	0.551	8.000	2.000	1.000	7520	3.2	XD.T 1505	**10002**	
C211.125.R.03-15-B-150-EF-400	1.250	3	0.551	4.000	1.500	1.250	24160	3.2	XD.T 1505		**32503**
C211.125.R.03-15-A-250-EF-1000	1.250	3	0.551	10.000	2.500	1.250	6800	3.2	XD.T 1505	**12503**	
C211.150.R.03-15-B125-200-EF-450	1.500	3	0.551	4.500	2.000	1.250	22160	3.2	XD.T 1505		**35003**
C211.150.R.04-15-B125-200-EF-450	1.500	4	0.551	4.500	2.000	1.250	22160	3.2	XD.T 1505		**35004**
C211.150.R.03-15-A125-300-EF-1000	1.500	3	0.551	10.000	3.000	1.250	6120	3.2	XD.T 1505	**15003**	

MaxiMill – 211-15 Shell mill

▲ Insert radius > 0.098": Modify cutter body







Designation	DC inch	ZNF	APMX inch	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	58 748 ...	58 749 ...
A211.150.R.03-15-A050-175-EF	1.500	3	0.551	1.420	0.500	1.420	22160	3.2	XD.T 1505	**15003**	
A211.200.R.05-15-A075-175-EF	2.000	5	0.551	1.750	0.750	1.750	20320	3.2	XD.T 1505	**20005**	
A211.250.R.06-15-A100-200-EF	2.500	6	0.551	2.250	1.000	2.250	18640	3.2	XD.T 1505	**25006**	
A211.300.R.05-15-A100-200-EF	3.000	5	0.551	2.250	1.000	2.250	17040	3.2	XD.T 1505	**30005**	
A211.300.R.08-15-A100-200-EF	3.000	8	0.551	2.250	1.000	2.250	17040	3.2	XD.T 1505		**30008**
A211.400.R.06-15-A125-200-EF	4.000	6	0.551	2.750	1.250	2.750	16000	3.2	XD.T 1505	**40006**	
A211.400.R.09-15-A125-200-EF	4.000	9	0.551	2.750	1.250	2.750	16000	3.2	XD.T 1505		**40009**
A211.500.R.10-15-B150-250-EF	5.000	10	0.551	3.750	1.500	3.750	14320	3.2	XD.T 1505	**50010**	
A211.600.R.08-15-B150-250-EF	6.000	8	0.551	2.500	1.500	3.750	13200	3.2	XD.T 1505	**60008**	
A211.600.R.10-15-B150-250-EF	6.000	10	0.551	3.750	1.500	3.750	13200	3.2	XD.T 1505		**60010**

Screwdriver

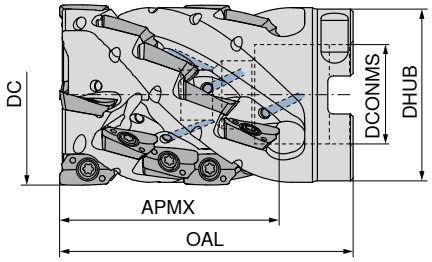
Molykote

Clamping screw

Spare parts DC	80 950 ...	70 950 ...	70 950 ...
1.000 - 6.000	**120**	**303**	**839**

MaxiMill – 211-15K Extended flute cutter

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows

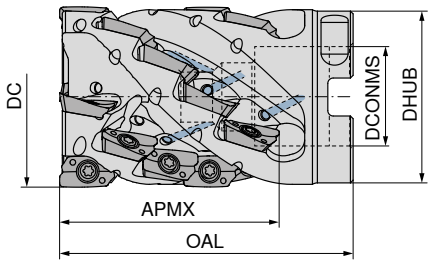


58 759 ...

Designation	DC inch	ZNF	APMX inch	ZEFP	ZNP	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	
A211.200.R.03K4-15-A075-EF	2.000	3	2.000	12	4	3.000	0.750	1.750	13600	3.2	XD.T 1505	**20003**
A211.250.R.04K5-15-A100-EF	2.500	4	2.500	20	5	3.500	1.000	2.250	12500	3.2	XD.T 1505	**25004**
A211.300.R.04K6-15-A125-EF	3.000	4	3.000	24	6	4.000	1.250	2.750	11360	3.2	XD.T 1505	**30104**

MaxiMill – 211-15K Extended flute cutter

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows



58 759 ...

Designation	DC inch	ZNF	APMX inch	ZEFP	ZNP	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	
A211.400.R.05KN6-15-A150-EF	4.000	5	3.091	30	6	4.250	1.500	3.750	10100	3.2	XD.T 1505	**40005**


Cap screw

Screwdriver


Molykote

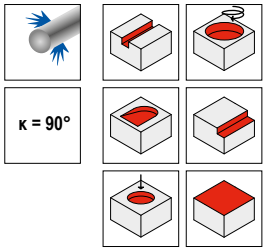

Clamping screw

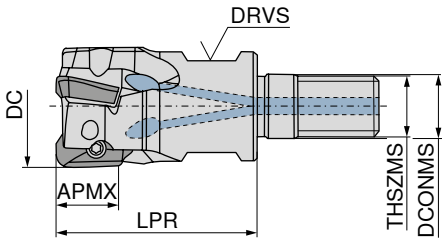
Spare parts DC				
	70 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**
2.000	**002**	**120**	**303**	**839**
2.500 - 3.000	**003**	**120**	**303**	**839**
4.000	**004**	**128**	**303**	**20500**

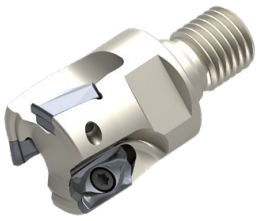
15

MaxiMill – 211-15 Screw in cutter

▲ Insert radius >2.5 mm: Modify cutter body



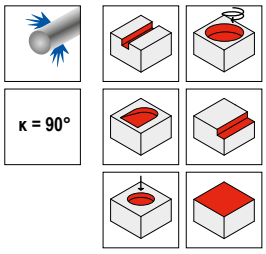


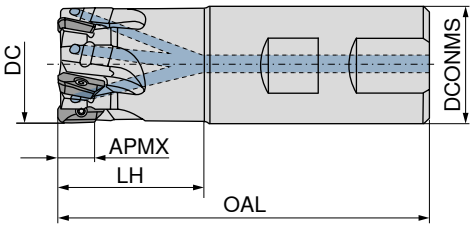


Designation	DC mm	ZNF	APMX mm	LPR mm	DCONMS mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	50 746 ...
G211.25.R.02-15	25	2	14	35	12.5	M12	17	26560	3.2	XD.T 1505	**025**
G211.32.R.03-15	32	3	14	35	17.0	M16	24	30200	3.2	XD.T 1505	**032**
G211.40.R.04-15	40	4	14	40	17.0	M16	27	27700	3.2	XD.T 1505	**040**

MaxiMill – 211-15 End milling cutter

▲ Insert radius >2.5 mm: Modify cutter body

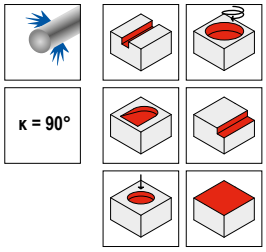


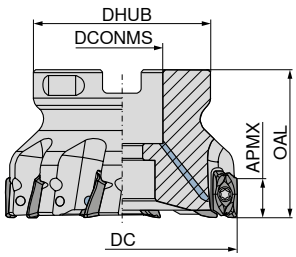


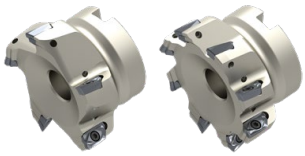
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	RPMX 1/min.	torque moment Nm	Insert	50 747 ...	50 747 ...
C211.25.R.02-15-B20-32	25	2	14	83	32	20	26560	3.2	XD.T 1505		**125**
C211.25.R.02-15-B/A-32	25	2	14	90	32	25	26560	3.2	XD.T 1505	**225**	**025**
C211.25.R.02-15-A-50-225	25	2	14	225	50	25	7520	3.2	XD.T 1505	**325**	
C211.32.R.03-15-B25-40	32	3	14	96	40	25	22160	3.2	XD.T 1505		**132**
C211.32.R.03-15-A-40	32	3	14	103	40	32	24160	3.2	XD.T 1505	**232**	
C211.32.R.03-15-B-40	32	3	14	103	40	32	24160	3.2	XD.T 1505		**032**
C211.32.R.03-15-A-63-250	32	3	14	250	63	32	6800	3.2	XD.T 1505	**332**	
C211.40.R.04-15-A-50	40	4	14	110	50	32	22160	3.2	XD.T 1505	**240**	
C211.40.R.04-15-B32-50	40	4	14	110	50	32	22160	3.2	XD.T 1505		**040**
C211.40.R.03-15-A-50-275	40	3	14	275	50	32	6120	3.2	XD.T 1505	**340**	

MaxiMill – 211-15 Shell mill

▲ Insert radius >2.5 mm: Modify cutter body







Designation	DC mm	ZNF	APMX mm	OAL mm	DCONMS H6 mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert	50 748 ...	50 749 ...
A211.40.R.03-15	40	3	14	40	16	38	22160	3.2	XD.T 1505	**040**	
A211.40.R.04-15	40	4	14	40	16	38	22160	3.2	XD.T 1505		**040**
A211.50.R.03-15	50	3	14	40	22	43	20320	3.2	XD.T 1505	**050**	
A211.50.R.05-15	50	5	14	40	22	43	20320	3.2	XD.T 1505		**050**
A211.63.R.04-15	63	4	14	45	22	48	18640	3.2	XD.T 1505	**063**	
A211.63.R.06-15	63	6	14	45	22	48	18640	3.2	XD.T 1505		**063**
A211.80.R.05-15	80	5	14	50	27	58	17040	3.2	XD.T 1505	**080**	
A211.80.R.08-15	80	8	14	50	27	58	17040	3.2	XD.T 1505		**080**
A211.100.R.06-15	100	6	14	50	32	78	15680	3.2	XD.T 1505	**100**	
A211.100.R.10-15	100	10	14	50	32	78	15680	3.2	XD.T 1505		**100**
A211.125.R.07-15	125	7	14	63	40	88	14320	3.2	XD.T 1505	**125**	
A211.125.R.11-15	125	11	14	63	40	88	14320	3.2	XD.T 1505		**125**
A211.160.R.08-15	160	8	14	63	40	93	13200	3.2	XD.T 1505	**160** 1)	
A211.160.R.12-15	160	12	14	63	40	93	13200	3.2	XD.T 1505		**160** 1)

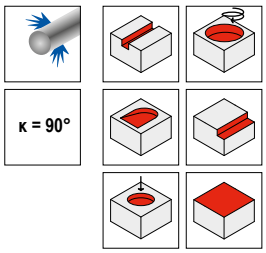
1) Without Through Coolant

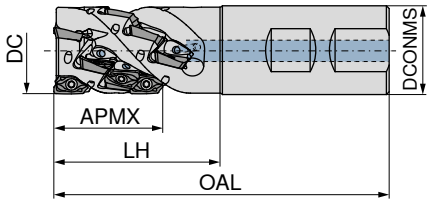
Spare parts DC	TORX® blade **80 950 ...**		 Clamping key – T **80 397 ...**		 Screwdriver **80 950 ...**		 Power Screw **70 950 ...**		 Molykote **70 950 ...**		 Clamping screw **70 950 ...**		 Torque screwdriver **80 950 ...**	
25 - 32	**054**				**128**				**303**		**839**		**193**	
40	**054**		**040**		**128**		**151**		**303**		**839**		**193**	
50	**054**		**050**		**128**		**154**		**303**		**839**		**193**	
63 - 160	**054**				**128**				**303**		**839**		**193**	

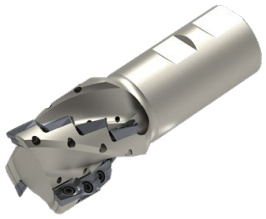
15

MaxiMill – 211-15KN shell end mill shank

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows





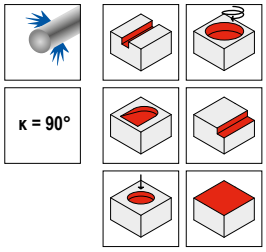


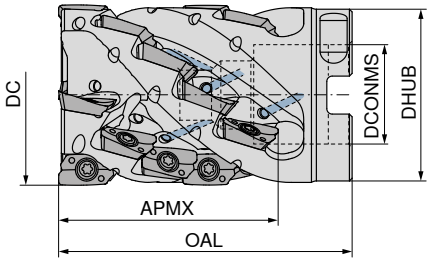
50 783 ...

Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	RPMX 1/min.	torque moment Nm	Insert	
C211.40.R.03KN3-15-B32-60	40	3	39.6	121	60	32	9	3	14800	3.2	XD.T 1505	**04033**
C211.50.R.03KN4-15-B40-68	50	3	52.6	138	67	40	12	4	13600	3.2	XD.T 1505	**05034**

MaxiMill – 211-15KN shell end face mill

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows





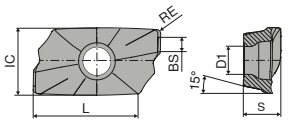
50 781 ...

Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert	
A211.50.R.03KN4-15	50	3	52.6	12	4	87	27	48	13600	3.2	XD.T 1505	**05034**
A211.50.R.03KN5-15	50	3	65.8	15	5	100	27	48	13600	3.2	XD.T 1505	**05035**
A211.50.R.04KN5-15	50	4	65.8	20	5	100	27	48	13600	3.2	XD.T 1505	**05045**
A211.63.R.03KN4-15	63	3	52.6	12	4	76	27	58	12500	3.2	XD.T 1505	**06334**
A211.63.R.03KN5-15	63	3	65.8	15	5	90	27	58	12500	3.2	XD.T 1505	**06335**
A211.63.R.04KN6-15	63	4	78.5	24	6	102	27	58	12500	3.2	XD.T 1505	**06346**
A211.63.R.05KN5-15	63	5	65.8	25	5	90	27	58	12500	3.2	XD.T 1505	**06355**
A211.80.R.04KN5-15	80	4	65.8	20	5	90	32	78	11360	3.2	XD.T 1505	**08045**
A211.80.R.05KN6-15	80	5	78.5	30	6	102	32	78	11360	3.2	XD.T 1505	**08056**

	 Cap screw	TORX® blade	Screwdriver	 Molykote	 Clamping screw	 Socket head screw	Torque screwdriver
	70 950 ...	**80 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts Designation							
A211.50.R.03KN4-15	**002**	**054**	**128**	**303**	**20800**	**181**	**193**
A211.50.R.03KN5-15	**002**	**054**	**128**	**303**	**20800**	**181**	**193**
A211.50.R.04KN5-15	**002**	**054**	**128**	**303**	**20800**	**181**	**193**
A211.63.R.03KN4-15	**002**	**054**	**128**	**303**	**20500**	**181**	**193**
A211.63.R.03KN5-15	**002**	**054**	**128**	**303**	**20500**	**181**	**193**
A211.63.R.04KN6-15	**002**	**054**	**128**	**303**	**20500**	**181**	**193**
A211.63.R.05KN5-15	**002**	**054**	**128**	**303**	**20500**	**181**	**193**
A211.80.R.04KN5-15	**004**	**054**	**128**	**303**	**20500**	**234**	**193**
A211.80.R.05KN6-15	**004**	**054**	**128**	**303**	**20500**	**234**	**193**
C211.40.R.03KN3-15-B32-60		**054**	**128**	**303**	**20800**		**193**
C211.50.R.03KN4-15-B40-68		**054**	**128**	**303**	**20800**		**193**

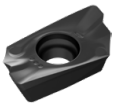
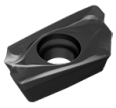
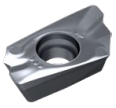
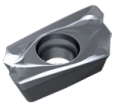
XDKT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XDKT 150508..	0.366	0.173	0.583	0.063	0.219
XDKT 150512..	0.366	0.173	0.583	0.063	0.219
XDKT 150516..	0.366	0.173	0.583	0.063	0.219
XDKT 150520..	0.366	0.173	0.583	0.063	0.219
XDKT 150525..	0.366	0.173	0.583	0.063	0.219
XDKT 150530..	0.366	0.173	0.583	0.063	0.219
XDKT 150532..	0.366	0.173	0.583	0.075	0.219
XDKT 150540..	0.366	0.173	0.583	0.047	0.219
XDKT 150560..	0.366	0.173	0.583	-	0.219



XDKT

XDKT

	-F50 CTCP220 DRAGONSKIN	-M50 CTCP220 DRAGONSKIN	-F50 CTPP225 DRAGONSKIN	-M50 CTPP225 DRAGONSKIN
				
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	XDKT	XDKT	XDKT	XDKT
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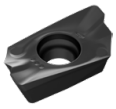
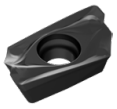
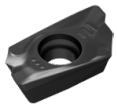
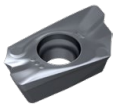
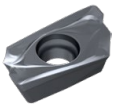
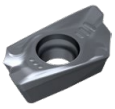
ISO / RE inch				
150508SR 0.031	258	258	058	058
P	●	●	●	●
M				
K				
N				
S				
H				
O				

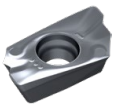
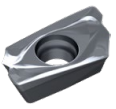
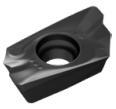
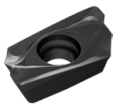
XDKT

	-F50 CTCP230 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-R50 CTCP230 DRAGONSKIN	-F50 CTPP235 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN	-R50 CTPP235 DRAGONSKIN
						
	F	M	R	F	M	R
	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
	51 035 ...	51 038 ...	51 040 ...	51 035 ...	51 038 ...	51 040 ...
ISO / RE inch						
150508SR 0.031	008	008	008	108	108	108
150512SR 0.047		012			112	
150516SR 0.063		016			116	
150520SR 0.079			020		120	120
150530SR 0.118		030 1)			130 1)	
150540SR 0.157		040 1)			140 1)	
P	●	●	●	●	●	●
M				○	○	○
K	○	○	○	○	○	○
N						
S						
H						
O						

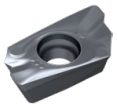
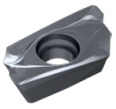
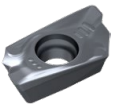
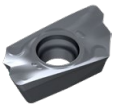
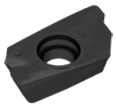
1) Insert radius > 0.098": Modify cutter body

15

XDKT

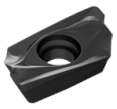
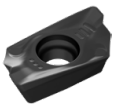
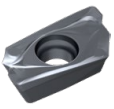
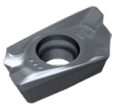
		-F50 CTPM225 DRAGONSKIN	-M50 CTPM225 DRAGONSKIN	-F50 CTCM235 DRAGONSKIN	-M50 CTCM235 DRAGONSKIN
					
		F	M	F	M
		XDKT	XDKT	XDKT	XDKT
		51 035 ...	51 038 ...	51 035 ...	51 038 ...
ISO	RE inch				
150508SR	0.031	208	208	308	308
P		●	●	●	●
M		●	●	●	●
K					
N					
S					
H					
O					

XDKT

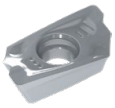
		-F50 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-R50 CTPM240 DRAGONSKIN	-F40 CTPM245 DRAGONSKIN	-F40 CTCM245 DRAGONSKIN
						
		F	M	R	F	F
		XDKT	XDKT	XDKT	XDKT	XDKT
		51 035 ...	51 038 ...	51 040 ...	51 114 ...	51 114 ...
ISO	RE inch					
150508ER	0.031				458	90801
150508SR	0.031	408	408	408		
150512ER	0.047					91201
150512SR	0.047		412			
150516ER	0.063					91601
150516SR	0.063		416			
150520ER	0.079					92001
150525ER	0.098					92501
150530SR	0.118		430 1)			
150532ER	0.126				482 1)	93201 1)
150540ER	0.157				490 1)	94001 1)
150540SR	0.157		440 1)			
150560ER	0.236					96001 1)
P		○	○	○	●	●
M		●	●	●	●	●
K						
N						
S						○
H						
O						

1) Insert radius > 0.098": Modify cutter body

XDKT

	-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F20 CTWN215
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
					
	M	R	M	R	F
	XDKT	XDKT	XDKT	XDKT	XDKT
	51 038 ...	51 040 ...	51 038 ...	51 040 ...	50 479 ...
ISO / RE inch					
150508FR 0.031					508
150508SR 0.031	508	508	608	608	
P					
M					
K	●	●	●	●	○
N					●
S					
H					
O					○

XDKT

	-F40 CTC5240	-F40 CTCS245	-R60 CTP6215
	DRAGONSKIN	DRAGONSKIN	
			
	F	F	R
	XDKT	XDKT	XDKT
	50 473 ...	51 114 ...	50 469 ...
ISO / RE inch			
150508ER 0.031	508	558	
150508SR 0.031			300
150532ER 0.126	532 [1]		
150540ER 0.157	540 [1]	59000[1]	
P			
M			
K			●
N			
S	●	●	
H			●
O			

1) Insert radius > 0.098": Modify cutter body

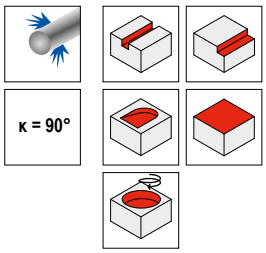
Milling guide

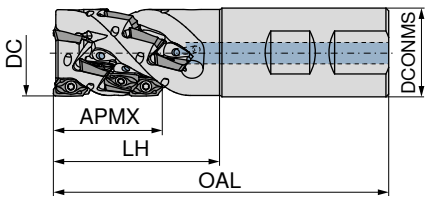
Cutting data standard values	→ 154–157	Machining strategy	→ 170
Starting Parameter	→ 170	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

15

MaxiMill – 211-20K End milling cutter

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows



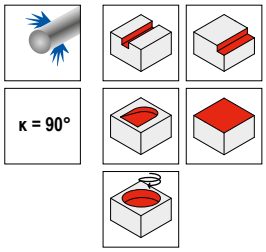


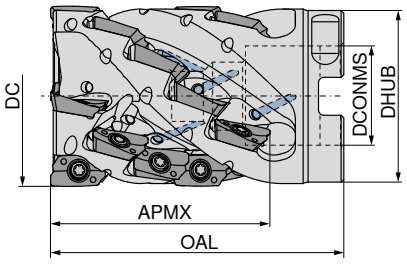
58 779 ...

Designation	DC inch	ZNF	APMX inch	ZNP	ZEFP	OAL inch	LH inch	DCONMS inch	torque moment Nm	Insert	
C211.200.R.03K10-20-B200-EF	2.000	3	6.500	10	30	11.000	6.690	2.000	5	XD.. 2007..	**20003**

MaxiMill – 211-20K Extended flute cutter

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows





NEW

58 780 ...

Designation	DC inch	ZNF	APMX inch	ZNP	ZEFP	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	Insert	
A211.250.R.04K4-20-A100-EF	2.500	4	2.650	4	16	3.750	1.000	2.250	14300	XD.. 2007..	**25004**
A211.300.R.05K5-20-A125-EF	3.000	5	3.250	5	20	4.250	1.250	2.750	12800	XD.. 2007..	**30005**
A211.400.R.05K5-20-A150-EF	4.000	5	3.340	5	20	4.250	1.500	3.750	10100	XD.. 2007..	**40005**


Cap screw

Screwdriver

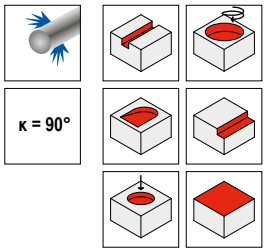

Molykote

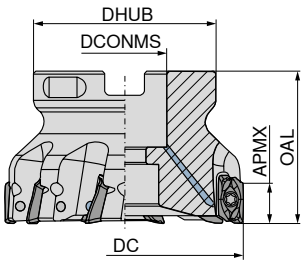

Clamping screw

70 950 ... | **80 950 ...** | **70 950 ...** | **70 950 ...**

Spare parts DC				
2.000		**106**	**303**	**01200**
2.500	**003**	**106**	**303**	**01200**
3.000	**004**	**106**	**303**	**01200**
4.000	**004**	**106**	**303**	**01200**

MaxiMill – 211-20 Shell mill



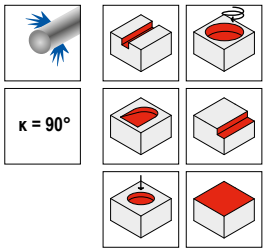


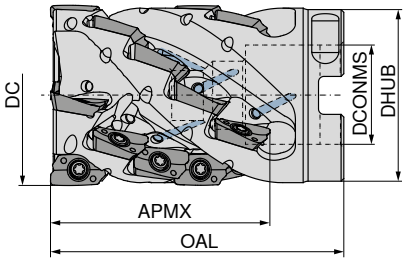
50 778 ...

Designation	DC mm	ZNF	APMX mm	OAL mm	DCONMS H6 mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert	
A211.63.R.05-20	63	5	19	45	22	48	14400	5	XD.. 2007..	**06305**
A211.80.R.06-20	80	6	19	50	27	58	12400	5	XD.. 2007..	**08006**
A211.100.R.07-20	100	7	19	50	32	78	10900	5	XD.. 2007..	**10007**

MaxiMill – 211-20K shell end face mill

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows





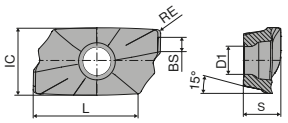
50 780 ...

Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS H6 mm	DHUB mm	torque moment Nm	Insert	
A211.63.R.04K4-20	63	4	68	16	4	92	27	58	5	XD.. 2007..	**06304**
A211.80.R.05K4-20	80	5	68	20	4	92	32	76	5	XD.. 2007..	**08005**

	 Cap screw	TORX® blade	Screwdriver	 Molykote	 Clamping screw	 Socket head screw	 Torque screwdriver
	70 950 ...	**80 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
50 778 06305		**037**	**106**	**303**	**01200**	**180**	**193**
50 778 08006		**037**	**106**	**303**	**01200**	**181**	**193**
50 778 10007		**037**	**106**	**303**	**01200**		**193**
50 780 06304	**003**	**037**	**106**	**303**	**01200**	**181**	**193**
50 780 08005	**004**	**037**	**106**	**303**	**01200**	**234**	**193**

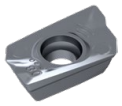
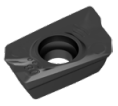
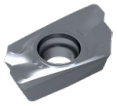
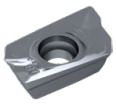
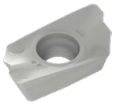
XDKT

Designation	IC inch	D1 inch	L inch	S inch
XDKT 200708..	0.492	0.217	0.740	0.273
XDKT 200716..	0.492	0.217	0.740	0.271
XDKT 200732..	0.492	0.217	0.740	0.269
XDKT 200740..	0.492	0.217	0.740	0.268
XDKT 200760..	0.492	0.217	0.740	0.268



XDKT

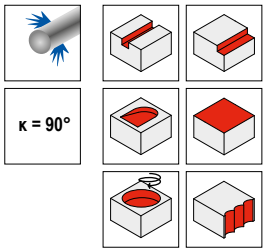
XDKT

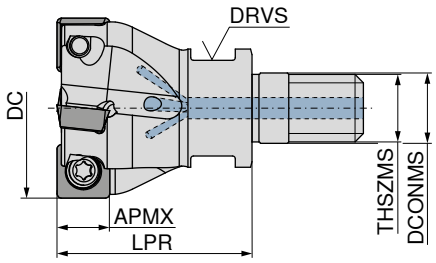
		-M50 CTPP235	-M50 CTCP230	-F40 CTPM245	-F40 CTCM245	-M50 CTPK220	-F40 CTC5240	-F40 CTCS245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	F	F	M	F	F
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		51 145 ...	51 145 ...	51 127 ...	51 127 ...	51 145 ...	51 127 ...	51 127 ...
ISO	RE inch							
200708ER	0.031	10800	00800	45800	90801	60800	15800	55800
200716ER	0.063	11600	01600	46600	91601	61600	16600	56600
200732ER	0.126			48200	93201		18200	58200
200740ER	0.157				94001		19000	
200760ER	0.236				96001		19200	
P		●	●	●	●			
M		○		●	●			
K		○	○			●		
N								
S					○		●	●
H								
O								

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 171
Starting Parameter	→ 171	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – 490-09 Screw in cutter

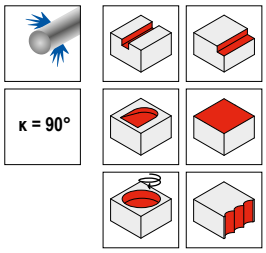


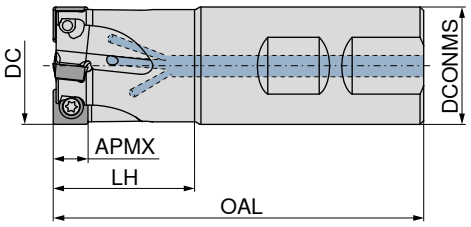


Designation	DC inch	ZNF	APMX inch	LPR inch	THSZMS	DCONMS inch	RPMX 1/min.	torque moment Nm	Insert	58 726 ...
G490.100.R.03-09-125-F	1.000	3	0.315	1.250	M12	0.492	23700	3.2	SD.. 09T3..	10003[1)]
G490.125.R.04-09-150-F	1.250	4	0.315	1.500	M16	0.669	19700	3.2	SD.. 09T3..	12504[1)]

1) Not in stock

MaxiMill – 490-09 End milling cutter





Designation	DC inch	ZNF	APMX inch	DCONMS inch	OAL inch	LH inch	RPMX 1/min.	torque moment Nm	Insert	58 727 ...	58 727 ...
C490.100.R.03-09-B-125-EF	1.000	3	0.315	1.000	3.500	1.250	23700	3.2	SD.. 09T3..		30003
C490.100.R.02-09-A-150-EF-800	1.000	2	0.315	1.000	8.000	1.500	19700	3.2	SD.. 09T3..	10002	
C490.125.R.04-09-B-150-EF	1.250	4	0.315	1.250	3.750	1.500	22000	3.2	SD.. 09T3..		32504
C490.125.R.03-09-A-200-EF-1000	1.250	3	0.315	1.250	10.000	2.000	14700	3.2	SD.. 09T3..	12503	


Screwdriver

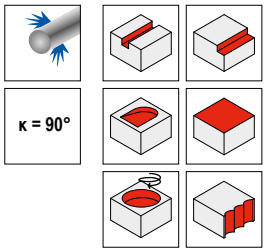

Molykote

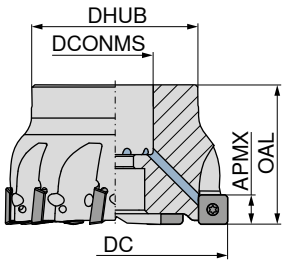

Clamping screw

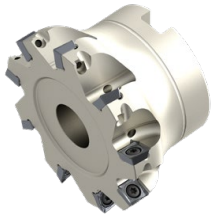
Spare parts DC	Screwdriver 80 950 ...	Molykote 70 950 ...	Clamping screw 70 950 ...
1.000 - 1.250	105	303	110

15

MaxiMill – 490-09 Shell mill







58 728 ...

Designation	DC inch	ZNF	APMX inch	DHUB inch	DCONMS $_{H6}$ inch	OAL inch	RPMX 1/min.	torque moment Nm	Insert	
A490.150.R.05-09-A050-175-EF	1.500	5	0.315	1.250	0.500	1.750	17000	3.2	SD.. 09T3..	**15005**
A490.200.R.06-09-A075-175-EF	2.000	6	0.315	1.750	0.750	1.750	14800	3.2	SD.. 09T3..	**20006**
A490.250.R.07-09-A100-200-EF	2.500	7	0.315	2.000	1.000	2.000	12850	3.2	SD.. 09T3..	**25007**
A490.300.R.09-09-A100-200-EF	3.000	9	0.315	2.130	1.000	2.000	11250	3.2	SD.. 09T3..	**30009**
A490.400.R.10-09-B125-200-EF	4.000	10	0.315	2.870	1.250	2.000	9900	3.2	SD.. 09T3..	**40010**
A490.500.R.11-09-B200-200-EF	5.000	11	0.315	3.750	2.000	2.000		3.2	SD.. 09T3..	**50011**
A490.600.R.12-09-B200-200-EF	6.000	12	0.315	3.750	2.000	2.000		3.2	SD.. 09T3..	**60012**

Screwdriver

80 950 ...

Molykote

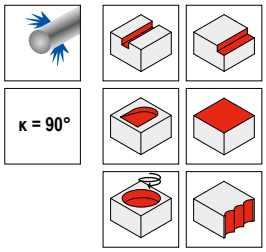
70 950 ...

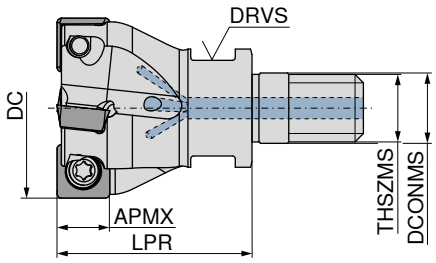
Clamping screw

70 950 ...

Spare parts			
DC			
1.500 - 6.000	**105**	**303**	**110**

MaxiMill – 490-09 Screw in cutter

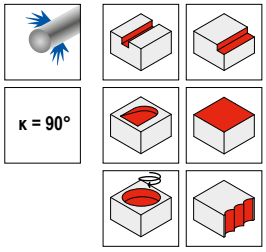


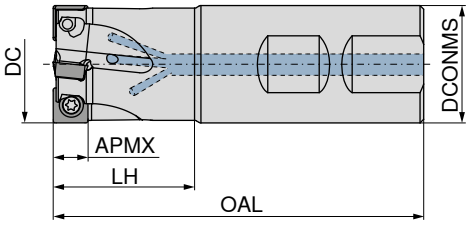


50 726 ...

Designation	DC mm	ZNF	APMX mm	LPR mm	THSZMS	DCONMS mm	DRVS mm	torque moment Nm	Insert	
G490.25.R.03-09	25	3	8	35	M12	12.5	17	3.2	SD.. 09T3..	**025**
G490.32.R.04-09	32	4	8	35	M16	17.0	24	3.2	SD.. 09T3..	**032**

MaxiMill – 490-09 End milling cutter

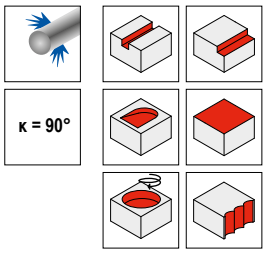


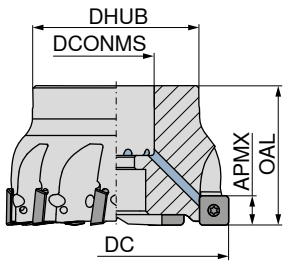


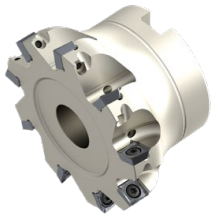
50 727 ... **50 727 ...**

Designation	DC mm	ZNF	APMX mm	DCONMS mm	OAL mm	LH mm	torque moment Nm	Insert		
C490.25.R.03-09-B-32	25	3	8	25	88	32	3.2	SD.. 09T3..		**025**
C490.25.R.02-09-A-20	25	2	8	20	165	40	3.2	SD.. 09T3..	**225**	
C490.25.R.02-09-A-40-165	25	2	8	25	165	40	3.2	SD.. 09T3..	**125**	
C490.32.R.04-09-B-25	32	4	8	25	100	40	3.2	SD.. 09T3..		**132**
C490.32.R.04-09-B-40	32	4	8	32	100	40	3.2	SD.. 09T3..		**032**

MaxiMill – 490-09 Shell mill





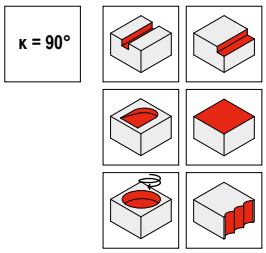


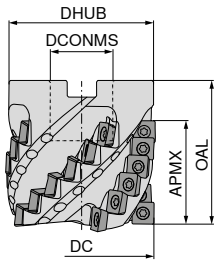
50 728 ...

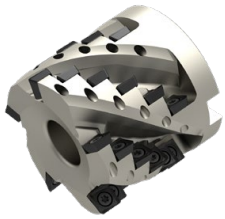
Designation	DC mm	ZNF	APMX mm	DHUB mm	DCONMS H6 mm	OAL mm	torque moment Nm	Insert	
A490.40.R.05-09	40	5	8	38	16	40	3.2	SD.. 09T3..	**040**
A490.42.R.06-09	42	6	8	38	16	40	3.2	SD.. 09T3..	**042**
A490.50.R.06-09	50	6	8	43	22	40	3.2	SD.. 09T3..	**050**
A490.52.R.07-09	52	7	8	43	22	40	3.2	SD.. 09T3..	**052**
A490.63.R.07-09	63	7	8	48	22	40	3.2	SD.. 09T3..	**063**
A490.66.R.08-09	66	8	8	48	22	40	3.2	SD.. 09T3..	**066**
A490.80.R.09-09	80	9	8	58	27	50	3.2	SD.. 09T3..	**080**
A490.100.R.10-09	100	10	8	78	32	50	3.2	SD.. 09T3..	**100**

MaxiMill – 490-09K shell end face mill

▲ ZEFP = Number of Inserts
▲ ZNP = Number of rows





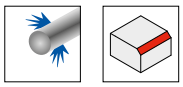


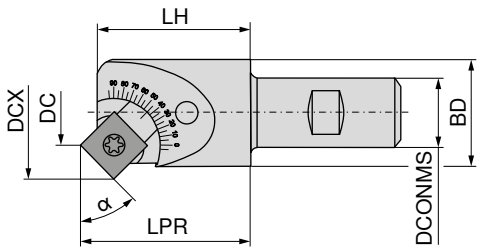
50 761 ...

Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS H6 mm	DHUB mm	torque moment Nm	Insert	
A490.40.R.03K6-09	40	3	41	18	6	55	16	38	3.2	SD.. 09T3..	**040**
A490.50.R.04K6-09	50	4	41	24	6	55	22	48	3.2	SD.. 09T3..	**050**
A490.63.R.05K6-09	63	5	41	30	6	60	27	61	3.2	SD.. 09T3..	**063**

	TORX® blade	 Clamping key – T	Screwdriver	 Power Screw	 Molykote	 Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts DC							
25 - 32	**036**		**113**		**303**	**110**	**192**
40 - 42	**036**	**040**	**113**	**151**	**303**	**110**	**192**
50 - 100	**036**		**113**		**303**	**110**	**192**

MaxiMill – 490-09 Adjustable single angle milling cutter





NEW

50 690 ...

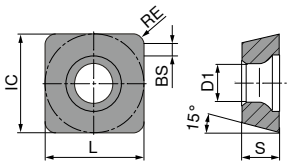
Designation	DC mm	DCX mm	LH mm	BD mm	LPR mm	ZNF	DCONMS mm	torque moment Nm	Insert	
C490.20.R.01	1.6 - 11.1	20.1 - 23.6	32	18.65	32.9 - 34.6	1	16	3.2	SD.. 09T3..	**01600**

	 Cylindrical screw	 Adjustment wedge	TORX® blade	Screwdriver	 Molykote	 Clamping screw	Torque screwdriver
	70 950 ...	**70 950 ...**	**80 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts for Article no.							
50 690 01600	**87500**	**87200**	**036**	**113**	**303**	**110**	**192**

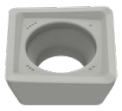
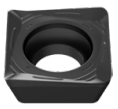
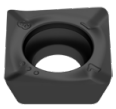
→ **Page 172**
Here you will find the angle-dependent dimensions.

SDHT / SDNT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
SD.T 09T3..	0.375	0.173	0.375	0.098	0.156

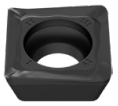
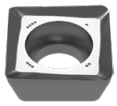


SDHT / SDNT

	TCM10	-29 CTCP230	CTPP235	-29 CTPP235	-33 CTPM240	-F50 CTPM245	-F50 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	CERMET						
	SDHT	SDNT	SDNT	SDNT	SDNT	SDNT	SDNT
	50 424 ...	51 011 ...	51 082 ...	51 011 ...	51 030 ...	51 111 ...	51 111 ...
ISO / RE inch							
09T308ER 0.031			108			458	90801
09T308SR 0.031	900	008		108	408		
P	●	●	●	●	○	●	●
M			○	○	●	●	●
K	○	○	○	○			
N							
S							○
H							
O							

SDNT / SDHT

NEW

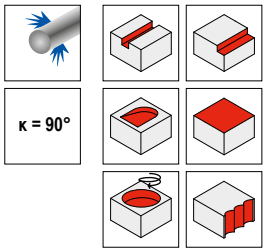
	-31 CTCK215	-F10 CTPX715	-27P H216T	-27 CTC5240	-M31 CTC5240	-F10 CTCS245
	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	SDNT	SDHT	SDHT	SDHT	SDNT	SDHT
	51 029 ...	51 125 ...	50 424 ...	50 496 ...	50 425 ...	51 125 ...
ISO / RE inch						
09T308ER 0.031				508	508	55800
09T308FR 0.031		00802	550			
09T308SR 0.031	508					
P		○				
M		○				
K	●	●	○			
N		●	●			
S		○		●	●	●
H						
O		○	○			

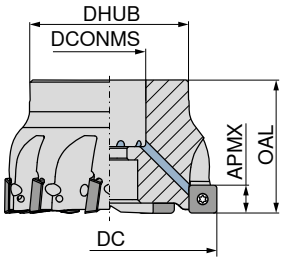
Milling guide

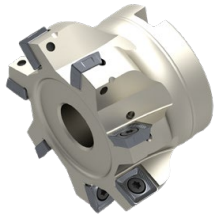
Cutting data standard values	→ 154–157	Starting Parameter	→ 172
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

15

MaxiMill – 490-12 Shell mill







58 703 ...

Designation	DC inch	ZNF	APMX inch	DHUB inch	DCONMS inch	OAL inch	torque moment Nm	Insert	
A490.200.R.05-12-A075-175-EF	2.000	5	0.393	1.750	0.750	1.750	5	SD.. 1205..	**20005**


Screwdriver

80 950 ...


Molykote

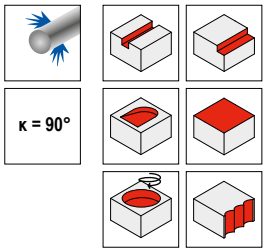
70 950 ...

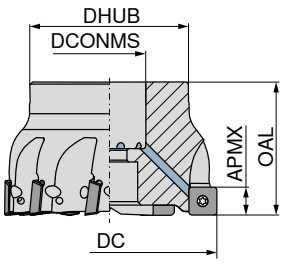

Clamping screw

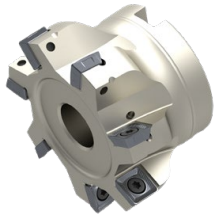
70 950 ...

Spare parts DC			
2.000	**106**	**303**	**01200**

MaxiMill – 490-12 Shell mill





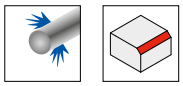


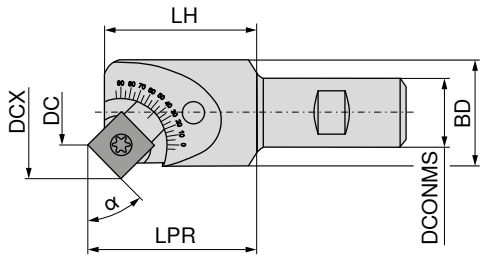
50 703 ...

Designation	DC mm	ZNF	APMX mm	DHUB mm	DCONMS mm	OAL mm	torque moment Nm	Insert	
A490.40.R.04-12	40	4	11	38	16	40	5	SD.. 1205..	**54000**
A490.50.R.05-12	50	5	11	43	22	40	5	SD.. 1205..	**550**
A490.63.R.06-12	63	6	11	48	22	40	5	SD.. 1205..	**563**
A490.80.R.07-12	80	7	11	58	27	50	5	SD.. 1205..	**580**
A490.100.R.08-12	100	8	11	75	32	50	5	SD.. 1205..	**600**
A490.125.R.10-12	125	10	11	88	40	63	5	SD.. 1205..	**625**

	TORX® blade	 Clamping key – T	 Screwdriver	 Power Screw	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
40	**037**	**040**	**114**	**151**	**303**	**01200**	**193**
50	**037**	**040**	**114**	**154**	**303**	**01200**	**193**
63 - 125	**037**	**040**	**114**		**303**	**01200**	**193**

MaxiMill – 490-12 Adjustable single angle milling cutter





NEW

50 690 ...

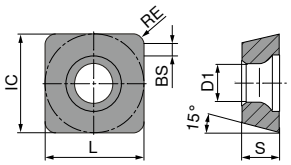
Designation	DC mm	DCX mm	LH mm	BD mm	LPR mm	ZNF	DCONMS mm	torque moment Nm	Insert	
C490.26.R.01	1.1 - 14.1	26.6 - 31.5	37	25	38.2 - 40.6	1	20	5	SD.. 1205..	**02000**

	 Cylindrical screw	 Adjustment wedge	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	70 950 ...	**70 950 ...**	**80 950 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
50 690 02000	**87400**	**87300**	**037**	**114**	**303**	**01200**	**193**

→ **Page 173**
Here you will find the angle-dependent dimensions.

SDHW / SDMT / SDHT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
SDH. 120508..	0.500	0.217	0.500	0.087	0.197
SDHT 120512..	0.500	0.217	0.500	0.071	0.197
SDHT 120520..	0.500	0.217	0.500	0.039	0.197
SDHT 120525..	0.500	0.217	0.500	0.059	0.197
SDMT 120508..	0.500	0.217	0.500	0.118	0.197
SDMT 1205ZZ..	0.500	0.217	0.500	0.035	0.197

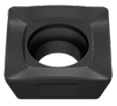
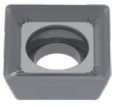
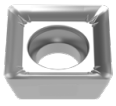
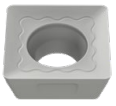


SDHW / SDMT / SDHT

	TCM10	-29 CTCP230	-29 CTPP235	-29 CTPM240	-33 CTPM240	-F50 CTPM245	-F50 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	CERMET						
	SDHW	SDMT	SDMT	SDMT	SDHT	SDMT	SDMT
	50 428 ...	51 081 ...	51 081 ...	51 081 ...	51 028 ...	51 110 ...	51 110 ...
ISO / RE inch							
120508ER 0.031						458	90801
120508SR 0.031	901						
120512SR 0.047					412		
120520SR 0.079					421		
1205ZZSN 0.031		020	120	420			
P	●	●	●	○	○	●	●
M			○	●	●	●	●
K	○	○	○				
N							
S							○
H							
O							

SDMT / SDHT

NEW

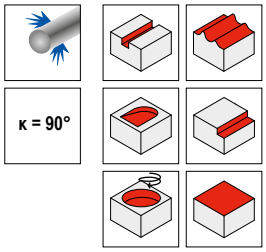
	-31 CTCK215	-F10 CTPX715	-27P H216T	-M31 CTC5240	-F50 CTCS245
	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
					
	SDMT	SDHT	SDHT	SDMT	SDMT
	51 059 ...	51 161 ...	50 426 ...	50 580 ...	51 110 ...
ISO / RE inch					
120508ER 0.031				508	55800
120508FR 0.031		00802	555		
120525FR 0.098			559		
1205ZZSN 0.031	521				
P		○			
M		○			
K	●	●	○		
N		●	●		
S		○		●	●
H					
O		○	○		

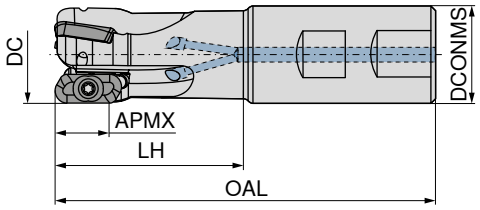
Milling guide

Cutting data standard values	→ 154–157	Starting Parameter	→ 173
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – HSC-11 End milling cutter 90°

▲ Insert radius > 0.125": Modify cutter body
▲ High Speed Cutter (HSC)



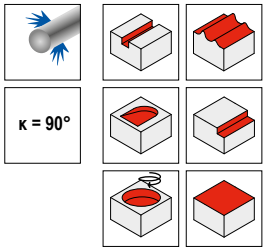


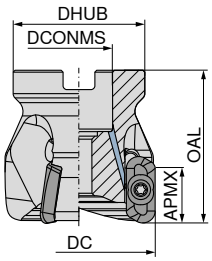
58 675 ...

Designation	DC inch	ZNF	APMX inch	DCONMS h6 inch	OAL inch	LH inch	torque moment Nm	Insert	
CHSC.0625.R.02-11-A-100-EF	0.625	2	0.393	0.625	3.000	1.000	1.8	XDHT 11T3..	**06202**
CHSC.0625.R.02-11-A-125-EF	0.625	2	0.393	0.625	3.250	1.250	1.8	XDHT 11T3..	**06302**
CHSC.0750.R.02-11-A-150-EF	0.750	2	0.393	0.750	3.600	1.500	1.8	XDHT 11T3..	**07502**
CHSC.100.R.03-11-A-200-EF	1.000	3	0.393	1.000	4.350	2.000	1.8	XDHT 11T3..	**10003**

MaxiMill – HSC-11 Shell mill 90°

▲ Insert radius > 0.125": Modify cutter body
▲ High Speed Cutter (HSC)





58 718 ...

Designation	DC inch	ZNF	APMX inch	DCONMS H6 inch	DHUB inch	OAL inch	torque moment Nm	Insert	
AHSC.150.R.04-11-A050-175-EF	1.500	4	0.393	0.500	1.421	1.750	1.8	XDHT 11T3..	**15004**
AHSC.200.R.04-11-A075-175-EF	2.000	4	0.393	0.750	1.750	1.750	1.8	XDHT 11T3..	**20004**
AHSC.250.R.05-11-A100-200-EF	2.500	5	0.393	1.000	2.250	2.000	1.8	XDHT 11T3..	**25005**
AHSC.300.R.05-11-A100-200-EF	3.000	5	0.393	1.000	2.250	2.000	1.8	XDHT 11T3..	**30005**

Screwdriver

80 950 ...

Molykote

70 950 ...

Clamping screw

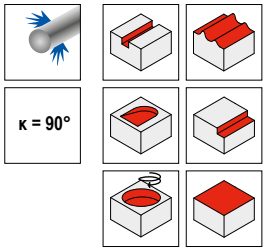
70 950 ...

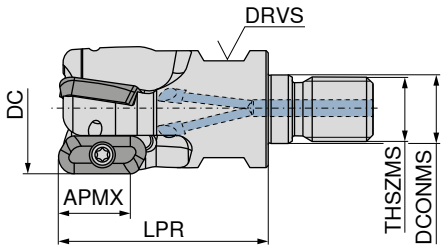
Spare parts DC			
0.625 - 1.000	**039**	**303**	**128**
1.500 - 3.000	**039**	**303**	**131**

15

MaxiMill – HSC-11 Screw in cutter

▲ Insert radius >3.2 mm: Modify cutter body

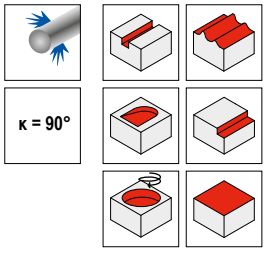


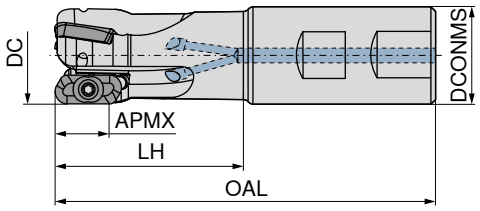


Designation	DC mm	ZNF	APMX mm	DCONMS mm	LPR mm	THSZMS	RPMX 1/min.	DRVS mm	torque moment Nm	Insert	55 107 ...
GHSC.16.R.02-11	16	2	10	8.5	27	M8	56000	10	1.8	XDHT 11T3..	**016**
GHSC.20.R.02-11	20	2	10	10.5	33	M10	50100	15	1.8	XDHT 11T3..	**020**
GHSC.25.R.03-11	25	3	10	12.5	35	M12	45000	17	1.8	XDHT 11T3..	**025**
GHSC.32.R.03-11	32	3	10	17.0	35	M16	39800	24	1.8	XDHT 11T3..	**032**
GHSC.40.R.03-11	40	3	10	17.0	35	M16	35500	24	1.8	XDHT 11T3..	**040**

MaxiMill – HSC-11 End milling cutter

▲ Insert radius >3.2 mm: Modify cutter body

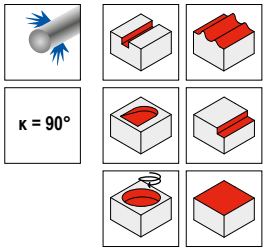


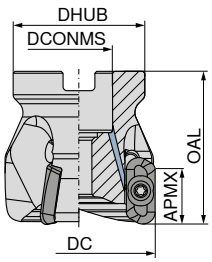


Designation	DC mm	ZNF	APMX mm	DCONMS $_{h6}$ mm	OAL mm	LH mm	RPMX 1/min.	torque moment Nm	Insert	50 675 ...	50 675 ...
CHSC.16.R.02-11-B/A-25	16	2	10	16	75	25	56200	1.8	XDHT 11T3..	**016**	**416**
CHSC.16.R.02-11-A-32	16	2	10	16	165	32	18800	1.8	XDHT 11T3..	**116**	
CHSC.20.R.02-11-A-32	20	2	10	20	84	32	50100	1.8	XDHT 11T3..	**020**	
CHSC.20.R.03-11-B-32	20	3	10	20	84	32	50100	1.8	XDHT 11T3..		**420**
CHSC.20.R.02-11-A-40	20	2	10	20	165	40	26700	1.8	XDHT 11T3..	**120**	
CHSC.25.R.03-11-A-40	25	3	10	25	98	40	45000	1.8	XDHT 11T3..	**225**	
CHSC.25.R.04-11-B-40	25	4	10	25	98	40	45000	1.8	XDHT 11T3..		**425**
CHSC.25.R.02-11-A-50	25	2	10	25	165	50	31700	1.8	XDHT 11T3..	**125**	
CHSC.25.R.03-11-A-50	25	3	10	25	165	50	31700	1.8	XDHT 11T3..	**325**	

MaxiMill – HSC-11 Shell mill

▲ Insert radius >3.2 mm: Modify cutter body



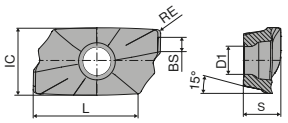


Designation	DC mm	ZNF	APMX mm	DCONMS $_{H6}$ mm	DHUB mm	OAL mm	RPMX 1/min.	torque moment Nm	Insert	50 718 ...
AHSC.40.R.04-11	40	4	10	16	38	50	35500	1.8	XDHT 11T3..	**040**
AHSC.50.R.04-11	50	4	10	22	43	50	31800	1.8	XDHT 11T3..	**050**
AHSC.63.R.05-11	63	5	10	22	43	50	28300	1.8	XDHT 11T3..	**063**
AHSC.80.R.05-11	80	5	10	27	58	50	25100	1.8	XDHT 11T3..	**080**
AHSC.100.R.05-11	100	5	10	32	78	50	22400	1.8	XDHT 11T3..	**100**

Spare parts DC	TORX® blade **80 950 ...**		 Clamping key – T **80 397 ...**		 Screwdriver **80 950 ...**		 Power Screw **70 950 ...**		 Molykote **70 950 ...**		 Clamping screw **70 950 ...**		 Torque screwdriver **80 950 ...**	
16 - 25	**043**				**125**				**303**		**128**		**192**	
32	**043**				**125**				**303**		**131**		**192**	
40	**043**		**040**		**125**		**151**		**303**		**131**		**192**	
50 - 63	**043**		**050**		**125**		**154**		**303**		**131**		**192**	
80 - 100	**043**				**125**				**303**		**131**		**192**	

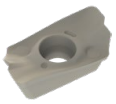
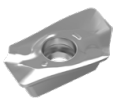
XDKT / XDHT

Designation	IC inch	D1 inch	L inch	BS inch	S inch
XD.T 11T302FR	0.268	0.110	0.417	0.079	0.150
XD.T 11T304FR	0.268	0.110	0.417	0.071	0.150
XD.T 11T308FR	0.268	0.110	0.417	0.055	0.150
XD.T 11T320FR	0.268	0.110	0.417	0.055	0.150
XD.T 11T325FR	0.268	0.110	0.417	0.055	0.150
XDHT 11T312FR	0.268	0.110	0.417	0.055	0.150
XDHT 11T316FR	0.268	0.110	0.417	0.055	0.150
XDHT 11T332FR	0.268	0.110	0.417	0.031	0.150
XDHT 11T340FR	0.268	0.110	0.417	-	0.150
XDHT 11T350FR	0.268	0.110	0.417	-	0.150



XDKT

XDKT / XDHT

	-F20 CTWN215	-27P H216T
		
	F	F
	XDKT	XDHT
	50 478 ...	50 477 ...

ISO	RE inch		
11T302FR	0.008	502	502
11T304FR	0.016	504	504
11T308FR	0.031	508	508
11T312FR	0.047		512
11T316FR	0.063		516
11T320FR	0.079	520 1)	520 1)
11T325FR	0.098	525 1)	525 1)
11T332FR	0.126		532 1)
11T340FR	0.157		540 1)
11T350FR	0.197		550 1)
P			
M			
K		○	○
N		●	●
S			
H			
O		○	○

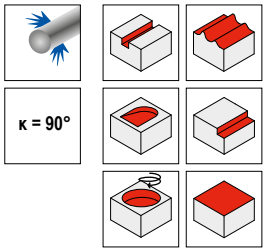
1) Insert radius > 0.063": Modify cutter body

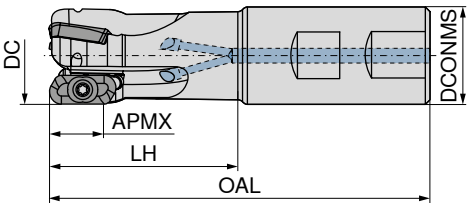
Milling guide

Safety advice	→ 174	Cutting data standard values	→ 175
Machining strategy	→ 176+177	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – HSC-19 End milling cutter 90°

▲ Insert radius > 0.157": Modify cutter body
▲ High Speed Cutter (HSC)



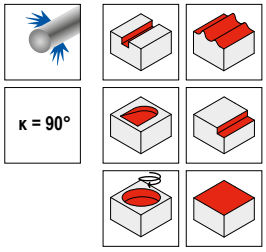


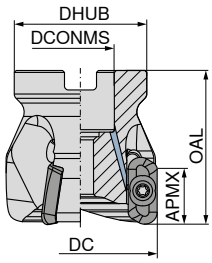
58 679 ...

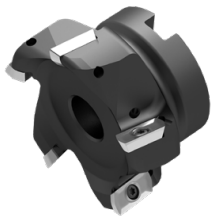
Designation	DC inch	ZNF	APMX inch	DCONMS h5 inch	OAL inch	LH inch	RPMX 1/min.	torque moment Nm	Insert	
CHSC.100.R.02-19-A-200-EF	1.000	2	0.709	1.000	4.500	2.000	35000	5	XDHT 1904..	**10002**
CHSC.100.R.02-19-A-250-EF	1.000	2	0.709	1.000	6.500	2.500	32800	5	XDHT 1904..	**10102**
CHSC.125.R.02-19-A-250-EF	1.250	2	0.709	1.250	5.000	2.500	29100	5	XDHT 1904..	**12502**
CHSC.125.R.02-19-A-325-EF	1.250	2	0.709	1.250	6.500	3.250	27200	5	XDHT 1904..	**12602**
CHSC.150.R.03-19-A125-325-EF	1.500	3	0.709	1.250	5.750	3.250	23800	5	XDHT 1904..	**15003**
CHSC.150.R.03-19-A125-400-EF	1.500	3	0.709	1.250	6.500	4.000	21900	5	XDHT 1904..	**15103**

MaxiMill – HSC-19 Shell mill 90°

▲ Insert radius > 0.157": Modify cutter body
▲ High Speed Cutter (HSC)

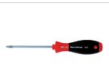






58 716 ...

Designation	DC inch	ZNF	APMX inch	DCONMS H6 inch	DHUB inch	OAL inch	RPMX 1/min.	torque moment Nm	Insert	
AHSC.200.R.03-19-A075-175-EF	2.000	3	0.709	0.750	1.750	1.750	21600	5	XDHT 1904..	**20003**
AHSC.250.R.03-19-A100-200-EF	2.500	3	0.709	1.000	2.250	2.250	18800	5	XDHT 1904..	**25003**
AHSC.250.R.04-19-A100-200-EF	2.500	4	0.709	1.000	2.250	2.250	18800	5	XDHT 1904..	**25004**
AHSC.300.R.03-19-A100-200-EF	3.000	3	0.709	1.000	2.250	2.250	16400	5	XDHT 1904..	**30003**
AHSC.300.R.04-19-A100-200-EF	3.000	4	0.709	1.000	2.250	2.250	16400	5	XDHT 1904..	**30004**
AHSC.400.R.04-19-B125-200-EF	4.000	4	0.709	1.250	2.750	2.750	14500	5	XDHT 1904..	**40004**
AHSC.500.R.05-19-B150-200-EF	5.000	5	0.709	1.500	3.750	3.750	12800	5	XDHT 1904..	**50005**
AHSC.600.R.05-19-B150-200-EF	6.000	5	0.709	1.500	3.750	3.750	11500	5	XDHT 1904..	**60005**


Screwdriver
80 950 ...


Molykote
70 950 ...

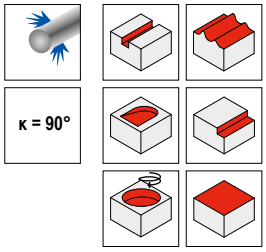

Clamping screw
70 950 ...

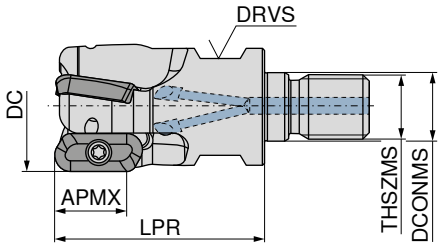
Spare parts DC					
1.000	**105**		**303**		**172**
1.250	**039**		**303**		**128**
1.250 - 1.500	**105**		**303**		**173**
2.000 - 6.000	**105**		**303**		**174**

15

MaxiMill – HSC-19 Screw-in cutter

▲ Insert radius >4.0 mm: Modify cutter body

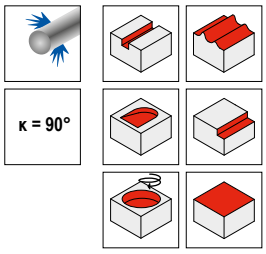


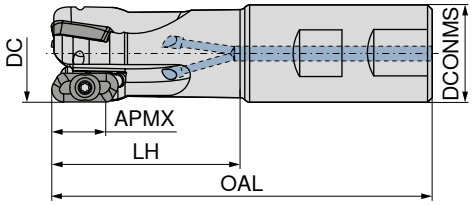


Designation	DC mm	ZNF	APMX mm	DCONMS mm	LPR mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	55 108 ...
GHSC.25.R.02-19	25	2	18	12.5	45	M12	17	34400	5	XDHT 1904..	**025**
GHSC.32.R.03-19	32	3	18	17.0	52	M16	24	29100	5	XDHT 1904..	**032**
GHSC.40.R.03-19	40	3	18	17.0	52	M16	24	24900	5	XDHT 1904..	**040**

MaxiMill – HSC-19 End milling cutter

▲ Insert radius >4.0 mm: Modify cutter body

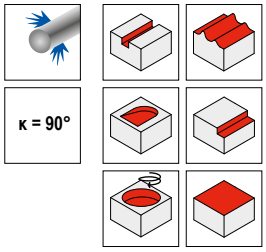


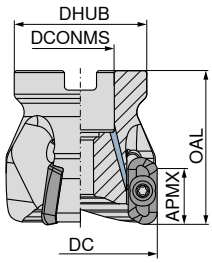


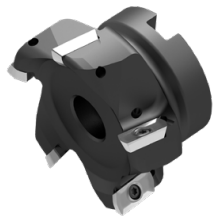
Designation	DC mm	ZNF	APMX mm	DCONMS $_{h5}$ mm	OAL mm	LH mm	RPMX 1/min.	torque moment Nm	Insert	50 679 ...	50 679 ...
CHSC.25.R.02-19-A-50	25	2	18	25	121	50	32400	5	XDHT 1904..	**225**	
CHSC.25.R.02-19	25	2	18	25	121	65	32400	5	XDHT 1904..		**025**
CHSC.25.R.02-19-A-63	25	2	18	25	165	63	24700	5	XDHT 1904..	**325**	
CHSC.32.R.02-19-A-63	32	2	18	32	125	63	28900	5	XDHT 1904..	**232**	
CHSC.32.R.03-19-A-63	32	3	18	32	125	63	28900	5	XDHT 1904..	**432**	
CHSC.32.R.03-19	32	3	18	32	125	65	28900	5	XDHT 1904..		**033**
CHSC.32.R.02-19	32	2	18	32	125	65	28900	5	XDHT 1904..		**032**
CHSC.32.R.02-19-A-80	32	2	18	32	165	80	24400	5	XDHT 1904..	**332**	
CHSC.32.R.03-19-A-80	32	3	18	32	165	80	24400	5	XDHT 1904..	**532**	

MaxiMill – HSC-19 Shell mill

▲ Insert radius >4.0 mm: Modify cutter body







50 716 ...

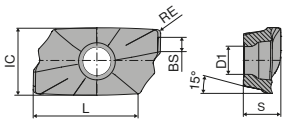
Designation	DC mm	ZNF	APMX mm	DCONMS $_{H6}$ mm	DHUB mm	OAL mm	RPMX 1/min.	torque moment Nm	Insert	
AHSC.40.R.03-19	40	3	18	16	38	50	24900	5	XDHT 1904..	**040**
AHSC.50.R.04-19	50	4	18	22	43	50	21600	5	XDHT 1904..	**050**
AHSC.63.R.04-19	63	4	18	22	48	50	18800	5	XDHT 1904..	**163**
AHSC.63.R.05-19	63	5	18	22	48	50	18800	5	XDHT 1904..	**063**
AHSC.80.R.04-19	80	4	18	27	58	50	16400	5	XDHT 1904..	**180**
AHSC.80.R.05-19	80	5	18	27	58	50	16400	5	XDHT 1904..	**080**
AHSC.100.R.04-19	100	4	18	32	78	50	14500	5	XDHT 1904..	**200**
AHSC.100.R.05-19	100	5	18	32	78	50	14500	5	XDHT 1904..	**100**
AHSC.125.R.05-19	125	5	18	40	88	63	12800	5	XDHT 1904..	**125**
AHSC.125.R.06-19	125	6	18	40	88	63	12800	5	XDHT 1904..	**225**

	TORX® blade	Clamping key – T	Screwdriver	Power Screw	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
DC							
25	**036**		**113**		**303**	**172**	**193**
32	**036**		**113**		**303**	**173**	**193**
40	**036**	**040**	**113**	**151**	**303**	**173**	**193**
50 - 63	**036**	**050**	**113**	**154**	**303**	**174**	**193**
80 - 125	**036**		**113**		**303**	**174**	**193**

15

XDHT

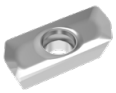
Designation	IC inch	D1 inch	L inch	BS inch	S inch
XDHT 190402..	0.375	0.183	0.748	0.079	0.187
XDHT 190404..	0.375	0.183	0.748	0.079	0.187
XDHT 190408..	0.375	0.183	0.748	0.079	0.187
XDHT 190412..	0.375	0.183	0.748	0.079	0.187
XDHT 190416..	0.375	0.183	0.748	0.079	0.187
XDHT 190420..	0.375	0.183	0.748	0.079	0.187
XDHT 190425..	0.375	0.183	0.748	0.055	0.187
XDHT 190432..	0.375	0.183	0.748	0.039	0.187
XDHT 190440..	0.375	0.183	0.748	0.039	0.187
XDHT 190450..	0.375	0.183	0.748	-	0.187



XDKT

XDHT

NEW

	-F10 CTPX715 DRAGONSKIN	-27P H216T
		
	F	F
	XDHT	XDHT
	51 159 ...	**50 487 ...**

ISO	RE inch		
190402FR	0.008	**00202**	**552**
190404FR	0.016	**00402**	**554**
190408FR	0.031	**00802**	**556**
190412FR	0.047	**01202**	**557**
190416FR	0.063	**01602**	**558**
190420FR	0.079	**02002**	**560**
190425FR	0.098	**02502**	**562**
190432FR	0.126	**03202**	**564**
190440FR	0.157	**04002**	**566**
190450FR	0.197	**05002**[1)]	**568** [1)]
P		○	
M		○	
K		●	○
N		●	●
S		○	
H			
O		○	○

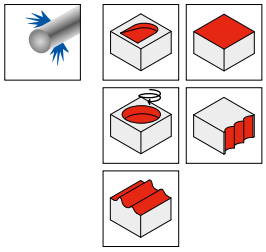
1) Insert radius > 0.157": Modify cutter body

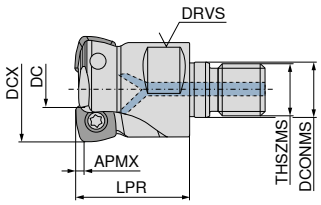
Milling guide

Cutting data standard values	→ 154–157	Safety advice	→ 174
Machining strategy	→ 178–180	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – HFC Screw in cutter

▲ High Feed Cutter (HFC)





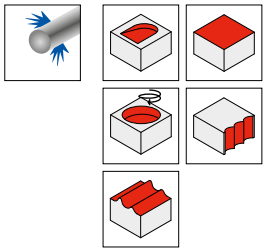
58 682 ...

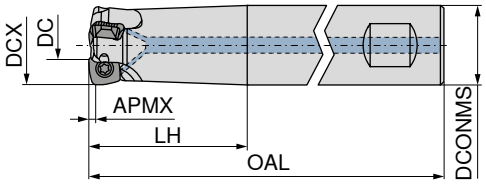
Designation	DC inch	DCX inch	ZNF	APMX inch	LPR inch	DCONMS inch	THSZMS	DRVS inch	RPMX 1/min.	torque moment Nm	Insert	
GHFC.0625.R.02-06-125-F	0.287	0.625	2	0.031	1.250	0.335	M8	0.394	17800	1.2	XPLX 0603..	**06202**[1)]
GHFC.0750.R.03-06-125-F	0.412	0.750	3	0.031	1.250	0.413	M10	0.591	21400	1.2	XPLX 0603..	**07503**[1)]
GHFC.100.R.04-06-150-F	0.662	1.000	4	0.031	1.500	0.492	M12	0.669	17000	1.2	XPLX 0603..	**10004**[1)]
GHFC.125.R.05-06-150-F	0.912	1.250	5	0.031	1.500	0.669	M16	0.945	20300	1.2	XPLX 0603..	**12505**[1)]

1) Not in stock

MaxiMill – HFC End milling cutter

▲ High Feed Cutter (HFC)

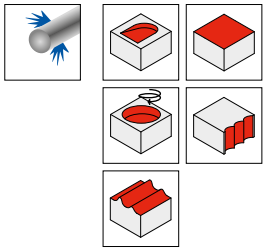


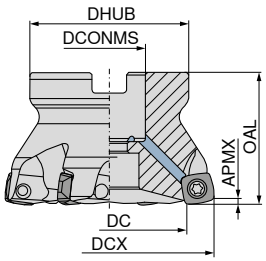


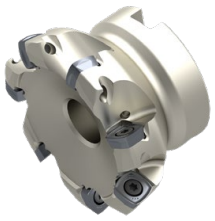

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS h6 inch	RPMX 1/min.	torque moment Nm	Insert	**58 681 ...**	**58 681 ...**
CHFC.0625.R.02-06-B-150-EF	0.287	0.625	2	0.031	3.500	1.500	0.625	18100	1.2	XPLX 0603..		**26202**
CHFC.0625.R.02-06-A-150-EF-800	0.287	0.625	2	0.031	8.000	1.500	0.625	18100	1.2	XPLX 0603..	**06202**	
CHFC.0750.R.03-06-B-200-EF	0.412	0.750	3	0.031	4.200	2.000	0.750	14100	1.2	XPLX 0603..		**27503**
CHFC.0750.R.03-06-A-200-EF-900	0.412	0.750	3	0.031	9.000	2.000	0.750	14100	1.2	XPLX 0603..	**07503**	
CHFC.100.R.04-06-B-200-EF	0.662	1.000	4	0.031	4.400	2.000	1.000	15400	1.2	XPLX 0603..		**30004**
CHFC.100.R.04-06-A-200-EF-900	0.662	1.000	4	0.031	9.000	2.000	1.000	15400	1.2	XPLX 0603..	**10004**	
CHFC.125.R.05-06-B100-250-EF	0.912	1.250	5	0.031	4.900	2.500	1.000	10700	1.2	XPLX 0603..		**32505**
CHFC.125.R.05-06-A100-250-EF-900	0.912	1.250	5	0.031	9.000	2.500	1.000	10700	1.2	XPLX 0603..	**12505**	
CHFC.100.R.03-09-B-200-EF	0.535	1.000	3	0.039	4.300	2.000	1.000	15400	3.2	XDLX 09T3..		**60003**
CHFC.100.R.03-09-A-200-EF-800	0.535	1.000	3	0.039	8.000	2.000	1.000	9000	3.2	XDLX 09T3..	**50003**	
CHFC.125.R.04-09-B100-250-EF	0.785	1.250	4	0.039	4.800	2.500	1.000	10700	3.2	XDLX 09T3..		**62504**
CHFC.125.R.03-09-A-250-EF-1000	0.785	1.250	3	0.039	10.000	2.500	1.250	8100	3.2	XDLX 09T3..	**52503**	
CHFC.125.R.02-12-A-250-EF-1000	0.596	1.250	2	0.079	10.000	2.500	1.250	6480	5	XOLX 1204..	**82502**	
CHFC.150.R.03-12-A125-250-EF-1000	0.846	1.500	3	0.079	10.000	2.500	1.250	6100	5	XOLX 1204..	**85003**	

MaxiMill – HFC Shell mill

▲ High Feed Cutter (HFC)







58 683 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DCONMS $_{H6}$ inch	DHUB inch	RPMX 1/min.	torque moment Nm	Insert	
AHFC.150.R.04-09-A050-175-EF	1.035	1.500	4	0.039	1.420	0.500	1.420	26400	3.2	XDLX 09T3..	**15004**
AHFC.200.R.05-09-A075-175-EF	1.535	2.000	5	0.039	1.750	0.750	1.750	23500	3.2	XDLX 09T3..	**20005**
AHFC.250.R.06-09-A075-200-EF	2.035	2.500	6	0.039	1.750	0.750	1.750	20500	3.2	XDLX 09T3..	**25006**
AHFC.200.R.04-12-A075-175-EF	1.346	2.000	4	0.079	1.750	0.750	1.750	18800	5	XOLX 1204..	**20104**
AHFC.250.R.05-12-A100-200-EF	1.846	2.500	5	0.079	2.250	1.000	2.250	16400	5	XOLX 1204..	**25105**
AHFC.300.R.07-12-A100-200-EF	2.346	3.000	7	0.079	2.250	1.000	2.250	14000	5	XOLX 1204..	**30107**
AHFC.400.R.08-12-A125-200-EF	3.346	4.000	8	0.079	2.750	1.250	2.750	12000	5	XOLX 1204..	**40108**
AHFC.500.R.10-12-B150-250-EF	4.346	5.000	10	0.079	3.750	1.500	3.750	9800	5	XOLX 1204..	**50110**
AHFC.300.R.06-19-A100-200-EF	1.970	3.000	6	0.130	2.250	1.000	2.250	4900	5	XOLX 1906..	**30206**
AHFC.400.R.08-19-A125-200-EF	2.970	4.000	8	0.130	2.750	1.250	2.750	4000	5	XOLX 1906..	**40208**
AHFC.500.R.10-19-B150-250-EF	3.970	5.000	10	0.130	3.750	1.500	3.750	3500	5	XOLX 1906..	**50210**

Screwdriver

80 950 ...

Molykote

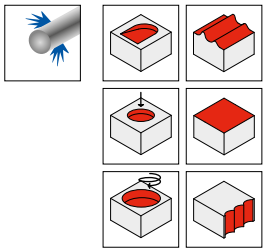
70 950 ...

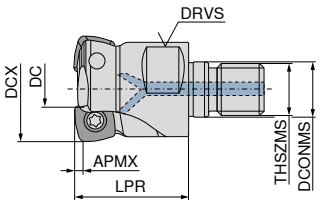
Clamping screw

70 950 ...

Spare parts **Insert**			
XDLX 09T3..	**105**	**303**	**304**
XDLX 09T3.. (Ø1.000)	**105**	**303**	**110**
XOLX 1204..	**106**	**303**	**01200**
XOLX 1906..	**106**	**303**	**302**
XPLX 0603..	**102**	**303**	**116**

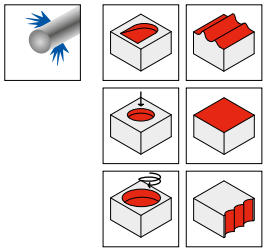
MaxiMill – HFC high-feed screw-in cutter

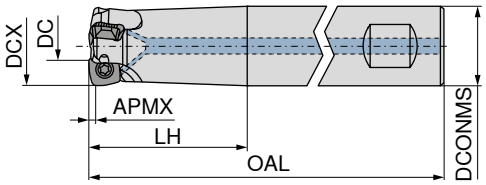




Designation	DC mm	DCX mm	ZNF	APMX mm	LPR mm	DCONMS mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	50 682 ...
GHFC.16.R.02-06	7	16	2	0.8	27	8.5	M8	10	20800	1.2	XPLX 0603..	**616**
GHFC.20.R.03-06	11	20	3	0.8	33	10.5	M10	15	19800	1.2	XPLX 0603..	**620**
GHFC.25.R.04-06	16	25	4	0.8	35	12.5	M12	17	18700	1.2	XPLX 0603..	**625**
GHFC.32.R.05-06	23	32	5	0.8	35	17.0	M16	24	22000	1.2	XPLX 0603..	**632**
GHFC.42.R.07-06	33	42	7	0.8	35	17.0	M16	24	15000	1.2	XPLX 0603..	**04207**
GHFC.25.R.02-09	12	25	2	1.0	35	12.5	M12	17	30000	3.2	XDLX 09T3..	**025**
GHFC.25.R.03-09	12	25	3	1.0	35	12.5	M12	17	30000	3.2	XDLX 09T3..	**125**
GHFC.32.R.03-09	19	32	3	1.0	35	17.0	M16	24	27000	3.2	XDLX 09T3..	**032**
GHFC.42.R.05-09	19	42	5	1.0	35	17.0	M16	24	26100	3.2	XDLX 09T3..	**04205**
GHFC.32.R.02-12	15	32	2	2.0	35	17.0	M16	24	21600	5	XOLX 1204..	**132**
GHFC.35.R.03-12	18	35	3	2.0	35	17.0	M16	24	21360	5	XOLX 1204..	**035**
GHFC.42.R.04-12	25	42	4	2.0	35	17.0	M16	24	20800	5	XOLX 1204..	**04204**

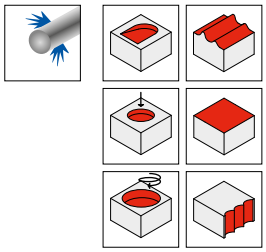
MaxiMill – HFC high-feed end mill

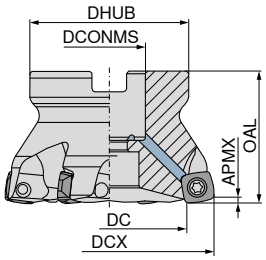


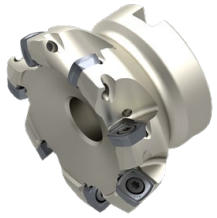


Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS $_{h6}$ mm	RPMX 1/min.	torque moment Nm	Insert	50 681 ...	50 681 ...
CHFC.16.R.02-06-B-40	7.0	16	2	0.8	89	40	16	17300	1.2	XPLX 0603..		**616**
CHFC.16.R.02-06-A-40-200	7.0	16	2	0.8	200	40	16	4600	1.2	XPLX 0603..	**716**	
CHFC.20.R.03-06-B-50	11.0	20	3	0.8	101	50	20	14500	1.2	XPLX 0603..		**620**
CHFC.20.R.03-06-A-50-225	11.0	20	3	0.8	225	50	20	4200	1.2	XPLX 0603..	**720**	
CHFC.25.R.04-06-B-50	16.0	25	4	0.8	107	50	25	15600	1.2	XPLX 0603..		**625**
CHFC.25.R.04-06-A-50-225	16.0	25	4	0.8	225	50	25	4600	1.2	XPLX 0603..	**725**	
CHFC.32.R.05-06-B-25-60	23.0	32	5	0.8	117	60	25	11000	1.2	XPLX 0603..		**632**
CHFC.32.R.05-06-A-25-60-225	23.0	32	5	0.8	225	60	25	3900	1.2	XPLX 0603..	**732**	
CHFC.25.R.02-09-A-50-225	12.3	25	2	1.0	225	50	25	9000	3.2	XDLX 09T3..	**025**	
CHFC.25.R.03-09-A-50-225	12.3	25	3	1.0	225	50	25	9000	3.2	XDLX 09T3..	**125**	
CHFC.32.R.03-09-A-63-250	19.3	32	3	1.0	250	63	32	8100	3.2	XDLX 09T3..	**032**	
CHFC.32.R.02-12-A-63-250	14.8	32	2	2.0	250	63	32	6480	5	XOLX 1204..	**132**	
CHFC.35.R.03-12-A-63-250	17.8	35	3	2.0	250	63	32	6480	5	XOLX 1204..	**035**	

MaxiMill – HFC high-feed face mill







50 683 ...

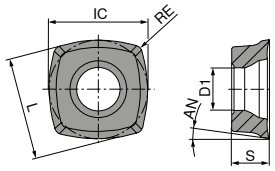
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS $_{H6}$ mm	DHUB mm	RPMX 1/min.	torque moment Nm	Insert	
AHFC.32.R.03-09	19.3	32	3	1.0	40	16	38	27700	3.2	XDLX 09T3..	**032**
AHFC.35.R.04-09	19.3	35	4	1.0	40	16	38	26700	3.2	XDLX 09T3..	**035**
AHFC.40.R.04-09	27.3	40	4	1.0	40	16	38	26400	3.2	XDLX 09T3..	**140**
AHFC.42.R.05-09	29.3	42	5	1.0	40	16	38	26100	3.2	XDLX 09T3..	**142**
AHFC.50.R.05-09	37.3	50	5	1.0	40	22	43	23500	3.2	XDLX 09T3..	**150**
AHFC.52.R.06-09	39.3	52	6	1.0	40	22	43	23000	3.2	XDLX 09T3..	**152**
AHFC.63.R.06-09	50.3	63	6	1.0	40	22	48	20500	3.2	XDLX 09T3..	**163**
AHFC.66.R.07-09	53.3	66	7	1.0	40	22	48	20000	3.2	XDLX 09T3..	**16600**
AHFC.40.R.03-12	22.8	40	3	2.0	40	16	38	21120	5	XOLX 1204..	**040**
AHFC.42.R.04-12	24.8	42	4	2.0	40	16	38	20880	5	XOLX 1204..	**042**
AHFC.50.R.04-12	32.8	50	4	2.0	40	22	43	18800	5	XOLX 1204..	**050**
AHFC.52.R.05-12	34.8	52	5	2.0	40	22	43	18400	5	XOLX 1204..	**052**
AHFC.63.R.05-12	45.8	63	5	2.0	40	22	48	16400	5	XOLX 1204..	**063**
AHFC.66.R.06-12	48.8	66	6	2.0	40	22	48	16000	5	XOLX 1204..	**066**
AHFC.80.R.07-12	62.8	80	7	2.0	50	27	58	14000	5	XOLX 1204..	**080**
AHFC.100.R.08-12	82.8	100	8	2.0	50	32	78	12000	5	XOLX 1204..	**100**
AHFC.63.R.05-19	36.7	63	5	3.3	40	22	48	5500	5	XOLX 1906..	**263**
AHFC.80.R.06-19	53.7	80	6	3.3	50	27	58	4700	5	XOLX 1906..	**280**
AHFC.100.R.08-19	73.7	100	8	3.3	52	32	78	4100	5	XOLX 1906..	**300**
AHFC.125.R.10-19	98.7	125	10	3.3	63	40	88	3600	5	XOLX 1906..	**325**
AHFC.160.R.11-19	133.7	160	11	3.3	63	40	98	3100	5	XOLX 1906..	**360** [1]

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm / Without Through Coolant

	TORX® blade	Clamping key – T	Screwdriver	Power Screw	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
Insert							
XDLX 09T3..	**036**		**113**		**303**	**110**	**192**
XDLX 09T3.. (Ø32 – Ø42)	**036**	**040**	**113**	**151**	**303**	**304**	**192**
XOLX 1204..	**037**		**114**		**303**	**01200**	**193**
XOLX 1204.. (Ø40 – Ø42)	**037**	**040**	**114**	**151**	**303**	**01200**	**193**
XOLX 1906..	**037**		**114**		**303**	**302**	**193**
XPLX 0603..	**033**		**110**		**303**	**116**	**192**

XPLX / XDLX / XOLX

Designation	IC inch	D1 inch	L inch	BS inch	S inch	AN °
XPLX 0603..	0.250	0.110	0.236	0.039	0.108	11.000
XDLX 09T3..	0.375	0.173	0.354	0.075	0.156	15.000
XOLX 1204..	0.500	0.217	0.472	0.051	0.187	10.000
XOLX 1906..	0.754	0.236	0.748	-	0.250	10.000



XPLX

	-M50 CTCP220	-M50 CTPP225	-M50 CTPP235	-M50 CTPM225	-M50 CTPM240	-F40 CTPM245	-F40 CTCM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	XPLX	XPLX	XPLX	XPLX	XPLX	XPLX	XPLX
	51 019 ...	51 019 ...	51 019 ...	51 019 ...	51 019 ...	51 116 ...	51 116 ...
ISO / RE inch							
060305ER 0.020						455	90501
060305SR 0.020	255	055	105	205	405		
P	●	●	●	●	○	●	●
M			○	●	●	●	●
K			○				
N							
S							○
H							
O							

XPLX

	-M50 CTCK215	-F40 CTC5240	-F40 CTCS245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
			
	XPLX	XPLX	XPLX
	51 019 ...	50 518 ...	51 116 ...
ISO / RE inch			
060305ER 0.020		558	55500
060305SR 0.020	505		
P			
M			
K	●		
N			
S		●	●
H			
O			

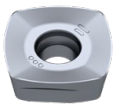
XDLX

		-M50 CTCP220 DRAGONSKIN	-M50 CTPP225 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN
					
		XDLX	XDLX	XDLX	XDLX
		51 016 ...	51 016 ...	51 016 ...	51 016 ...
ISO	RE inch				
09T308SR	0.031	258	058	008	108
P		●	●	●	●
M					○
K				○	○
N					
S					
H					
O					

XDLX

		-M50 CTPM225 DRAGONSKIN	-M50 CTCM235 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN	-F40 CTPM245 DRAGONSKIN	-M50 CTPM245 DRAGONSKIN	-M50 CTCM245 DRAGONSKIN
							
		XDLX	XDLX	XDLX	XDLX	XDLX	XDLX
		51 016 ...	51 016 ...	51 016 ...	51 115 ...	51 016 ...	51 016 ...
ISO	RE inch						
09T308ER	0.031				458		
09T308SR	0.031	208	308	408		458	90801
P		●	●	○	●	●	●
M		●	●	●	●	●	●
K							
N							
S							○
H							
O							

XDLX / XOLX

		-M50 CTCK215 DRAGONSKIN	-M50 CTPK220 DRAGONSKIN	-F40 CTC5240 DRAGONSKIN	-F40 CTCS245 DRAGONSKIN
					
		XDLX	XOLX	XDLX	XDLX
		51 016 ...	51 017 ...	50 503 ...	51 115 ...
ISO	RE inch				
09T308ER	0.031			558	558
09T308SR	0.031	508			
190615SR	0.059		61500		
P					
M					
K		●	●		
N					
S				●	●
H					
O					

XOLX

		-M50 CTCP220 DRAGONSKIN	-M50 CTPP225 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN	-R50 CTPP235 DRAGONSKIN
						
		XOLX	XOLX	XOLX	XOLX	XOLX
		51 017 ...	51 017 ...	51 017 ...	51 017 ...	51 018 ...
ISO	RE inch					
120410SR	0.039	260	060	010	110	110
P		●	●	●	●	●
M					○	○
K				○	○	○
N						
S						
H						
O						

15

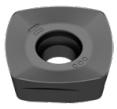
XOLX

		-M50 CTPM225	-M50 CTCM235	-M50 CTPM240	-F40 CTPM245	-M50 CTPM245	-F40 CTCM245	-M50 CTCM245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		XOLX	XOLX	XOLX	XOLX	XOLX	XOLX	XOLX
		51 017 ...	51 017 ...	51 017 ...	51 022 ...	51 017 ...	51 022 ...	51 017 ...
ISO	RE inch							
120410ER	0.039				460		91001	
120410SR	0.039	210	310	410		460		91001
P		●	●	○	●	●	●	●
M		●	●	●	●	●	●	●
K								
N								
S							○	○
H								
O								

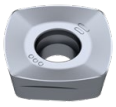
XOLX / XOHX

		-M50 CTCK215	-F40 CTC5240	-F50 CTC5240	-F40 CTCS245	-F50 CTCS245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		XOLX	XOLX	XOHX	XOLX	XOHX
		51 017 ...	50 504 ...	51 124 ...	51 022 ...	51 124 ...
ISO	RE inch					
120410ER	0.039		558		560	
120410SR	0.039	510		16000		56000
P						
M						
K		●				
N						
S			●	●	●	●
H						
O						

XOLX

	-M50 CTCP230	-M50 CTPP235	-M50 CTPM240	-F40 CTPM245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	XOLX	XOLX	XOLX	XOLX
	51 017 ...	51 017 ...	51 017 ...	51 022 ...
ISO / RE inch				
190615ER 0.059				465
190615SR 0.059	015	115	415	
P	●	●	○	●
M		○	●	●
K	○	○		
N				
S				
H				
O				

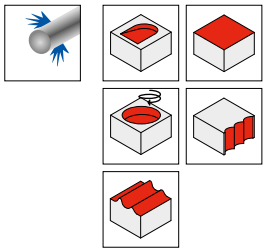
XOLX

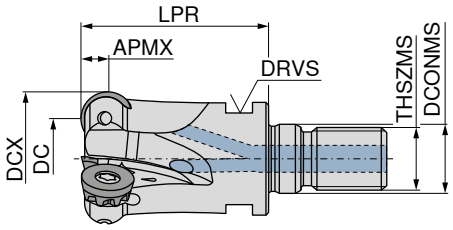
	-F40 CTCM245	-M50 CTCK215	-M50 CTPK220	-F40 CTC5240	-F40 CTCS245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
	XOLX	XOLX	XOLX	XOLX	XOLX
	51 022 ...	51 017 ...	51 017 ...	50 504 ...	51 022 ...
ISO / RE inch					
190615ER 0.059	91501			515	56500
190615SR 0.059		515	61500		
P	●				
M	●				
K		●	●		
N					
S	○			●	●
H					
O					

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 184–187
Starting Parameter	→ 184–187	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

MaxiMill – 251 RS Screw in cutter

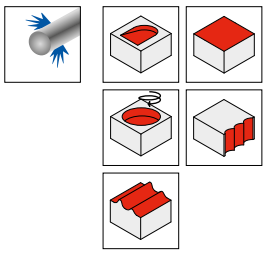


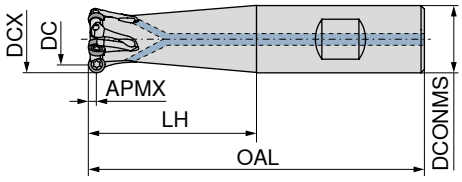


Designation	DC inch	DCX inch	ZNF	APMX inch	DCONMS inch	LPR inch	THSZMS	RPMX 1/min.	torque moment Nm	Insert	58 684 ...
G251.100.R.03-10-125-RS-F	0.606	1.000	3	0.197	0.492	1.250	M12	25450	2	RP.X 10T3..	10103
G251.125.R.04-10-125-RS-F	0.856	1.250	4	0.196	0.669	1.500	M16	25450	2	RP.X 10T3..	12604[1)]
G251.150.R.05-10-175-RS-F	1.106	1.500	5	0.197	0.669	1.750	M16	15150	2	RP.X 10T3..	15105[1)]
G251.125.R.03-12-125-RS-F	0.777	1.250	3	0.236	0.492	1.575	M12	25450	3.2	RP.X 1204..	22503[1)]

1) Not in stock

MaxiMill – 251 RS End milling cutter





Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	LH inch	DCONMS inch	RPMX 1/min.	Insert	58 685 ...	58 685 ...
C251.0750.R.03-08-B-125-RS-EF	0.435	0.750	3	0.157	3.500	1.250	0.750	31800	RDHX 0802..		27503
C251.0750.R.03-08-A-200-RS-EF-800	0.435	0.750	3	0.157	8.000	2.000	0.750	22260	RDHX 0802..	07503	
C251.100.R.04-08-B-225-RS-EF	0.685	1.000	4	0.157	4.500	2.250	1.000	25450	RDHX 0802..		30004
C251.100.R.04-08-A-300-RS-EF-800	0.685	1.000	4	0.157	8.000	3.000	1.000	18000	RDHX 0802..	10004	
C251.125.R.05-08-B-275-RS-EF	0.935	1.250	5	0.157	5.250	2.750	1.250	19850	RDHX 0802..		32505
C251.125.R.05-08-A-325-RS-EF-1000	0.935	1.250	5	0.157	10.000	3.250	1.250	18000	RDHX 0802..	12505	
C251.100.R.03-10-B-225-RS-EF	0.606	1.000	3	0.197	4.500	2.250	1.000	25450	RP.X 10T3..		50003
C251.100.R.03-10-A-300-RS-EF-800	0.606	1.000	3	0.197	8.000	3.000	1.000	20000	RP.X 10T3..	40003	
C251.125.R.04-10-B-275-RS-EF	0.857	1.250	4	0.197	5.250	2.750	1.250	19850	RP.X 10T3..		52504
C251.125.R.04-10-A-325-RS-EF-1000	0.857	1.250	4	0.197	10.000	3.250	1.250	18000	RP.X 10T3..	42504	
C251.150.R.05-10-B125-325-RS-EF	1.106	1.500	5	0.197	6.000	3.250	1.250	15100	RP.X 10T3..		55005
C251.150.R.05-10-A125-375-RS-EF-1000	1.106	1.500	5	0.197	10.000	3.750	1.250	10700	RP.X 10T3..	45005	
C251.125.R.02-12-A-325-RS-EF-1000	0.778	1.250	2	0.236	10.000	3.250	1.250	8500	RP.X 1204..	62502	
C251.150.R.03-12-A125-375-RS-EF-1000	1.028	1.500	3	0.236	10.000	3.750	1.250	12500	RP.X 1204..	65003	
C251.150.R.02-16-A125-375-RS-EF-1000	0.870	1.500	2	0.315	10.000	3.750	1.250	10500	RP.X 1605..	75002	

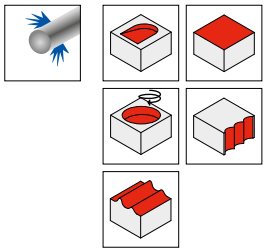

Screwdriver

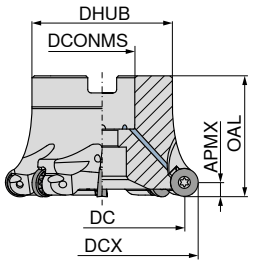

Molykote

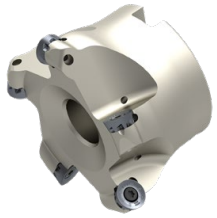

Clamping screw

Spare parts	80 950 ...	70 950 ...	70 950 ...
Insert			
RDHX 0802..	102	303	116
RP.X 10T3..	104	303	840
RP.X 10T3..		303	
RP.X 1204..	105	303	304
RP.X 1605..	106	303	01200

MaxiMill – 251 RS Shell mill







58 686 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS $_{H6}$ inch	RPMX 1/min.	torque moment Nm	Insert	
A251.150.R.06-08-A050-175-RS-EF	1.185	1.500	6	0.157	1.420	1.420	0.500	15150	1.2	RDHX 0802..	**15006**
A251.300.R.12-08-A100-200-RS-IN-EF	2.685	3.000	12	0.157	2.250	2.250	1.000	7950	1.2	RDHX 0802..	**30012**
A251.150.R.05-10-A050-175-RS-EF	1.106	1.500	5	0.197	1.420	1.420	0.500	15900	2	RP.X 10T3..	**15105**
A251.200.R.06-10-A075-175-RS-EF	1.606	2.000	6	0.197	1.750	1.750	0.750	12700	2	RP.X 10T3..	**20106**
A251.200.R.05-12-A075-175-RS-EF	1.528	2.000	5	0.236	1.750	1.750	0.750	12700	3.2	RP.X 1204..	**20205**
A251.200.R.06-12-A075-175-RS-EF	1.528	2.000	6	0.236	1.750	1.750	0.750	12700	3.2	RP.X 1204..	**20206**
A251.250.R.06-12-A100-200-RS-EF	2.028	2.500	6	0.236	2.250	2.250	1.000	10100	3.2	RP.X 1204..	**25206**
A251.300.R.07-12-RS-A100-200-EF	2.528	3.000	7	0.236	2.250	2.250	1.000	7950	3.2	RP.X 1204..	**30207**
A251.400.R.10-12-B125-200-RS-EF	3.528	4.000	10	0.236	2.750	2.750	1.250	6350	3.2	RP.X 1204..	**40210**
A251.600.R.12-12-B150-200-RS-EF	5.528	6.000	12	0.236	3.750	3.750	1.500	8300	3.2	RP.X 1204..	**60212**[1)]
A251.200.R.03-16-A075-175-RS-EF	1.370	2.000	3	0.315	1.750	1.750	0.750	12700	5	RP.X 1605..	**20303**
A251.250.R.05-16-A100-200-RS-EF	1.870	2.500	5	0.315	2.250	2.250	1.000	10100	5	RP.X 1605..	**25305**
A251.300.R.06-16-A100-200-RS-EF	2.370	3.000	6	0.315	2.250	2.250	1.000	7950	5	RP.X 1605..	**30306**
A251.400.R.07-16-B125-200-RS-EF	3.370	4.000	7	0.315	2.750	2.750	1.250	6350	5	RP.X 1605..	**40307**
A251.500.R.08-16-B150-200-RS-EF	4.370	5.000	8	0.315	3.750	3.750	1.500	5400	5	RP.X 1605..	**50308**
A251.600.R.10-16-B150-200-RS-EF	5.370	6.000	10	0.315	3.750	3.750	1.500	7200	5	RP.X 1605..	**60310**
A251.300.R.05-20-A100-200-RS-EF	2.213	3.000	5	0.394	2.250	2.250	1.000	8600	5	RP.X 2006..	**30405**
A251.400.R.06-20-A125-200-RS-EF	3.213	4.000	6	0.394	2.750	2.750	1.250	6350	5	RP.X 2006..	**40406**
A251.500.R.07-20-B150-200-RS-EF	4.213	5.000	7	0.394	3.750	3.750	1.500	5400	5	RP.X 2006..	**50407**
A251.600.R.08-20-B150-200-RS-EF	5.213	6.000	8	0.394	3.750	3.750	1.500	6500	1.2	RP.X 2006..	**60408**

1) Not in stock

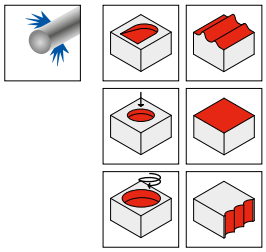
Screwdriver

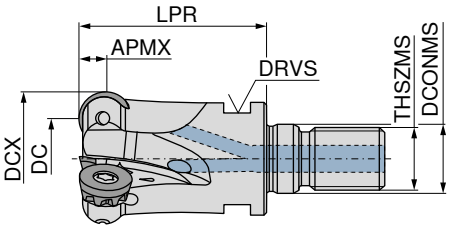
Molykote

Clamping screw

	80 950 ...	**70 950 ...**	**70 950 ...**
Spare parts			
Insert			
RDHX 0802..	**102**	**303**	**116**
RP.X 10T3..	**104**	**303**	**840**
RP.X 1204..	**105**	**303**	**304**
RP.X 1605..	**106**	**303**	**01200**
RP.X 2006..	**106**	**303**	**302**

MaxiMill – 251 RS Screw in cutter



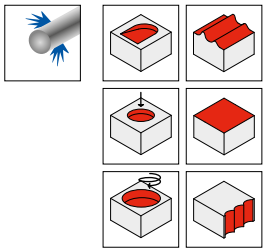


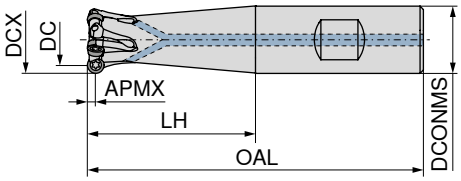
50 684 ...

Designation	DC mm	DCX mm	ZNF	APMX mm	DCONMS mm	LPR mm	THSZMS	DRVS mm	RPMX 1/min.	torque moment Nm	Insert	
G251.20.R.05-05-RS	15	20	5	2.5	10.5	33	M10	15	31800	0.7	RDHX 0501..	**220**
G251.25.R.06-05-RS	20	25	6	2.5	12.5	35	M12	17	24450	0.7	RDHX 0501..	**225**
G251.32.R.07-05-RS	27	32	7	2.5	17.0	35	M16	24	19850	0.7	RDHX 0501..	**232**
G251.20.R.03-08-RS	12	20	3	4.0	10.5	33	M10	15	25000	1.2	RDHX 0802..	**120**
G251.25.R.04-08-RS	17	25	4	4.0	12.5	35	M12	17	19000	1.2	RDHX 0802..	**125**
G251.32.R.05-08-35-RS	24	32	5	4.0	17.0	35	M16	24	19000	1.2	RDHX 0802..	**132**
G251.20.R.02-10-RS	10	20	2	5.0	10.5	33	M10	15	30000	2	RP.X 10T3..	**020**
G251.25.R.03-10-RS	15	25	3	5.0	12.5	35	M12	17	30000	2	RP.X 10T3..	**025**
G251.32.R.04-10-RS	22	32	4	5.0	17.0	35	M16	24	25000	2	RP.X 10T3..	**032**
G251.25.R.02-12-35-RS	13	25	2	6.0	12.5	35	M12	17	25000	3.2	RP.X 1204..	**525**
G251.32.R.03-12-35-RS	20	32	3	6.0	17.0	35	M16	24	19850	3.2	RP.X 1204..	**532**
G251.35.R.03-12-35-RS	23	35	3	6.0	17.0	35	M16	24	15900	3.2	RP.X 1204..	**535**
G251.42.R.04-12-42-RS	30	42	4	6.0	17.0	42	M16	24	15000	3.2	RP.X 1204..	**542**

	TORX® blade	 Screwdriver	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts Insert					
RDHX 0501..	**031**	**108**	**303**	**149**	**191**
RDHX 0802..	**033**	**110**	**303**	**116**	**191**
RP.X 10T3..	**035**	**112**	**303**	**840**	**192**
RP.X 1204..	**036**	**113**	**303**	**304**	**192**

MaxiMill – 251 RS End milling cutter

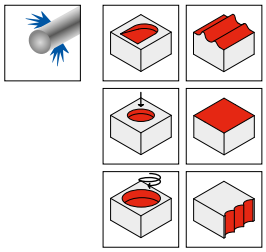


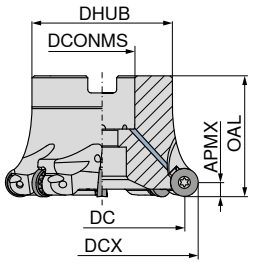


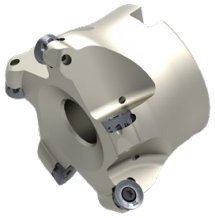
Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	RPMX 1/min.	Insert	50 685 ...		50 685 ...	
C251.12.R-03-05-B-16-25-RS	7	12	3	2.5	75	25	16	40000	RDHX 0501..				**012**
C251.12.R-03-05-A-32-165-RS	7	12	3	2.5	165	32	12	16000	RDHX 0501..		**112**		
C251.16.R-04-05-B-32-RS	11	16	4	2.5	81	32	16	40000	RDHX 0501..				**316**
C251.16.R-04-05-A-40-165-RS	11	16	4	2.5	165	40	16	18000	RDHX 0501..		**016**		
C251.20.R-05-05-B-40-RS	15	20	5	2.5	91	40	20	31800	RDHX 0501..				**620**
C251.20.R-05-05-A-50-165-RS	15	20	5	2.5	165	50	20	18000	RDHX 0501..		**120**		
C251.16.R-02-08-B-32-RS	8	16	2	4.0	81	32	16	40000	RDHX 0802..				**116**
C251.16.R-02-08-A-40-165-RS	8	16	2	4.0	165	40	16	18000	RDHX 0802..		**216**		
C251.20.R-03-08-B-40-RS	12	20	3	4.0	91	40	20	31800	RDHX 0802..				**220**
C251.20.R-03-08-A-60-RS	12	20	3	4.0	110	50	20	30000	RDHX 0802..		**020**		
C251.20.R-03-08-A-50-200-RS	12	20	3	4.0	200	50	20	25000	RDHX 0802..		**320**		
C251.25.R-04-08-B-50-RS	17	25	4	4.0	107	50	25	25500	RDHX 0802..				**625**
C251.25.R-04-08-A-60-RS	17	25	4	4.0	116	60	25	19000	RDHX 0802..		**125**		
C251.25.R-04-08-A-60-225-RS	17	25	4	4.0	225	60	25	18000	RDHX 0802..		**225**		
C251.20.R-02-10-A-50-RS	10	20	2	5.0	102	50	20	25000	RP.X 10T3..		**420**		
C251.20.R-02-10-A-50-200-RS	10	20	2	5.0	200	50	20	25000	RP.X 10T3..		**520**		
C251.25.R.03-10-A-60-RS	15	25	3	5.0	116	60	25	25000	RP.X 10T3..		**025**		
C251.25.R-03-10-B-60-RS	15	25	3	5.0	116	60	25	20000	RP.X 10T3..				**325**
C251.25.R-03-10-A-60-225-RS	15	25	3	5.0	225	60	25	18000	RP.X 10T3..		**425**		
C251.32.R.04-10-A-70-RS	22	32	4	5.0	130	70	32	25000	RP.X 10T3..		**032**		
C251.25.R-02-12-B-30-RS	13	25	2	6.0	86	30	25	25000	RP.X 1204..				**525**
C251.32.R-03-12-A-RS	20	32	3	6.0	100	40	32	19000	RP.X 1204..		**232**		
C251.32.R-03-12-B-40-RS	20	32	3	6.0	100	40	32	19000	RP.X 1204..				**132**

Spare parts	TORX® blade	Screwdriver	Molykote	Clamping screw	Torque screwdriver
	80 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Insert					
RDHX 0501..	**031**	**108**	**303**	**149**	**191**
RDHX 0802..	**033**	**110**	**303**	**116**	**191**
RP.X 10T3..	**035**	**112**	**303**	**840**	**192**
RP.X 10T3..		**112**	**303**	**840**	
RP.X 1204..	**036**	**113**	**303**	**304**	**192**

MaxiMill – 251 RS Shell mill







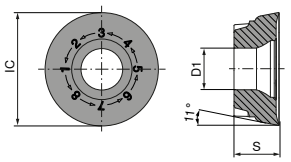
50 686 ...

Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS $_{H6}$ mm	RPMX 1/min.	torque moment Nm	Insert	
A251.40.R.03-10-RS	30	40	3	5	40	38	16	15900	2	RP.X 10T3..	**240**
A251.40.R.05-10-RS	30	40	5	5	40	38	16	16000	2	RP.X 10T3..	**140**
A251.42.R.06-10-RS	32	42	6	5	40	38	16	16000	2	RP.X 10T3..	**142**
A251.50.R.04-10-RS	40	50	4	5	40	43	22	12700	2	RP.X 10T3..	**350**
A251.50.R.06-10-RS	40	50	6	5	40	43	22	12500	2	RP.X 10T3..	**150**
A251.52.R.06-10-RS	42	52	6	5	40	43	22	12500	2	RP.X 10T3..	**152**
A251.40.R.04-12-RS	28	40	4	6	40	38	16	15900	3.2	RP.X 1204..	**340**
A251.50.R.04-12-RS	38	50	4	6	40	43	22	12700	3.2	RP.X 1204..	**250**
A251.50.R.05-12-RS	38	50	5	6	40	43	22	12500	3.2	RP.X 1204..	**050**
A251.66.R.07-12-RS	54	66	7	6	40	48	22	9000	3.2	RP.X 1204..	**166**
A251.80.R.05-12-RS	68	80	5	6	50	58	27	7950	3.2	RP.X 1204..	**180**
A251.80.R.07-12-RS	68	80	7	6	50	58	27	8000	3.2	RP.X 1204..	**080**
A251.100.R.06-12-RS	88	100	6	6	50	78	32	6350	3.2	RP.X 1204..	**100**
A251.100.R.10-12-RS	88	100	10	6	50	78	32	6350	3.2	RP.X 1204..	**200**
A251.50.R.04-16-RS	34	50	4	8	40	48	22	12700	5	RP.X 1605..	**450**
A251.52.R.04-16-RS	36	52	4	8	40	48	22	10100	5	RP.X 1605..	**452**
A251.63.R.05-16-RS	47	63	5	8	40	48	22	10100	5	RP.X 1605..	**163**
A251.66.R.05-16-RS	50	66	5	8	40	48	22	7950	5	RP.X 1605..	**466**
A251.80.R.06-16-RS	64	80	6	8	50	58	27	7950	5	RP.X 1605..	**280**
A251.100.R.07-16-RS	84	100	7	8	50	78	32	6350	5	RP.X 1605..	**300**
A251.125.R.08-16-RS	109	125	8	8	63	88	40	5050	5	RP.X 1605..	**225**
A251.80.R.05-20-RS	60	80	5	10	50	58	27	7950	5	RP.X 2006..	**380**
A251.100.R.06-20-RS	80	100	6	10	50	78	32	6350	5	RP.X 2006..	**400**
A251.125.R.06-20-RS	105	125	6	10	63	88	40	5050	5	RP.X 2006..	**125**

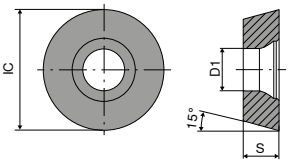
	TORX® blade	 Clamping key – T	 Screwdriver	 Power Screw	 Molykote	 Clamping screw	 Torque screwdriver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
Insert							
RP.X 10T3..	**035**	**040**	**112**	**151**	**303**	**840**	**192**
RP.X 1204..	**036**	**040**	**113**	**151**	**303**	**304**	**192**
RP.X 1605..	**037**	**050**	**114**	**154**	**303**	**01200**	**193**
RP.X 2006..	**037**		**114**		**303**	**302**	**193**

RDHX / RPHX / RPNX

Designation	IC inch	D1 inch	S inch
RDHX 0501..	0.197	0.098	0.063
RDHX 0802..	0.315	0.110	0.094
RP.X 10T3..	0.394	0.134	0.156
RP.X 1204..	0.472	0.173	0.187
RP.X 1605..	0.630	0.217	0.219
RP.X 2006..	0.787	0.236	0.250



RP.X 10T3.. / RP.X 1204.. / RP.X 1605.. / RPNX 2006..



RDHX 0501.. / RDHX0802..

RDHX

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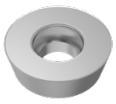
0802M4SN				471	92101
P	●	●	○	●	●
M		○	●	●	●
K	○	○			
N					
S					○
H					
O					

RDHX

	-FN H216T	-M31 CTC5240	-F50 CTCS245
		DRAGONSKIN	DRAGONSKIN
			
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ISO			
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0802M0FN	602		
0802M0SN			570
0802M4EN		50100	
P			
M			
K	○		
N	●		
S		●	●
H			
O	○		

RPHX / RPNX

	-SN TCM10	-F50 CTCP230 DRAGONSKIN	-M50 CTCP230 DRAGONSKIN	-SN CTCP230 DRAGONSKIN	-SN CTCP230 DRAGONSKIN
					
	CERMET RPHX	RPNX	RPNX	RPHX	RPNX
ISO	50 483 ...	51 055 ...	51 054 ...	51 052 ...	51 057 ...
10T3M0SN	900				
10T3M8SN		020	020	020	
1204M0SN	902				
1204M8SN		025	025	025	025
1605M8SN			030	030	030
2006M8SN					035
P	●	●	●	●	●
M					
K	○	○	○	○	○
N					
S					
H					
O					

RPHX / RPNX

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				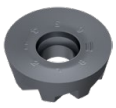
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10T3M8EN			120	
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1204M8SN	125	125		
1605M0SN		130		
2006M8EN				120
P	●	●	●	●
M	○	○	○	○
K	○	○	○	○
N				
S				
H				
O				

RPNX / RPHX

	-M50 CTPP235 DRAGONSKIN	-M50 CTPP235 DRAGONSKIN	-SN CTPP235 DRAGONSKIN	-SN CTPP235 DRAGONSKIN
				
	RPNX	RPHX	RPHX	RPNX
	51 054 ...	51 050 ...	51 052 ...	51 057 ...
ISO				
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1204M8SN	125		125	125
1605M8SN	130		130	130
2006M8SN				135
P	●	●	●	●
M	○	○	○	○
K	○	○	○	○
N				
S				
H				
O				

RPHX

	-F50 CTPM225 DRAGONSKIN	-M30 CTPM225 DRAGONSKIN	-SN CTPM225 DRAGONSKIN	-F50 CTCM235 DRAGONSKIN	-M30 CTCM235 DRAGONSKIN
					
	RPHX	RPHX	RPHX	RPHX	RPHX
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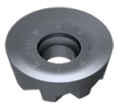
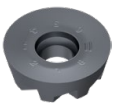
ISO					
1204M8EN		225			325
1204M8SN	225		225	325	
P	●	●	●	●	●
M	●	●	●	●	●
K					
N					
S					
H					
O					

15

RPHX / RPNX

	-F50 CTPM240 DRAGONSKIN	-F50 CTPM240 DRAGONSKIN	-M30 CTPM240 DRAGONSKIN	-M30 CTPM240 DRAGONSKIN	-M50 CTPM240 DRAGONSKIN
					
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10T3M8SN	420				420
1204M8EN			425		
1204M8SN	425				425
1605M8EN			430		
1605M8SN	430				
2006M8EN				420	
2006M8SN		435			
P	○	○	○	○	○
M	●	●	●	●	●
K					
N					
S					
H					
O					

RPHX / RPNX

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			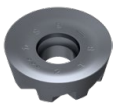		
	RPHX	RPHX	RPNX	RPHX	RPHX
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ISO					
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10T3M8SN		471	471		471
1204M4EN	475 [1]			475 [1]	
1204M4SN		475 [1]	475 [1]		475 [1]
1204M6SN		476			476
1204M8SN		477	476		477
1605M8SN		480			
2006M4SN		485 [1]			
2006M8SN			485		
P	●	●	●	●	●
M	●	●	●	●	●
K					
N					
S					
H					
O					

1) Insert with 4 indexes

RPNX / RPHX

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		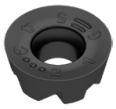		
	RPNX	RPNX	RPHX	RPHX
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ISO				
10T3M4SN	92001[1)]		92001[1)]	92001[1)]
10T3M8SN	92101		92101	
1204M4SN	92501[1)]		92501[1)]	92501[1)]
1204M6SN		92601	92601	92601
1204M8SN	92601			92701
1605M8SN	93001		93001	
2006M8SN	93501	93501		
P	●	●	●	●
M	●	●	●	●
K				
N				
S	○	○	○	○
H				
O				

1) Insert with 4 indexes

RPHX / RPNX

		-SN CTCK215 DRAGONSKIN	-SN CTCK215 DRAGONSKIN	-SN CTPK220 DRAGONSKIN	NEW -F10 CTPX715 DRAGONSKIN	-27P H216T
						
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ISO						
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10T3M8SN	520			620		
1204M8FN					02502	602
1204M8SN	525	525		625		
1605M8FN					03002	604
1605M8SN	530	530		630		
2006M8SN		535		635		
P					○	
M					○	
K	●	●	●		●	○
N					●	●
S					○	
H						
O					○	○

15

RPNX / RPHX

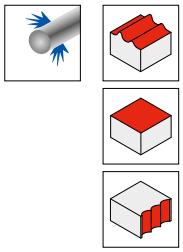
	-M31 CTC5240 DRAGONSKIN	-M31 CTC5240 DRAGONSKIN	-F50 CTCS245 DRAGONSKIN	-F50 CTCS245 DRAGONSKIN	-R60 CTP6215
					
	RPNX	RPHX	RPHX	RPNX	RPNX
ISO	51 149 ...	50 493 ...	51 051 ...	51 055 ...	50 508 ...
10T3M4EN		550 [1]			
10T3M4SN			570 [1]		
10T3M8EN		551			
10T3M8SN			571		
1204M4EN		552 [1]			
1204M4SN			575		
1204M6EN		56200			
1204M6SN			57800		
1204M8EN		582			300
1204M8SN			577		
1605M8EN		555	58100		
2006M8EN	12001				
2006M8SN				585	
P					
M					
K					●
N					
S	●	●	●	●	
H					●
O					

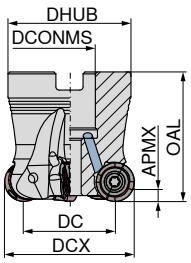
1) Insert with 4 indexes

Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 188
Technical Information	→ 191–197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

MaxiMill – 252 Shell mill





58 689 ...

Designation	DC inch	DCX inch	ZNF	APMX inch	OAL inch	DHUB inch	DCONMS inch	RPMX 1/min.	torque moment Nm	Insert	
A252.150.R.04-12-A050-175-EF	1.027	1.500	4	0.118	1.500	1.500	0.500	15900	3.2	RNHU 1205..	**15004**
A252.200.R.05-12-A075-175-EF	1.527	2.000	5	0.118	1.750	1.750	0.750	12700	3.2	RNHU 1205..	**20005**
A252.250.R.06-12-A100-200-EF	2.027	2.500	6	0.118	2.250	2.250	1.000	10100	3.2	RNHU 1205..	**25006**
A252.300.R.07-12-A100-200-EF	2.527	3.000	7	0.118	2.250	2.250	1.000	7950	3.2	RNHU 1205..	**30007**

Screwdriver

80 950 ...

Molykote

70 950 ...

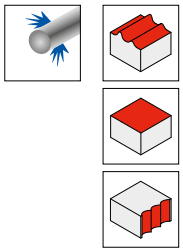
Clamping screw

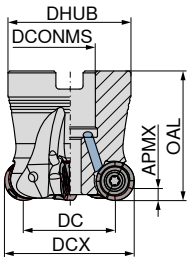
70 950 ...

Spare parts DCX			
1.500 - 3.000	**128**	**303**	**859**

15

MaxiMill – 252 Shell mill





NEW

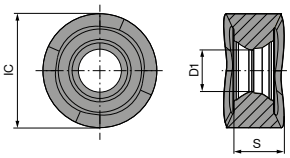
50 689 ...

Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS mm	DHUB mm	torque moment Nm	Insert	
A252.40.R.05-10	30	40	5	2.5	40	16	38	2	RNHU 1004..	**140**
A252.42.R.05-10	32	42	5	2.5	40	16	38	2	RNHU 1004..	**142**
A252.50.R.06-10	40	50	6	2.5	40	22	43	2	RNHU 1004..	**150**
A252.52.R.07-10	42	52	7	2.5	40	22	43	2	RNHU 1004..	**152**
A252.63.R.08-10	53	63	8	2.5	40	22	48	2	RNHU 1004..	**16300**
A252.80.R.10-10	70	80	10	2.5	50	27	58	2	RNHU 1004..	**18000**
A252.40.R.04-12	28	40	4	3.0	40	16	38	3.2	RNHU 1205..	**240**
A252.50.R.05-12	38	50	5	3.0	40	22	43	3.2	RNHU 1205..	**250**
A252.52.R.05-12	40	52	5	3.0	40	22	43	3.2	RNHU 1205..	**252**
A252.63.R.06-12	51	63	6	3.0	40	22	48	3.2	RNHU 1205..	**263**
A252.66.R.07-12	54	66	7	3.0	40	22	48	3.2	RNHU 1205..	**266**
A252.80.R.08-12	68	80	8	3.0	50	27	58	3.2	RNHU 1205..	**280**
A252.100.R.10-12	88	100	10	3.0	50	32	78	3.2	RNHU 1205..	**30000**
A252.125.R.12-12	113	125	12	3.0	63	40	88	3.2	RNHU 1205..	**32500**

	TORX® blade	 Clamping key – T	 Screwdriver	 Power Screw	 Molykote	 Clamping screw	 Torque screw-driver
	80 950 ...	**80 397 ...**	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**80 950 ...**
Spare parts							
Insert							
RNHU 1004.. (Ø40 – Ø80)	**053**		**127**		**303**	**710**	**192**
RNHU 1205.. (Ø40)	**054**	**040**	**128**	**151**	**303**	**839**	**192**
RNHU 1205.. (Ø50 – Ø125)	**054**		**128**		**303**	**839**	**192**

RNHU

Designation	IC inch	D1 inch	S inch
RNHU 1004..	0.394	0.134	0.181
RNHU 1205..	0.472	0.173	0.209



RNHU

	NEW	NEW	NEW	NEW	NEW	NEW
	-M50 CTPP235	-F50 CTPM240	-M31 CTPM245	-M32 CTPM245	-M31 CTC5240	-M31 CTC5240
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	RNHU	RNHU	RNHU	RNHU	RNHU	RNHU
	51 130 ...	51 129 ...	51 106 ...	51 107 ...	50 520 ...	50 521 ...
ISO						
1004M4ER	12000	42000	470	470	550	
1205M4ER		42500	475	475		552
1205M4SR	12500					
P	●	○	●	●		
M	○	●	●	●		
K	○					
N						
S					●	●
H						
O						

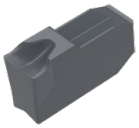
Milling guide

Cutting data standard values	→ 154–157	Machining strategy	→ 189
Technical Information	→ 191+197	Chip groove description and overview	→ 198–200
Grade description and overview	→ 202–207		

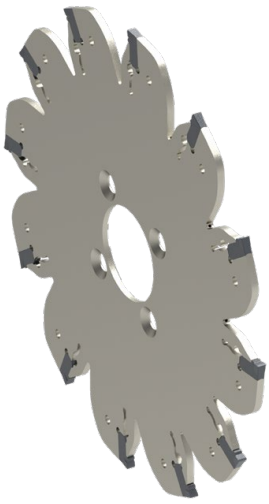
Application tips – **MaxiMill** – Slot-SX

▲ The following components are required to complete the tool:

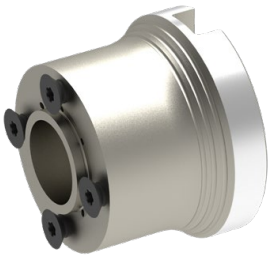
Spanner



Grooving insert



Saw cutters

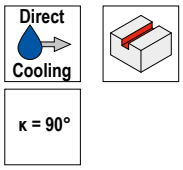


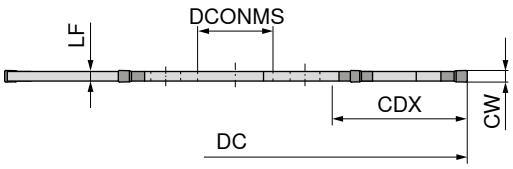
Multipurpose milling cutter adapter

MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws





NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 383 ...
ASLOT.80.R.6.13.DC-SX2	80	2	23	13	1.65	6	5000	SX E2 ..	AD.SLOT.13...	**08002**
ASLOT.80.R.6.13.DC-SX3	80	3	23	13	2.50	6	6700	SX E3 ..	AD.SLOT.13...	**08003**
ASLOT.80.R.4.13.DC-SX4	80	4	23	13	3.50	4	5200	SX E4 ..	AD.SLOT.13...	**08004**
ASLOT.80.R.4.13.DC-SX5	80	5	23	13	4.50	4	5000	SX E5 ..	AD.SLOT.13...	**08005**

Clamping screw

Insert mounting key SX

Spare parts for Article no.	50 950 ...	70 950 ...
50 383 08002	**00100**	**836**
50 383 08003	**00100**	**836**
50 383 08004	**00100**	**837**
50 383 08005	**00100**	**837**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

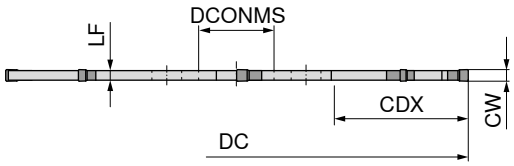
MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

Direct Cooling

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS H6 mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 384 ...
ASLOT.100.R.8.22.DC-SX2	100	2	29	22	1.65	8	4500	SX E2 ..	AD.SLOT.22...	**10002**
ASLOT.100.R.8.22.DC-SX3	100	3	29	22	2.50	8	6000	SX E3 ..	AD.SLOT.22...	**10003**
ASLOT.100.R.6.22.DC-SX4	100	4	29	22	3.50	6	5700	SX E4 ..	AD.SLOT.22...	**10004**
ASLOT.100.R.6.22.DC-SX5	100	5	29	22	4.50	6	4500	SX E5 ..	AD.SLOT.22...	**10005**
ASLOT.100.R.4.22.DC-SX6	100	6	29	22	5.40	4	3900	SX E6 ..	AD.SLOT.22...	**10006**

Clamping screw

50 950 ...

Insert mounting key SX

70 950 ...

Spare parts for Article no.		
50 384 10002	**00100**	**836**
50 384 10003	**00100**	**836**
50 384 10004	**00100**	**837**
50 384 10005	**00100**	**837**
50 384 10006	**00100**	**837**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

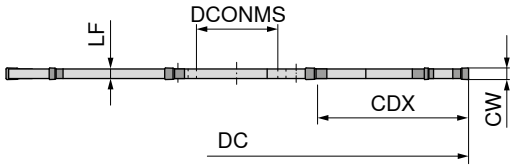
MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

Direct Cooling

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 385 ...
ASLOT.125.R.10.22.DC-SX2	125	2	42	22	1.65	10	4000	SX E2 ..	AD.SLOT.22...	**12502**
ASLOT.125.R.10.22.DC-SX3	125	3	42	22	2.50	10	5300	SX E3 ..	AD.SLOT.22...	**12503**

Clamping screw

Insert mounting key SX

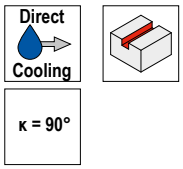
Spare parts for Article no.	50 950 ...	70 950 ...
50 385 12502	**00100**	**836**
50 385 12503	**00100**	**836**

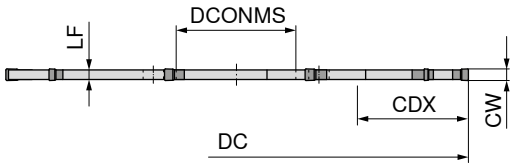
→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws





NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 386 ...
ASLOT.125.R.10.32.DC-SX2	125	2	30	32	1.65	10	4000	SX E2 ..	AD.SLOT.32...	**12502**
ASLOT.125.R.10.32.DC-SX3	125	3	30	32	2.50	10	5300	SX E3 ..	AD.SLOT.32...	**12503**
ASLOT.125.R.8.32.DC-SX4	125	4	30	32	3.50	8	4200	SX E4 ..	AD.SLOT.32...	**12504**
ASLOT.125.R.8.32.DC-SX5	125	5	30	32	4.50	8	4000	SX E5 ..	AD.SLOT.32...	**12505**
ASLOT.125.R.8.32.DC-SX6	125	6	30	32	5.40	8	3500	SX E6 ..	AD.SLOT.32...	**12506**

Clamping screw

Insert mounting key SX

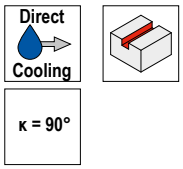
Spare parts for Article no.	50 950 ...	70 950 ...
50 386 12502	**00200**	**836**
50 386 12503	**00200**	**836**
50 386 12504	**00200**	**837**
50 386 12505	**00200**	**837**
50 386 12506	**00200**	**837**

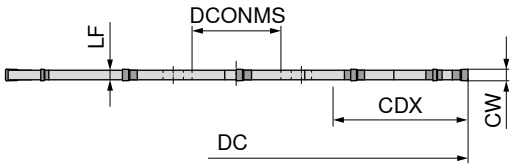
→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws





NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 387 ...
ASLOT.160.R.12.32.DC-SX2	160	2	48	32	1.65	12	3500	SX E2 ..	AD.SLOT.32...	**16002**
ASLOT.160.R.12.32.DC-SX3	160	3	48	32	2.50	12	4700	SX E3 ..	AD.SLOT.32...	**16003**

Clamping screw

Insert mounting key SX

Spare parts for Article no.	50 950 ...	70 950 ...
50 387 16002	**00200**	**836**
50 387 16003	**00200**	**836**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

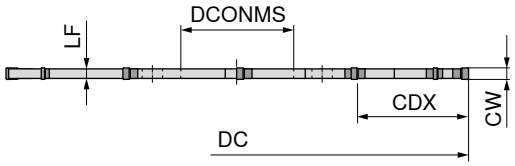
MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

Direct Cooling

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 388 ...
ASLOT.160.R.12.40.DC-SX2	160	2	39	40	1.65	12	3500	SX E2 ..	AD.SLOT.40...SK	**16002**
ASLOT.160.R.12.40.DC-SX3	160	3	39	40	2.50	12	4700	SX E3 ..	AD.SLOT.40...SK	**16003**
ASLOT.160.R.10.40.DC-SX4	160	4	39	40	3.50	10	3700	SX E4 ..	AD.SLOT.40...SK	**16004**
ASLOT.160.R.10.40.DC-SX5	160	5	39	40	4.50	10	3500	SX E5 ..	AD.SLOT.40...SK	**16005**
ASLOT.160.R.10.40.DC-SX6	160	6	39	40	5.40	10	3100	SX E6 ..	AD.SLOT.40...SK	**16006**

Clamping screw

50 950 ...

Insert mounting key SX

70 950 ...

Spare parts for Article no.		
50 388 16002	**00300**	**836**
50 388 16003	**00300**	**836**
50 388 16004	**00300**	**837**
50 388 16005	**00300**	**837**
50 388 16006	**00300**	**837**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

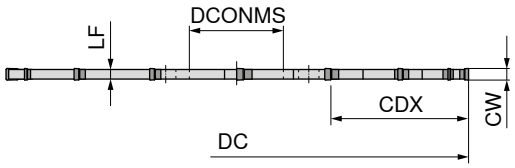
MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

Direct Cooling

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 389 ...
ASLOT.200.R.16.40.DC-SX2	200	2	59	40	1.65	16	3200	SX E2 ..	AD.SLOT.40...SK	**20002**
ASLOT.200.R.16.40.DC-SX3	200	3	59	40	2.50	16	4200	SX E3 ..	AD.SLOT.40...SK	**20003**
ASLOT.200.R.14.40.DC-SX4	200	4	59	40	3.50	14	3300	SX E4 ..	AD.SLOT.40...SK	**20004**
ASLOT.200.R.14.40.DC-SX5	200	5	59	40	4.50	14	3100	SX E5 ..	AD.SLOT.40...SK	**20005**
ASLOT.200.R.14.40.DC-SX6	200	6	59	40	5.40	14	2800	SX E6 ..	AD.SLOT.40...SK	**20006**

Clamping screw

50 950 ...

Insert mounting key SX

70 950 ...

Spare parts for Article no.		
50 389 20002	**00300**	**836**
50 389 20003	**00300**	**836**
50 389 20004	**00300**	**837**
50 389 20005	**00300**	**837**
50 389 20006	**00300**	**837**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

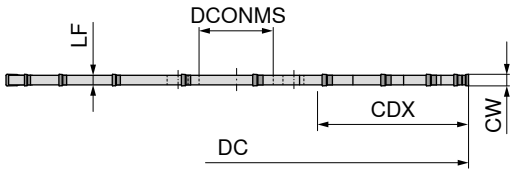
MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

Direct Cooling

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 380 ...
ASLOT.250.R.20.40.DC-SX3	250	3	84	40	2.5	20	3700	SX E3 ..	AD.SLOT.40...ZK	**25003**
ASLOT.250.R.18.40.DC-SX4	250	4	84	40	3.5	18	2900	SX E4 ..	AD.SLOT.40...ZK	**25004**
ASLOT.250.R.18.40.DC-SX5	250	5	84	40	4.5	18	2800	SX E5 ..	AD.SLOT.40...ZK	**25005**
ASLOT.250.R.18.40.DC-SX6	250	6	84	40	5.4	18	2500	SX E6 ..	AD.SLOT.40...ZK	**25006**[1)]

1) Not in stock

Clamping screw

50 950 ...

Insert mounting key SX

70 950 ...

Spare parts for Article no.		
50 380 25003	**00400**	**836**
50 380 25004	**00400**	**837**
50 380 25005	**00400**	**837**
50 380 25006	**00400**	**837**

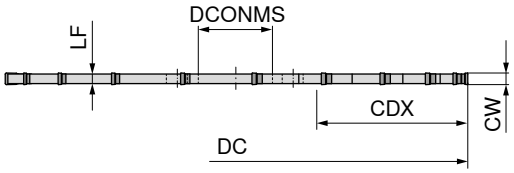
→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws

κ = 90°



NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 390 ...
ASLOT.250.R.20.40-SX3	250	3	84	40	2.5	20	3700	SX E3 ..	AD.SLOT.40...ZK	**25003**
ASLOT.250.R.18.40-SX4	250	4	84	40	3.5	18	2900	SX E4 ..	AD.SLOT.40...ZK	**25004**
ASLOT.250.R.18.40-SX5	250	5	84	40	4.5	18	2800	SX E5 ..	AD.SLOT.40...ZK	**25005**
ASLOT.250.R.18.40-SX6	250	6	84	40	5.4	18	2500	SX E6 ..	AD.SLOT.40...ZK	**25006**[1]

1) Not in stock

Clamping screw

50 950 ...

Insert mounting key SX

70 950 ...

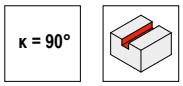
Spare parts for Article no.		
50 390 25003	**00400**	**836**
50 390 25004	**00400**	**837**
50 390 25005	**00400**	**837**
50 390 25006	**00400**	**837**

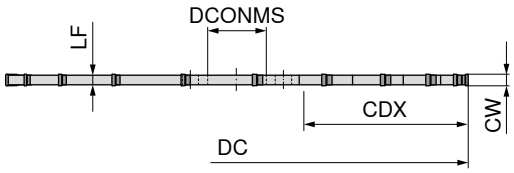
→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

MaxiMill – Slot-SX slot milling and parting off cutter

Scope of supply:

Slot milling and parting off cutters **without** assembly key, **without** clamping screws





NEW

Designation	DC mm	CW mm	CDX mm	DCONMS $_{H6}$ mm	LF mm	ZEFP	RPMX 1/min.	Insert	Adapter	50 391 ...
ASLOT.315.R.22.40-SX4	315	4	115	40	3.5	22	2600	SX E4 ..	AD.SLOT.40...ZK	**31504**
ASLOT.315.R.22.40-SX5	315	5	115	40	4.5	22	2500	SX E5 ..	AD.SLOT.40...ZK	**31505**
ASLOT.315.R.22.40-SX6	315	6	115	40	5.4	22	2200	SX E6 ..	AD.SLOT.40...ZK	**31506**[1)]

1) Not in stock

Clamping screw

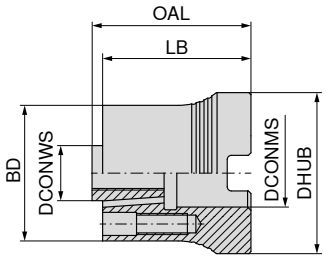
Insert mounting key SX

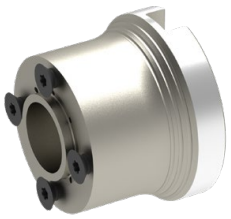
Spare parts for Article no.	50 950 ...	70 950 ...
50 391 31504	**00400**	**837**
50 391 31505	**00400**	**837**
50 391 31506	**00400**	**837**

→ **Page 146**
Here you will find suitable multipurpose milling cutter adapters.

MaxiMill – Slot-SX multipurpose milling cutter adapter

Scope of supply:
Multipurpose milling cutter adapter including screws



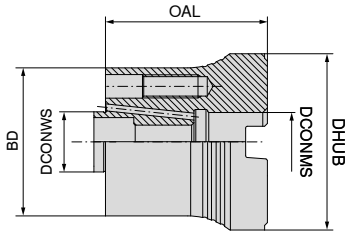


NEW

Designation	DCONMS mm	DCONWS h6 mm	DHUB mm	LB mm	OAL mm	BD mm	50 395 ...
AD.SLOT.13.32.A16	16	13	38	35	37.5	32	01300
AD.SLOT.22.40.A22	22	22	48	35	37.5	40	02200
AD.SLOT.32.63.A27	27	32	58	45	47.5	63	03200
AD.SLOT.40.80.A32.SK	32	40	78	55	57.5	80	04000
AD.SLOT.40.80.A32.ZK	32	40	78	55	57.5	80	04100

MaxiMill – Slot-SX multipurpose INCH milling cutter adapter

Scope of supply:
Multipurpose milling cutter adapter including screws



NEW

Designation	DCONMS inch	DCONWS h6 inch	DHUB inch	LB inch	OAL inch	BD inch	58 395 ...
AD.SLOT.13.32.A50-E	0.500	0.512	1.500	1.378	1.476	1.260	01300
AD.SLOT.22.40.A075-E	0.750	0.866	1.750	1.378	1.476	1.575	02200
AD.SLOT.32.63.A100-E	1.000	1.260	2.250	1.772	1.870	2.480	03200
AD.SLOT.40.80.A125.SK-E	1.250	1.575	2.750	2.165	2.264	3.150	04000
AD.SLOT.40.80.A125.ZK-E	1.250	1.575	2.750	2.165	2.264	3.150	04100

Spare parts for Article no.	 Clamping screw 50 950 ...	 Clamping screw 50 950 ...	 Clamping screw 50 950 ...	 Power Screw 70 950 ...	
50 395 01300	00100				151
50 395 02200 / 58 395 01300	00100				
50 395 03200 / 58 395 03200	00200				
50 395 04000 / 58 395 04000			00300		
50 395 04100 / 58 395 04100		00400			
58 395 02200	00100				

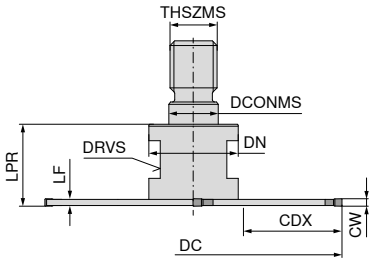
MaxiMill – Slot-SX screw-in multipurpose milling cutter

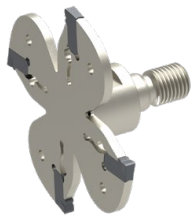
Scope of supply:

Screw-in multipurpose milling cutter **without** assembly key

Direct Cooling

κ = 90°





NEW

50 392 ...

Designation	DC mm	CW mm	CDX mm	DCONMS mm	THSZMS	LF mm	DN mm	LPR mm	DRVS mm	ZEFP	RPMX 1/min.	Insert	
GSLOT.63.R.4.M10.DC-SX2	63	2	21	10.5	M10	1.65	19	18	15	4	5700	SX E2 ..	**06302**
GSLOT.63.R.4.M10.DC-SX3	63	3	21	10.5	M10	2.50	19	18	15	4	7500	SX E3 ..	**06303**

Insert mounting key SX

70 950 ...

Spare parts for Article no.	
50 392 06302	**836**
50 392 06303	**836**

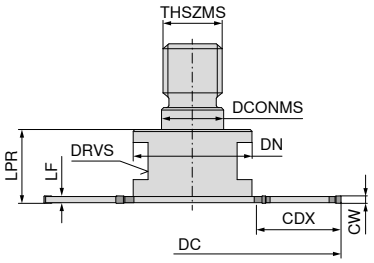
MaxiMill – Slot-SX screw-in multipurpose milling cutter

Scope of supply:

Screw-in multipurpose milling cutter **without** assembly key

Direct Cooling

κ = 90°



NEW

50 393 ...

Designation	DC mm	CW mm	CDX mm	DCONMS mm	THSZMS	LF mm	DN mm	LPR mm	DRVS mm	ZEFP	RPMX 1/min.	Insert	
GSLOT.80.R.6.M16.DC-SX2	80	2	23	17	M16	1.65	32	20	24	6	5000	SX E2 ..	**08002**
GSLOT.80.R.6.M16.DC-SX3	80	3	23	17	M16	2.50	32	20	24	6	6700	SX E3 ..	**08003**
GSLOT.80.R.4.M16.DC-SX4	80	4	23	17	M16	3.50	32	20	24	4	5200	SX E4 ..	**08004**

Insert mounting key SX

70 950 ...

Spare parts for Article no.	
50 393 08002	**836**
50 393 08003	**836**
50 393 08004	**837**

15

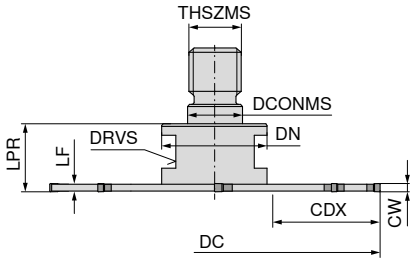
MaxiMill – Slot-SX screw-in multipurpose milling cutter

Scope of supply:

Screw-in multipurpose milling cutter **without** assembly key

Direct Cooling

κ = 90°



NEW

50 394 ...

Designation	DC mm	CW mm	CDX mm	DCONMS mm	THSZMS	LF mm	DN mm	LPR mm	DRVS mm	ZEFP	RPMX 1/min.	Insert	
GSLOT.100.R.8.M16.DC-SX2	100	2	33	17	M16	1.65	32	20	24	8	4500	SX E2 ..	**10002**
GSLOT.100.R.8.M16.DC-SX3	100	3	33	17	M16	2.50	32	20	24	8	6000	SX E3 ..	**10003**
GSLOT.100.R.6.M16.DC-SX4	100	4	33	17	M16	3.50	32	20	24	6	4700	SX E4 ..	**10004**

Insert mounting key SX

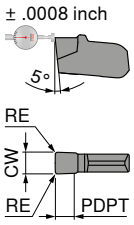
70 950 ...

Spare parts for Article no.	
50 394 10002	**836**
50 394 10003	**836**
50 394 10004	**837**

Suitable adapters for screw-in cutters can be found in – Chapter 16 Adapters and accessories

Insert SX

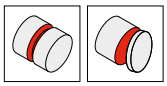
F	M	R



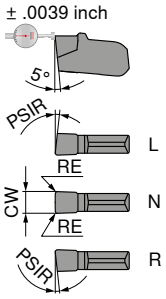
-F2
CTP1340
DRAGONSKIN

Designation	CW inch	RE inch	PDPT inch	for tool holder	70 346 ...
SX E2.00 N 0.20	0.079	0.008	0.059	-SX2	**622**
SX E3.00 N 0.30	0.118	0.012	0.079	-SX3	**623**
SX E4.00 N 0.40	0.157	0.016	0.098	-SX4	**624**
P					●
M					●
K					○
N					○
S					●
H					
O					

Insert SX



F	M	R



-M1
CTCP335
DRAGONSKIN

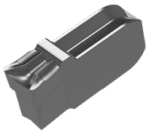
-M1
CTP1340
DRAGONSKIN

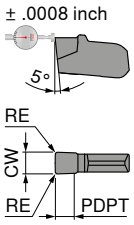
Designation	IH	CW inch	RE inch	for tool holder	70 342 ...	70 342 ...
SX E2.00 N 0.20	N	0.079	0.008	-SX2	**52200**	**622**
SX E3.00 N 0.20	N	0.118	0.008	-SX3	**523**	**623**
SX E4.00 N 0.30	N	0.157	0.012	-SX4	**524**	**624**
SX E5.00 N 0.30	N	0.197	0.012	-SX5	**52500**	**625**
SX E6.00 N 0.40	N	0.236	0.016	-SX6	**52600**	**626**
P					●	●
M					○	●
K					●	○
N						○
S						●
H						
O						

Insert SX

F	M	R

-27P
H216T





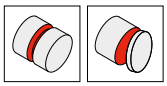
70 349 ...

Designation	CW inch	RE inch	PDPT inch	for tool holder	
SX E2.00 N 0.20	0.079	0.008	0.079	-SX2	**122**
SX E3.00 N 0.30	0.118	0.012	0.098	-SX3	**123**
SX E4.00 N 0.40	0.157	0.016	0.118	-SX4	**124**

P	
M	
K	○
N	●
S	
H	
O	○

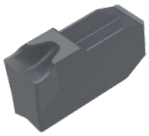
Insert SX

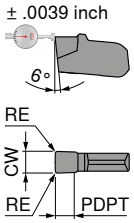
NEW



F	M	R

-M7
CTP1340
DRAGONSKIN



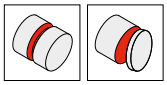


70 347 ...

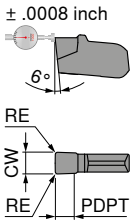
Designation	CW inch	RE inch	PDPT inch	for tool holder	
SX E2.00 N 0.20	0.079	0.008	0.059	-SX2	**62200**
SX E3.00 N 0.20	0.118	0.008	0.079	-SX3	**62300**
SX E4.00 N 0.25	0.157	0.010	0.098	-SX4	**62400**
SX E5.00 N 0.30	0.197	0.012	0.106	-SX5	**62500**
SX E6.00 N 0.35	0.236	0.014	0.118	-SX6	**62600**

P	●
M	●
K	○
N	○
S	●
H	
O	

Insert SX



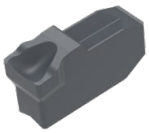
F	M	R



NEW

-M8
CTP1340

DRAGONSKIN



70 348 ...

Designation	CW inch	RE inch	PDPT inch	for tool holder	
SX E2.00 N 0.20	0.079	0.008	0.059	-SX2	**62200**
SX E3.00 N 0.20	0.118	0.008	0.079	-SX3	**62300**
SX E4.00 N 0.25	0.157	0.010	0.098	-SX4	**62400**
SX E5.00 N 0.30	0.197	0.012	0.106	-SX5	**62500**
SX E6.00 N 0.35	0.236	0.014	0.118	-SX6	**62600**

P	●
M	●
K	○
N	○
S	●
H	
O	

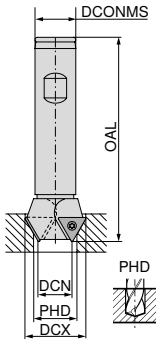
Milling guide

Cutting data standard values	→ 190	Technical Information	→ 191–197
Chip groove description and overview	→ 198–200	Grade description and overview	→ 202–207

Insert countersink 90°

Scope of supply:
Indexable insert countersink including clamping screws

WPS




SIG 90°

58 196 ...

DCX inch	DCN inch	PHD inch	ZEFP	ZNF	DCONMS inch	OAL inch	Insert	
0.748	0.276	0.374	2	2	0.625	3.940	TOHX 090204	**19000**
0.906	0.433	0.472	2	2	0.625	3.940	TOHX 090204	**23000**
1.024	0.433	0.472	1	2	0.625	3.940	TOHX 090204	**26000**
1.181	0.472	0.472	2	2	0.750	3.940	TOHX 140305	**30000**
1.339	0.630	0.669	2	2	0.750	3.940	TOHX 140305	**34000**
1.457	0.748	0.787	2	2	0.750	3.940	TOHX 140305	**37000**


TORX® Screws

62 950 ...

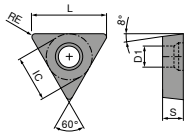

Screwdriver

80 950 ...

Spare parts DCX		
0.748 - 1.024	**09900**	**125**
1.181 - 1.457	**12600**	**127**

TOHX

Designation	L inch	S inch	D1 inch	IC inch
140305EN	0.536	0.118	0.150	0.323



TOHX

	-G06 BK8425	-U877 BK8425	-G12 BK8425
			
	F TOHX	F TOHX	F TOHX
	62 602 ...	62 604 ...	62 603 ...
ISO / RE inch			
090204EN 0.016		31400	31400
140305EN 0.020	33000		
P	●	●	●
M	●	●	●
K	●	●	●
N	○	○	○
S	●	●	●
H	○	○	○
O			

TOHX

	-U877 K10
	
	F TOHX
	62 604 ...
ISO / RE inch	
090204EN 0.016	51400
P	
M	
K	
N	●
S	●
H	
O	●

15

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment		Tensile strength lbf/in²* / HB / HRC	Material number	Material designation	Material number	Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C	Annealed	60900 lbf/in² / 125 HB	1.0401	1015	1.0301	1010
		P.1.2	< 0.45 % C	Annealed	92800 lbf/in² / 190 HB	1.1191	1045	1.0737	12L14
		P.1.3		Tempered	121800 lbf/in² / 250 HB	1.1191	1045	1.0503	1043
		P.1.4	< 0.75 % C	Annealed	132000 lbf/in² / 270 HB	1.1223	1060	1.0535	1055
		P.1.5		Tempered	146500 lbf/in² / 300 HB	1.1223	1060	1.1274	1095
	Low-alloy steel	P.2.1		Annealed	88500 lbf/in² / 180 HB	1.7131	5115	1.6523	8620
		P.2.2		Tempered	134900 lbf/in² / 275 HB	1.7131	5115	1.6582	4340
		P.2.3		Tempered	146500 lbf/in² / 300 HB	1.7225	4142	1.7131	5115
		P.2.4		Tempered	174000 lbf/in² / 375 HB	1.7225	4142	17223	4140
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	98600 lbf/in² / 200 HB	1.4021	420	1.2379	D2
		P.3.2		Hardened and tempered	159500 lbf/in² / 300 HB	1.2343	H11	1.3343	M2
		P.3.3		Hardened and tempered	188500 lbf/in² / 400 HB	1.2343	H11	1.2363	A2
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	98600 lbf/in² / 200 HB	1.4016	430	1.4125	440C
		P.4.2	Martensitic	Tempered	117500 lbf/in² / 250 HB	1.4112	S44003	1.4021	420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	88500 lbf/in² / 200 HB	1.4301	304	1.4401	316
		M.2.1	Austenitic	Tempered	300 HB	1.4841	314	1.4568	17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)		113100 lbf/in² / 230 HB	1.4462	S32205	1.4410	S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic		88500 lbf/in² / 180 HB	0.6010	A48-20B	0.6025	A48-40 B
		K.1.2	Pearlitic (martensitic)		127600 lbf/in² / 260 HB	0.6030	A48-45B	0.6040	A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic		78300 lbf/in² / 160 HB	0.7040	60-40-18	0.7050	65-45-12
		K.2.2	Pearlitic		122600 lbf/in² / 250 HB	0.7070	100-70-03	0.7660	A439 Type D2
	Malleable iron	K.3.1	Ferritic		63800 lbf/in² / 130 HB	0.8035	GTW-35-04		
		K.3.2	Pearlitic		113100 lbf/in² / 230 HB	0.8170	70003		
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB	3.0255	A91060	3.0255	A91060
		N.1.2	Hardenable		49300 lbf/in² / 100 HB	3.1355	2024	3.1355	2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		36300 lbf/in² / 75 HB	3.2581	A04130 / A413-0	3.2581	A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable		43500 lbf/in² / 90 HB	3.2134	G-AlSi5Cu1Mg		
		N.2.3	> 12 % Si, non-hardenable		63800 lbf/in² / 130 HB		G-AlSi17Cu4Mg		
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		54400 lbf/in² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0380	C37700
		N.3.2	CuZn, CuSnZn		43500 lbf/in² / 90 HB	2.0331	CuZn15	2.0331	C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper		49300 lbf/in² / 100 HB	2.0060	E-Cu57		
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB	3.5612	MgAl6Zn		
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	98600 lbf/in² / 200 HB	1.4864	X12NiCrSi 36-16	1.4864	330
		S.1.2			137800 lbf/in² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4980	S66286
		S.2.1	Ni or Co basis	Annealed	121800 lbf/in² / 250 HB	2.4856	Inconel 625	2.4812	Hastelloy C
		S.2.2			171100 lbf/in² / 350 HB	2.4952	Nimonic 80A	2.4668	Inconel 718
		S.2.3		Cast	156600 lbf/in² / 320 HB	2.4674	Nimocast PK24	2.4670	Nimocast 713
	Titanium alloys	S.3.1	Pure titanium		5800 lbf/in²	3.7025	Ti99,8		
		S.3.2	Alpha + beta alloys		152300 lbf/in²	3.7165	TiAl6V4		
		S.3.3	Beta alloys		203100 lbf/in² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr		
H	Hardened steel	H.1.1		Hardened and tempered	46-55 HRC				
		H.1.2		Hardened and tempered	56-60 HRC				
		H.1.3		Hardened and tempered	61-65 HRC				
		H.1.4		Hardened and tempered	66-70 HRC				
	Chilled iron	H.2.1		Cast	400 HB				
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 21800 lbf/in²				
		O.1.2	Plastics, thermoplastic		≤ 14500 lbf/in²				
		O.2.1	Aramid fibre-reinforced		≤ 145000 lbf/in²				
		O.2.2	Glass/carbon-fibre reinforced		≤ 145000 lbf/in²				
		O.3.1	Graphite						

*** Tensile Strength at Rupture (Rm)**

Cutting data standard values

Index	CTEP210		TCM10		CTCP220		CTPP225		CTCP230		CTPP231		CTPP235		CTPP236	
	CERMET		CERMET													
					DRAGONSKIN								DRAGONSKIN			
	Cutting Material **hard** (v_c↑) → **tough** (v_c↓)															
	v_c (ft/min)															
P.1.1	1130		960		1120	560	870	520	940	500	660	330	810	450	990	590
P.1.2	1000		850		1020	510	770	470	800	440	560	300	690	400	890	530
P.1.3	870		740		920	460	680	430	670	390	460	260	570	350	740	430
P.1.4	820		710		890	450	650	410	620	370	560	300	530	330	890	530
P.1.5	760		650		840	420	610	390	560	350	530	300	470	310	790	460
P.2.1	1020		870		1030	520	790	480	820	450	560	300	700	410	890	530
P.2.2	810		700		880	440	650	410	610	370	430	230	520	330	660	400
P.2.3	760		650		840	420	610	390	560	350	560	300	470	310	890	530
P.2.4	600		520		730	360	500	340	390	280	400	200	320	250	590	360
P.3.1					460	230	430	210	460	290	560	300	400	320	890	530
P.3.2					310	170	330	170	300	180	460	260	360	270	590	460
P.3.3					170	100	230	120	130	70	400	230	320	230	500	400
P.4.1					460	230	430	210	460	290	460	260	400	320	590	460
P.4.2					390	200	380	190	380	230	430	230	380	300	560	430
M.1.1											560	300	400	320	890	530
M.2.1													360	270		
M.3.1													390	390		
K.1.1									1020	630	1190	300	530	360	500	360
K.1.2	990		790						530	330	1190	300	500	360	500	360
K.2.1	1160		920						660	400	760	560	500	360	500	360
K.2.2	990		790						430	260	530	360	500	360	500	360
K.3.1	990		790						630	380					690	500
K.3.2									530	330					690	500
N.1.1																
N.1.2																
N.2.1																
N.2.2																
N.2.3																
N.3.1																
N.3.2																
N.3.3																
N.4.1																
S.1.1																
S.1.2																
S.2.1																
S.2.2																
S.2.3																
S.3.1																
S.3.2																
S.3.3																
H.1.1																
H.1.2																
H.1.3																
H.1.4																
H.2.1																
H.3.1																
O.1.1																
O.1.2																
O.2.1																
O.2.2																
O.3.1																

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

Cutting data standard values

Index	CTPM225		CTCM235		CTPM240		CTPM241		CTPM245		CTCM245		CTN3105		CTL3215	
													CERAMIC		CBN	
	DRAGONSKIN															
	Cutting Material **hard** (v_c↑) → **tough** (v_c↓)															
	v_c (ft/min)															
P.1.1	900	630	830	610	750	470	660	330	800	460	920	440				
P.1.2	760	540	690	500	620	420	560	300	680	410	800	390				
P.1.3	640	450	570	410	500	370	460	230	570	360	680	340				
P.1.4	600	430	530	370	460	350	560	300	530	340	650	330				
P.1.5	530	380	470	330	400	330	500	260	480	320	590	300				
P.2.1	780	550	710	520	640	420	560	300	700	420	820	400				
P.2.2	580	420	520	370	450	350	400	200	520	340	640	320				
P.2.3	530	380	470	330	400	330	560	300	480	320	590	300				
P.2.4	380	280	310	210	260	270	360	200	330	260	450	240				
P.3.1	490	400	450	380	410	350	690	330	510	350	580	400				
P.3.2	400	330	420	360	370	310	590	330	470	310	540	360				
P.3.3	310	270	400	350	320	280	530	300	430	260	500	310				
P.4.1	490	400	450	380	410	350	460	300	510	350	580	400				
P.4.2	440	370	440	370	390	330	430	260	490	330	560	380				
M.1.1	**490**	**400**	**450**	**380**	**410**	**350**	**690**	**330**	**510**	**350**	**580**	**400**				
M.2.1	**400**	**330**	**420**	**360**	**370**	**310**	**590**	**300**	**470**	**310**	**540**	**360**				
M.3.1	**460**	**380**	**440**	**380**	**400**	**340**	**690**	**330**	**500**	**340**	**570**	**390**				
K.1.1													**2640**		**2 640**	
K.1.2													**1980**		**1980**	
K.2.1																
K.2.2															**1490**	
K.3.1																
K.3.2																
N.1.1																
N.1.2																
N.2.1																
N.2.2																
N.2.3																
N.3.1																
N.3.2																
N.3.3																
N.4.1																
S.1.1								200				260				
S.1.2								200				230				
S.2.1								200				120				
S.2.2								200				80				
S.2.3								200				100				
S.3.1								200				270				
S.3.2								200				170				
S.3.3								200				130				
H.1.1																
H.1.2															500	
H.1.3																
H.1.4																
H.2.1															920	
H.3.1																
O.1.1																
O.1.2																
O.2.1																
O.2.2																
O.3.1																

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

Cutting data standard values

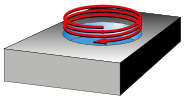
Index	CTCK215		CTPK220		CTPK221		AMZ		H216T		CTWN215		CTC5240		CTCS245		CTP6215	
	DRAGONSKIN		DRAGONSKIN										DRAGONSKIN					
	Cutting Material **hard** (v_c↑) → **tough** (v_c↓)																	
	v_c (ft/min)																	
P.1.1			630	400	630	400												
P.1.2			600	330	590	330												
P.1.3			500	270	500	260												
P.1.4			600	330	590	330												
P.1.5			560	300	560	300												
P.2.1			600	330	590	330												
P.2.2			460	270	460	260												
P.2.3			600	330	590	330												
P.2.4			430	270	430	260												
P.3.1			700	400	690	400												
P.3.2			530	300	530	300												
P.3.3			430	270	430	260												
P.4.1			700	400	690	400												
P.4.2			630	330	630	330												
M.1.1					400	330												
M.2.1					360	300												
M.3.1					400	330												
K.1.1	**1190**	**690**	**1060**	**630**	**890**	**660**	660	430	430	430	430	430					920	830
K.1.2	**730**	**430**	**560**	**330**	**890**	**660**	530	360	360	360	360	360					630	530
K.2.1	**760**	**460**	**690**	**430**	**830**	**590**	610	430	430	430	430	430					590	500
K.2.2	**530**	**330**	**460**	**300**	**590**	**400**	500	400	400	400	400	400					590	500
K.3.1	**830**	**500**	**660**	**400**	**730**	**560**	660	430	430	430	430	430					830	730
K.3.2	**690**	**430**	**560**	**330**	**730**	**560**	580	360	360	360	360	400					630	530
N.1.1								**4950**		**4950**		**4950**						
N.1.2								**3300**		**3300**		**3300**						
N.2.1								**3960**		**3630**		**3630**						
N.2.2								**3960**		**3300**		**3300**						
N.2.3								**990**		**920**		**920**						
N.3.1								**1160**		**1160**		**1160**						
N.3.2								**1160**		**1160**		**1160**						
N.3.3								**1060**		**1060**		**1060**						
N.4.1								**1060**		**1060**		**1060**						
S.1.1								200						**260**		**210**		
S.1.2								170						**230**		**180**		
S.2.1								100						**120**		**90**		
S.2.2								70						**80**		**70**		
S.2.3								70						**100**		**80**		
S.3.1								200						**260**		**210**		
S.3.2								130						**170**		**130**		
S.3.3								100						**130**		**110**		
H.1.1																	**170**	
H.1.2																	**130**	
H.1.3																		
H.1.4																		
H.2.1																		
H.3.1																		
O.1.1								530	530	530	530	530						
O.1.2																		
O.2.1								590	790	790	790	790						
O.2.2																		
O.3.1																		

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

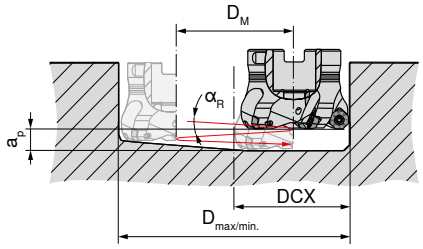
System MaxiMill 274-04/-09

Machining strategy

Helical plunge milling



$D_{max.}$ in inch = largest diameter for flat bottom hole
$D_{min.}$ in inch = smallest hole diameter for flat bottom surface
D_M = D_{max} – DCX and D_{min} – DCX



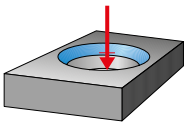
OF..04

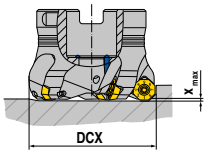
DCX inch	D_{max} inch	D_{min} inch	$\alpha_{R\,max}$ °
1.01	1.77	1.54	2.3
1.21	2.17	1.93	1.9
1.48	2.72	2.48	1.4
1.80	3.35	3.11	1.2
2.19	4.13	3.90	0.9
2.70	5.16	4.92	0.7
3.37	6.50	6.26	0.6
4.16	8.07	7.83	0.5
5.15	10.04	9.80	0.4

SF..09

DCX inch	D_{max} inch	D_{min} inch	$\alpha_{R\,max}$ °
1.08	1.77	1.65	1.9
1.28	2.17	2.05	1.5
1.54	2.72	2.60	1.1
1.87	3.35	3.23	0.9
2.27	4.13	4.02	0.7
2.78	5.16	5.04	0.5
3.44	6.50	6.38	0.4
4.23	8.07	7.95	0.3
5.22	10.04	9.92	0.3

Axial plunging





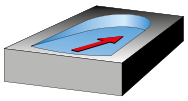
OF..04

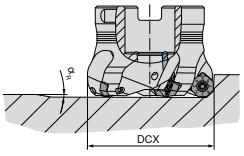
DCX inch	x_{max} inch
1.01	0.10
1.21	0.10
1.48	0.10
1.80	0.10
2.19	0.10
2.70	0.10
3.37	0.10
4.16	0.10
5.15	0.10

SF..09

DCX inch	x_{max} inch
1.08	0.15
1.28	0.14
1.54	0.13
1.87	0.12
2.27	0.12
2.78	0.12
3.44	0.11
4.23	0.11
5.22	0.11

Angled ramping





OF..04

DCX inch	$\alpha_{R\,max}$ °
1.01	14.2
1.21	9.5
1.48	6.5
1.80	4.7
2.19	3.5
2.70	2.7
3.37	2.0
4.16	1.6
5.15	1.2

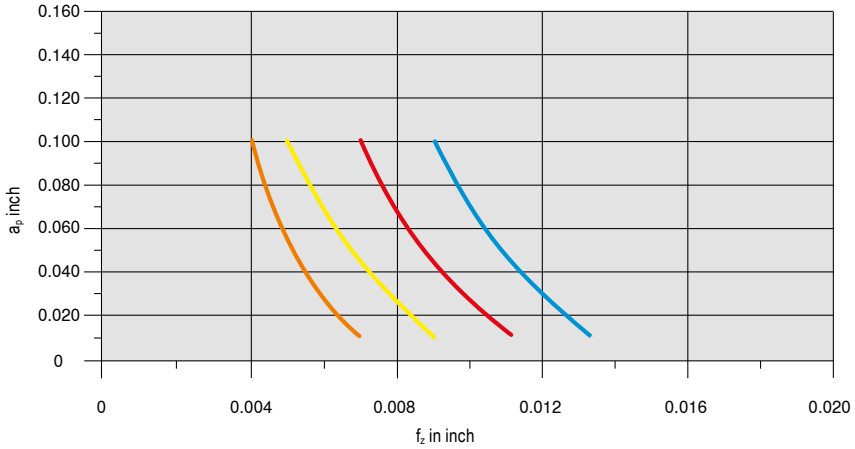
SF..09

DCX inch	$\alpha_{R\,max}$ °
1.08	20.4
1.28	13.0
1.54	8.0
1.87	5.8
2.27	4.3
2.78	3.2
3.44	2.3
4.23	1.7
5.22	1.3

System MaxiMill 274-04

Starting Parameter

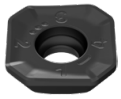
OF.. 04



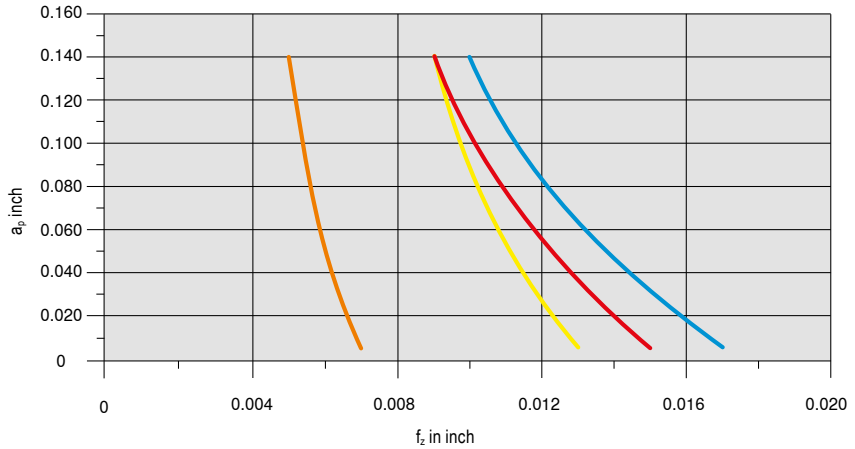
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**OFHT040305SN-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**OFHT040305SN-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**OFHT040305SN-M50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**OFHT040305SN-F50**	**CTC5240**	115	Emulsion

System MaxiMill 274-09

Starting Parameter



SF.. 09



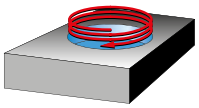
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SFKT0903AFSR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SFHT0903AFSR-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SFKT0903AFSR-R50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**SFHT0903AFSR-F50**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

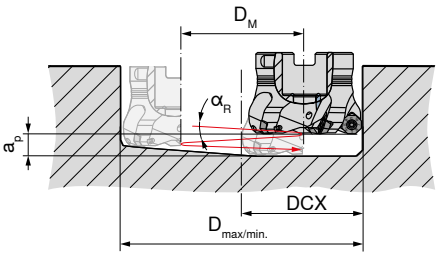
System MaxiMill 274-05/-12

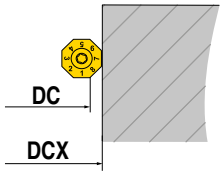
Machining strategy

Helical plunge milling



$D_{max.}$ in inch = largest diameter for flat bottom hole
$D_{min.}$ in inch = smallest hole diameter for flat bottom surface
D_M = D_{max} – DCX and D_{min} – DCX





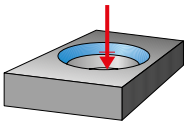
OF..05

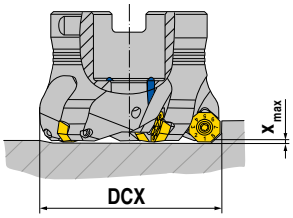
DC inch	DCX inch	D_{max} inch	D_{min} inch	$\alpha_{R\,max}$ °
1.97	**2.28**	4.21	3.90	1.1
2.48	**2.80**	5.24	4.92	0.9
3.15	**3.46**	6.57	6.26	0.7
3.94	**4.25**	8.15	7.83	0.5
4.92	**5.23**	10.12	9.80	0.4

SF..12

DC inch	DCX inch	D_{max} inch	D_{min} inch	$\alpha_{R\,max}$ °
1.85	**2.40**	4.21	4.13	0.5
2.36	**2.91**	5.24	5.16	0.4
3.03	**3.58**	6.57	6.50	0.3
3.81	**4.37**	8.15	8.07	0.25
4.80	**5.35**	10.12	10.04	0.2

Axial plunging





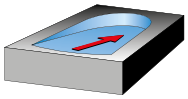
OF..05

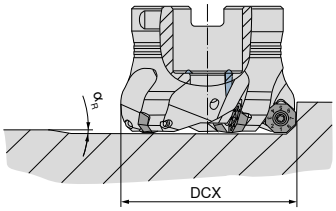
DC inch	DCX inch	X_{max} inch
1.97	**2.28**	0.09
2.48	**2.80**	0.07
3.15	**3.46**	0.07
3.94	**4.25**	0.04
4.92	**5.23**	0.06

SF..12

DC inch	DCX inch	X_{max} inch
1.85	**2.40**	0.13
2.36	**2.91**	0.13
3.03	**3.58**	0.12
3.81	**4.37**	0.10
4.80	**5.35**	0.10

Angled ramping





OF..05

DC inch	DCX inch	$\alpha_{R\,max}$ °
1.97	**2.28**	3.2
2.48	**2.80**	2.0
3.15	**3.46**	1.5
3.94	**4.25**	0.7
4.92	**5.23**	0.7

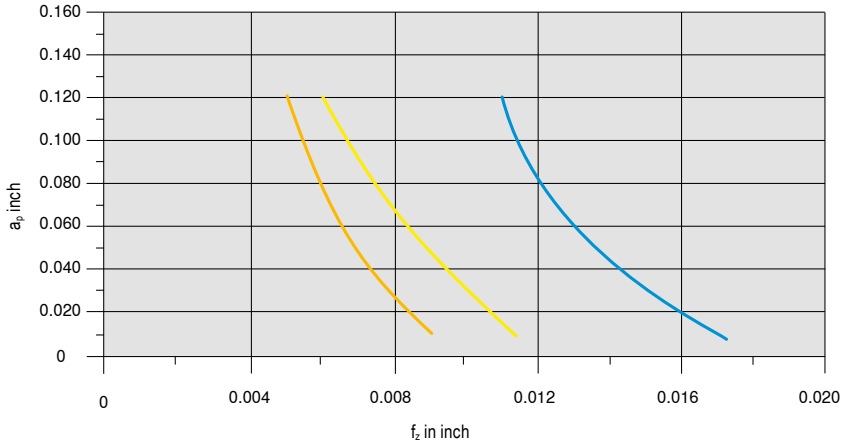
SF..12

DC inch	DCX inch	$\alpha_{R\,max}$ °
1.85	**2.40**	4.9
2.36	**2.91**	3.4
3.03	**3.58**	2.4
3.81	**4.37**	1.6
4.80	**5.35**	1.3

System MaxiMill 274-05

Starting Parameter

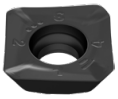
OF.. 05



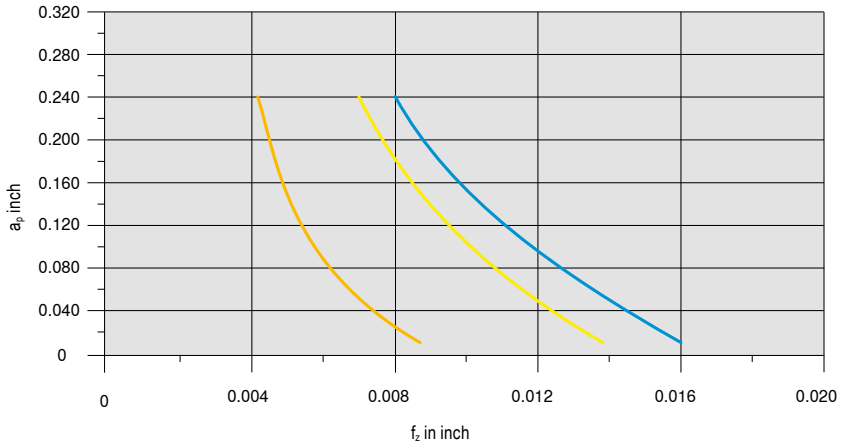
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**OFHT050410SN-M50**	**CTCP230**	660	Dry
Stainless steel	**M.2.1**	316Ti	**OFHT050410SN-F50**	**CTPM240**	320	Emulsion
Heat-resistant	**S.2.2**	Inconel 718	**OFHT050410SN-F50**	**CTC5240**	115	Emulsion

System MaxiMill 274-12

Starting Parameter



SF.. 12

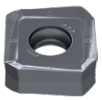


Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SFKT1204AFSR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SFKT1204AFSR-M50**	**CTPM240**	320	Emulsion
Heat-resistant	**S.2.2**	Inconel 718	**SFHT1204AFER-F40**	**CTC5240**	115	Emulsion

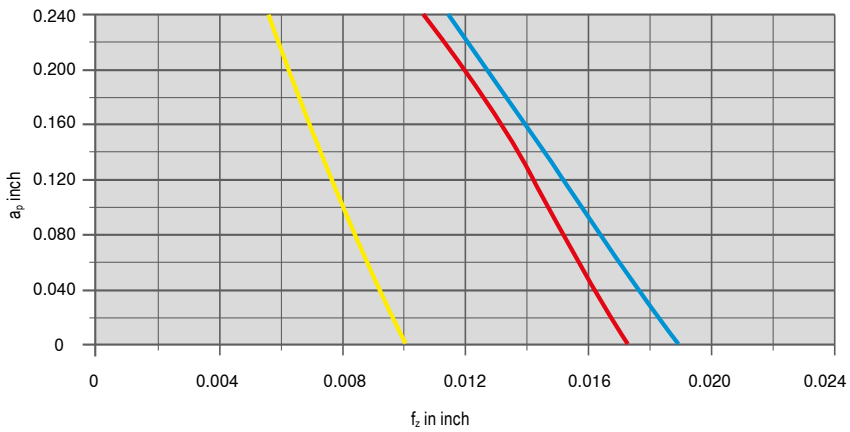
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 271-12

Starting Parameter



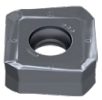
SOHU 12



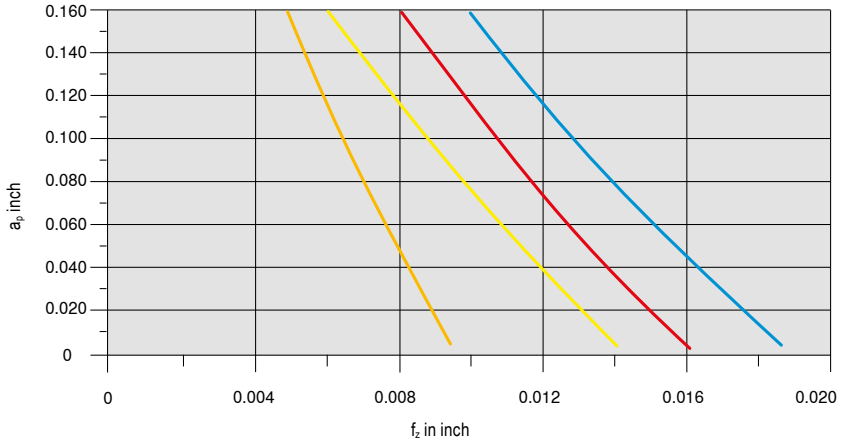
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SOHU 1204ABSR-M50**	**CTPP230**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SOHU 1204ABSR**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SOHU 1204ABSR-R50**	**CTCK215**	990	Dry
Heat-resistant	**S.2.2**	Inconel 718	**SOHU 1204ABSR-F50**	**CTC5240**	115	Emulsion

System MaxiMill 271-17

Starting Parameter



SAKU 17



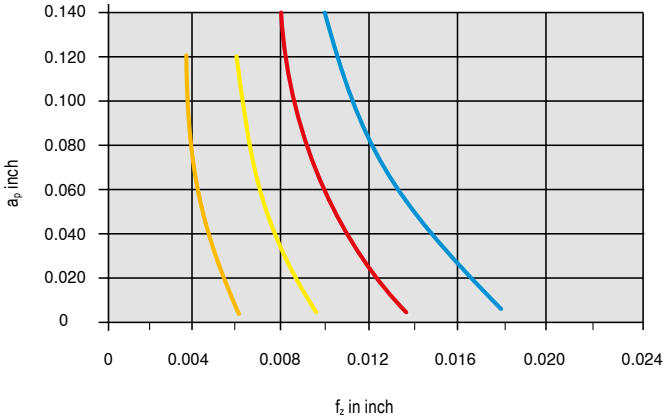
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SAKU 1706ABSR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SAKU 1706ABSR-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SAKU 1706ABSR-R50**	**CTCK215**	990	Dry
Heat-resistant	**S.2.2**	Inconel 718	**SAKU 1706ABSR-F50**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 273

Starting Parameter

OAKU

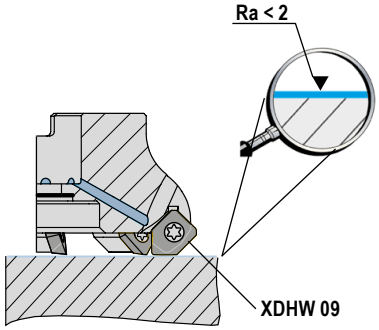


Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**OAKU 060508SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**OAKU 060508SR-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**OAKU 060508SR-R50**	**CTCK215**	990	Dry
Heat-resistant	**S.2.2**	Inconel 718	**OAKU 060508ER-F40**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 270

Machining strategy

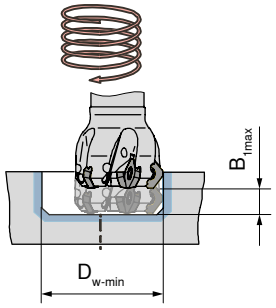


Finish milling with trailing edge inserts

Two wiper inserts are mounted in each 5.000" head

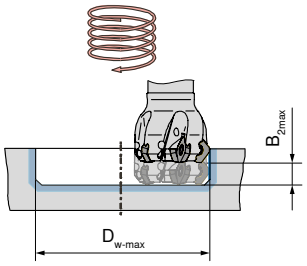

Steel	SDNT	0903AESN-29	CTPP235	+	XDHW	0903AESN CTPP235
	SDNT	0903AESN-29	CTCP230	+	XDHW	0903AESN CTCP230
	SDHT	0903AESN-33	CTCP230	+	XDHW	0903AESN CTCP230
	SDHW	0903AESN	TCM10	+	XDHW	0903AESN TCM10
Cast iron	SDNT	0903AESN-31	CTCK215	+	XDHW	0903AEEN CTCK215
Non-ferrous metals	SDHT	0903AEFN-ALP	-27P H216T	+	XDHW	0903AEFN -27P H216T

Helical plunge milling (without start hole)



C 270-09

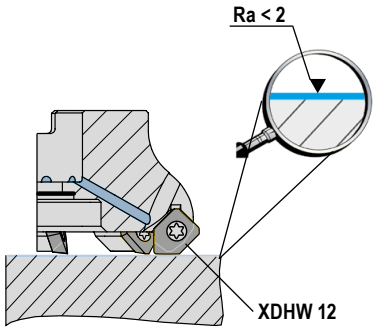
DC inch	$D_{w\text{-}min}$ inch	$B_{1\,max}$ inch	$D_{w\text{-}max}$ inch	$B_{2\,max}$ inch
0.25	0.57	0.06	0.75	0.06
0.50	1.12	0.06	1.22	0.06
0.63	1.44	0.06	1.54	0.06
0.75	1.75	0.06	1.85	0.06
1.00	2.15	0.06	2.24	0.06
1.25	2.70	0.06	2.80	0.06



A 270-09

DC inch	$D_{w\text{-}min}$ inch	$B_{1\,max}$ inch	$D_{w\text{-}max}$ inch	$B_{2\,max}$ inch
1.25	2.70	0.06	2.80	0.06
1.50	3.33	0.06	3.43	0.06
2.00	4.11	0.06	4.21	0.06
2.50	5.14	0.06	5.24	0.06
3.00	6.48	0.06	6.57	0.06
4.00	8.05	0.06	8.15	0.06
5.00	10.02	0.06	10.12	0.06
6.00	12.78	0.06	12.87	0.06

System MaxiMill 270-12

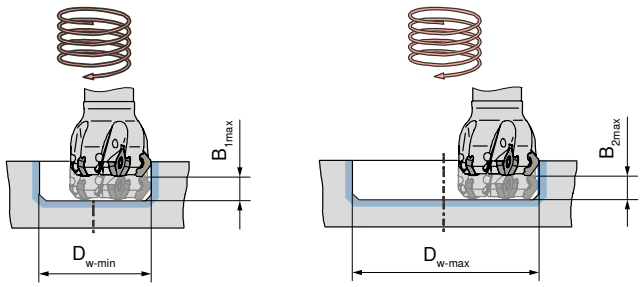


Finish milling with trailing edge inserts

Two wiper inserts are mounted in each 5.000" head


Steel	SDMT	1204AESN-29R	CTPP235	+	XDHW	1204AESN CTPP235
	SDMT	1204AESN-29R	CTCP230	+	XDHW	1204AESN CTCP230
	SDHW	1204AESN-R	TCM10	+	XDHW	1204AESN TCM10
	SDMT	1204AEEN-31	CTCK215	+	XDHW	1204AEEN CTCK215
Cast iron	SDHW	1204AESN-R	CTCK215	+	XDHW	1204AEEN CTCK215
Non-ferrous metals	SDHT	1204AEFN-ALP	-27P H216T	+	XDHW	1204AEFN -27P H216T

Helical plunge milling (without start hole)

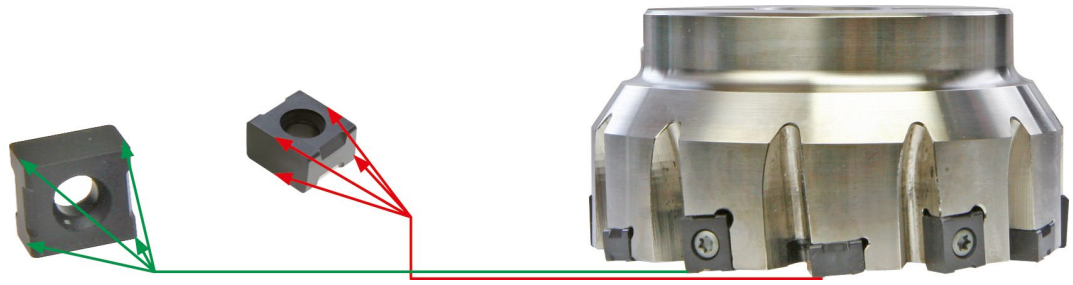


DC inch	$D_{w\text{-}min}$ inch	$B_{1\,max}$ inch	$D_{w\text{-}max}$ inch	$B_{2\,max}$ inch
1.25	2.93	0.06	3.07	0.06
1.50	3.56	0.06	3.70	0.06
2.00	4.35	0.06	4.49	0.06
2.50	5.37	0.06	5.51	0.06
3.00	6.71	0.06	6.85	0.06
4.00	8.29	0.06	8.43	0.06
5.00	10.26	0.06	10.39	0.06
6.00	13.01	0.06	13.15	0.06

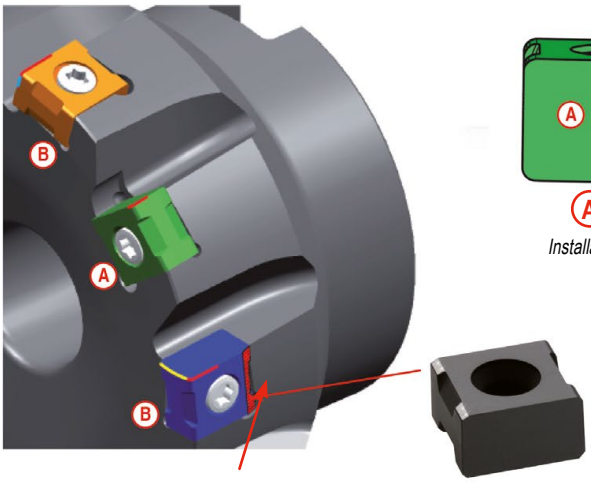
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill HEC 11 / HEC 12

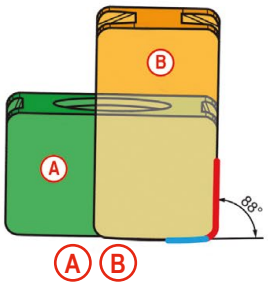
4 cutting edges per installation position



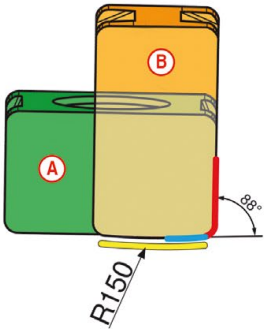
Correct assembly of standard and trailing edge inserts



Marking for the correct assembly



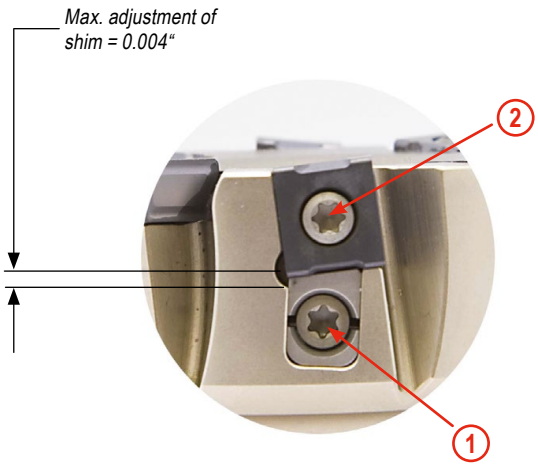
Installation position



Face machining insert — B
Insert main cutting edge — A B
Trailing edge facet — B

Adjust the tools in axial direction

- ▲ Install the wedge into the cutter body and lightly clamp the clamping screw so as not to clamp. — 1
- ▲ Install the inserts as shown and tighten to 1.0 Nm torque. — 2
- ▲ Using pre-setting equipment, mark the highest cutting edge. — 1
- ▲ With small adjustments of the setting screw set all cutting edges to the same height by 0.0002“ or better. — 1
- ▲ Clamp insert with 3.2 Nm torque. — 2



Average chip thickness [h_m] – the approach

Face milling

1 Select appropriate average chip thickness [h_m] for the steel from the table.

Material	Tensile strength N/mm²	h_m inch
for steel	...–800	0.008
for steel	800–1000	0.007
for steel	1000–1200	0.006
for steel	1200–...	0.006
for stainless steel	... –750	0.008
for stainless steel	750–900	0.007
for stainless steel	900–1150	0.007
for stainless steel	1150– ...	0.006

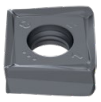
2 Select the corrected feed rate value from the table based on the appropriate chip thickness [h_m] and depth of cut [a_e].

h_m inch	Corrected feed value f_z for h_m			
0.008	0.016 **	0.016 **	0.013	0.011
0.007	0.016 **	0.016 **	0.011	0.010
0.006	0.016 **	0.014	0.010	0.009
0.006	0.014	0.012	0.009	0.008
0.008	0.016 **	0.016 **	0.013	0.012
0.007	0.016 **	0.016 **	0.012	0.011
0.007	0.016 **	0.015	0.011	0.009
0.006	0.015	0.013	0.009	0.008
a_e =	**0.012 x DC**	**0.016 x DC**	**0.030 x DC**	**0.040 x DC**

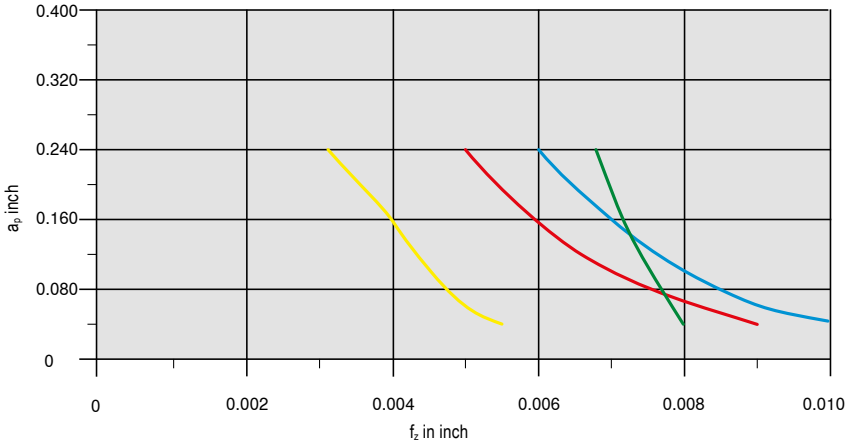
** f_z > 0.016": Danger of an open space contact

System MaxiMill 491-09

Starting Parameter



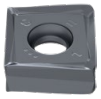
SNHU 09



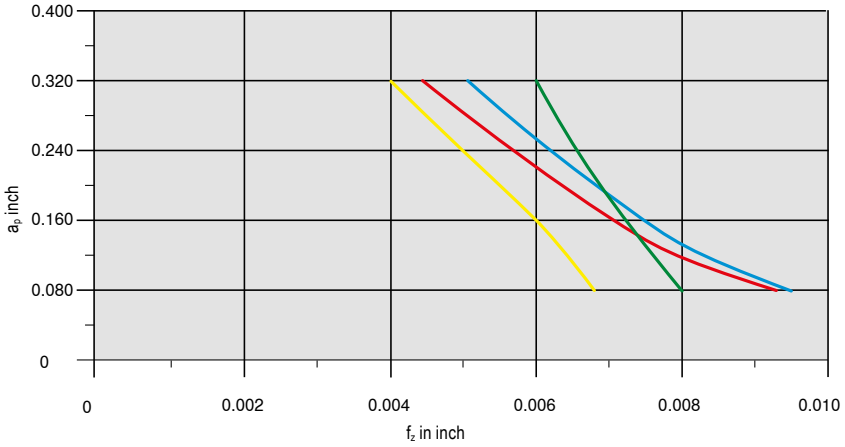
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SNHU09T308SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SNHU09T308SR-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SNHU09T308SR-R50**	**CTCK215**	825	Dry
Non-ferrous metals	**N.1.2**	Aluminum	**SNHU09T308FR-F10**	**CTWN215**	1650	Emulsion

System MaxiMill 491-12

Starting Parameter



SNHU 12



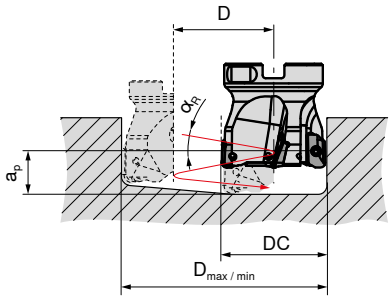
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SNHU120408SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SNHU120408SR-F50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SNHU120408SR-R50**	**CTCK215**	825	Dry
Non-ferrous metals	**N.1.2**	Aluminum	**SNHU120408FR-F10**	**CTC5240**	1650	Emulsion

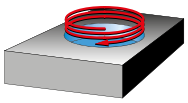
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

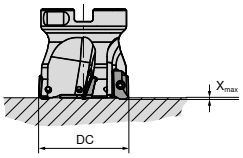
System MaxiMill 211-07

Machining strategy

Helical plunge milling





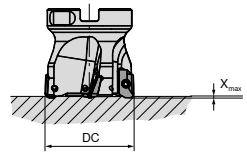


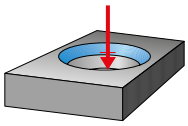
a_p inch = D * π * tan α_R

DC inch	D_{max} / RE 0.4 inch	D_{min} inch	$\alpha_{R\,max}$ °
0.39	0.75	0.51	5.5
0.50	0.91	0.67	6.0
0.63	1.22	0.98	3.0
0.75	1.54	1.30	2.0
1.00	1.93	1.69	1.5
1.25	2.48	2.24	1.2
1.50	3.11	2.87	0.8
2.00	3.90	3.66	0.7

DC inch	D inch	$\alpha_{R\,max\,360°}$ °
0.39	0.51	5.5
0.50	0.67	6.0
0.63	0.98	3.0
0.75	1.30	2.0
1.00	1.69	1.5
1.25	2.24	1.2
1.50	2.87	0.8
2.00	3.66	0.7

Axial plunging

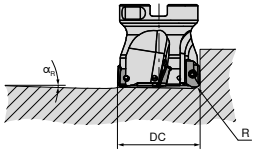


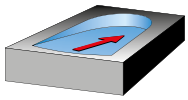


DC inch	X_{max} inch
0.39	0.03
0.50	0.03
0.63	0.03
0.75	0.03
1.00	0.03
1.25	0.03
1.50	0.03
2.00	0.03

$D_{max.}$ in inch = largest diameter for flat bottom hole
$D_{min.}$ in inch = smallest hole diameter for flat bottom surface

Angled ramping

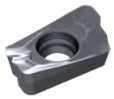




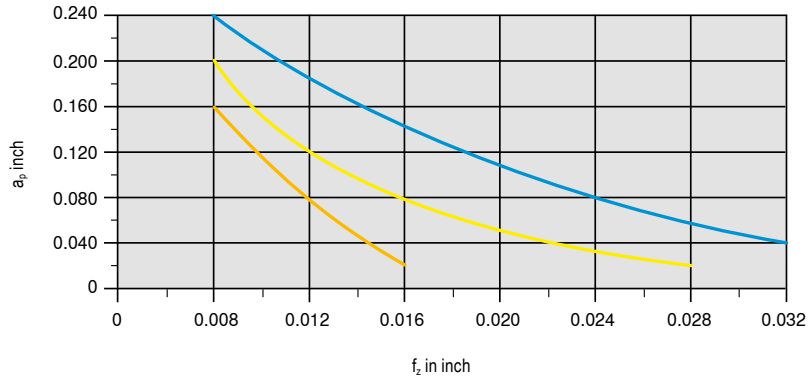
DC inch	α °
0.39	11.0
0.50	7.9
0.63	4.3
0.75	3.0
1.00	2.5
1.25	1.6
1.50	1.2
2.00	1.0

D = D_{max} - DC / D_{min} - DC

Starting Parameter



XDKT 07

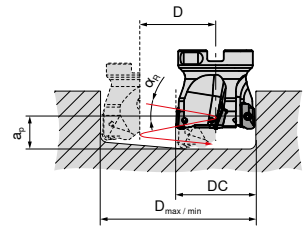


Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XDKT070308SR-M50**	**CTCP230**	660	Dry
Stainless steel	**M.2.1**	316Ti	**XDKT070308SR-F50**	**CTPM240**	320	Emulsion
Heat-resistant	**S.2.2**	Inconel 718	**XDKT070308ER-F50**	**CTC5240**	115	Emulsion

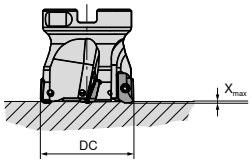
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 211-11

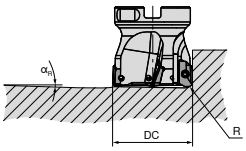
Machining strategy



1 Helical plunge milling



2 Axial plunging



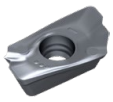
3 Angled ramping

DC inch		1 Helical plunge milling RE = 0.032"	2 Axial plunging X_{max}	3 Angled ramping α_R
0.50	α_R	16 °	0.056“	18 °
	$D_{max.}$	0.83“		
	$D_{min.}$	0.55“		
0.63	α_R	9.5 °	0.060“	10.8 °
	$D_{max.}$	1.14“		
	$D_{min.}$	0.83“		
0.75	α_R	7 °	0.080“	9.8 °
	$D_{max.}$	1.45“		
	$D_{min.}$	1.18“		
1.00	α_R	4.5 °	0.080“	7.5 °
	$D_{max.}$	1.85“		
	$D_{min.}$	1.57“		
1.25	α_R	3.2 °	0.040“	4.8 °
	$D_{max.}$	2.40“		
	$D_{min.}$	2.08“		
1.50	α_R	2.2 °	0.064“	2.9 °
	$D_{max.}$	3.03“		
	$D_{min.}$	2.83“		
2.00	α_R	1.7 °	0.064“	2.2 °
	$D_{max.}$	3.85“		
	$D_{min.}$	3.66“		
2.50	α_R	1.5 °	0.064“	1.8 °
	$D_{max.}$	4.84“		
	$D_{min.}$	4.57“		
3.00	α_R	1.0 °	0.064“	1.4 °
	$D_{max.}$	6.18“		
	$D_{min.}$	6.03“		
4.00	α_R	0.8 °	0.064“	1.1 °
	$D_{max.}$	4.21“		
	$D_{min.}$	3.97“		

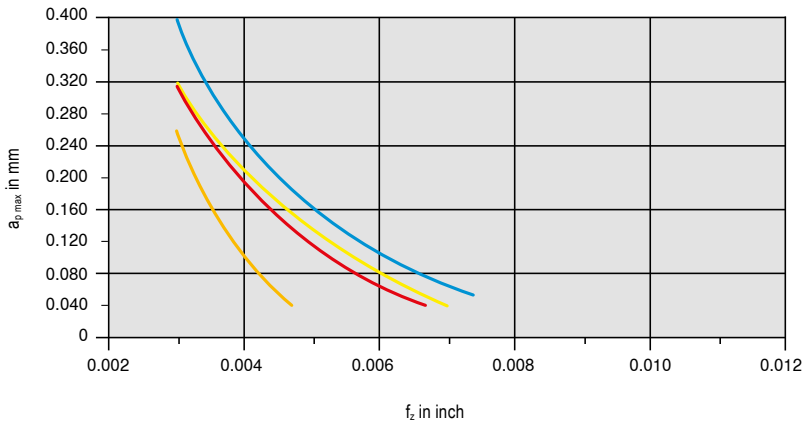
$D_{max.}$ in inch	=	largest diameter for flat bottom hole
$D_{min.}$ in inch	=	Smallest diameter for flat bottom surface
a_p inch	=	D x π x tan (α_R) = Pitch
l_a in mm	=	Overhang length

DC inch	Maximum speed related to projection length n_{max} in min^{-1}				
	l_a = 1–2 x Ø inch	l_a = 2.5 x Ø inch	l_a = 3 x Ø inch	l_a = 4 x Ø inch	l_a = 5 x Ø inch
0.50	55000	51500	47000	42000	37000
0.63	42000	38500	34100	28900	24200
0.75	36900	33000	28500	23900	19500
1.00	33200	29000	24400	19900	15400
1.25	30200	26000	20900	16600	11900
1.50	27700	23000	18000	13500	9000
2.00	25400	20400	15400	10800	6100
2.50	23300	18300	12900	8300	3700
3.00	21300	16100	10600	5800	
4.00	19600	14100	8400		

Starting Parameter



XDKT 11

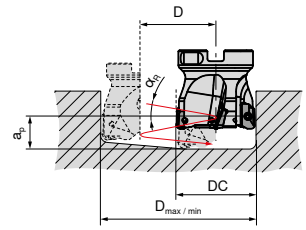


Material			Inserts		v_c in ft/min	Cooling
Steel	P.4.1	P20	XDKT11T308SR-M50	CTCP230	660	Dry
Stainless steel	M.2.1	316Ti	XDKT11T308SR-F50	CTPM240	320	Emulsion
Cast iron	K.1.1	GG25 Cast Iron	XDKT11T308SR-R50	CTCK215	825	Dry
Heat-resistant	S.2.2	Inconel 718	XDKT11T308ER-F50	CTC5240	115	Emulsion

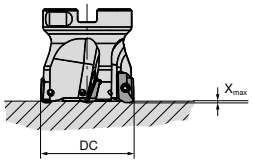
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 211-15

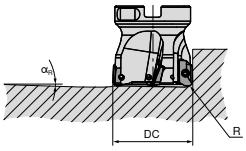
Machining strategy



① Helical plunge milling



② Axial plunging



③ Angled ramping

DC inch		① Helical plunge milling RE = 0.032"	② Axial plunging X_{max}	③ Angled ramping α_R
1.00	α_R	7.5 °		
	$D_{max.}$	1.89"	0.108"	9.5 °
	$D_{min.}$	1.45"		
1.25	α_R	5 °		
	$D_{max.}$	2.44"	0.060"	6.8 °
	$D_{min.}$	1.85"		
1.50	α_R	3.2 °		
	$D_{max.}$	3.07"	0.060"	5.1 °
	$D_{min.}$	2.48"		
2.00	α_R	2.5 °		
	$D_{max.}$	3.86"	0.060"	2.5 °
	$D_{min.}$	3.38"		
2.50	α_R	1.5 °		
	$D_{max.}$	4.88"	0.060"	2.5 °
	$D_{min.}$	4.37"		
3.00	α_R	1.3 °		
	$D_{max.}$	6.22"	0.060"	2.0 °
	$D_{min.}$	5.78"		
4.00	α_R	1.1 °		
	$D_{max.}$	7.80"	0.060"	1.5 °
	$D_{min.}$	7.48"		
5.00	α_R	0.9 °		
	$D_{max.}$	9.76"	0.060"	0.9 °
	$D_{min.}$	9.45"		
6.00	α_R	0.6 °		
	$D_{max.}$	12.52"	0.060"	0.7 °
	$D_{min.}$	12.20"		

Maximum speed related to projection length n_{max} in min^{-1}			
DC inch	l_a = 2 x Ø inch	l_a = 3 x Ø inch	l_a = 5 x Ø inch
1.00	26560	19520	13320
1.25	24160	16720	9520
1.50	22160	14400	7200
2.00	20320	12320	4880
2.50	18640	10320	2960
3.00	17040	8480	
4.00	15680	6720	
5.00	14320		
6.00	13200		

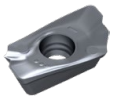
$D_{max.}$ in inch = largest diameter for flat bottom hole

$D_{min.}$ in inch = Smallest diameter for flat bottom surface

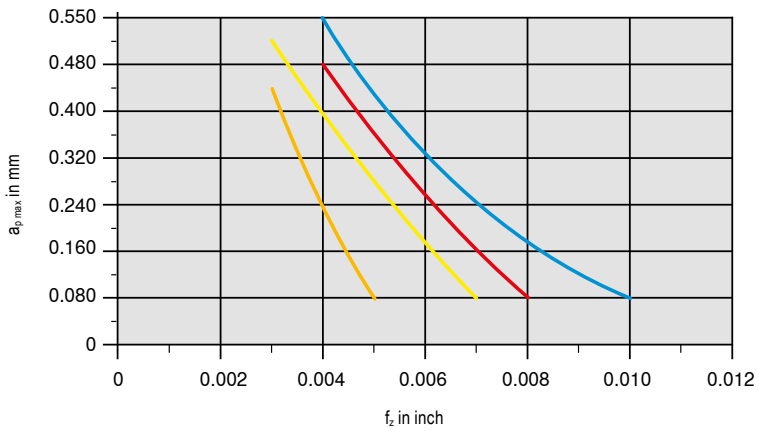
a_p inch = D x π x tan (α_R) = Pitch

l_a in mm = Overhang length

Starting Parameter



XDKT 15



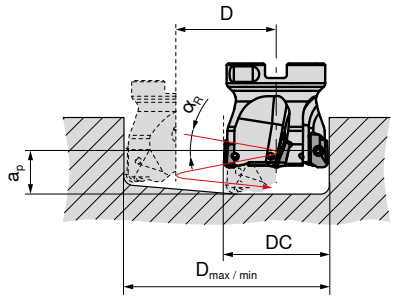
Material			Inserts		v_c in ft/min	Cooling
Steel	P.4.1	P20	XDKT150508SR-M50	CTCP230	660	Dry
Stainless steel	M.2.1	316Ti	XDKT150508SR-F50	CTPM240	320	Emulsion
Cast iron	K.1.1	GG25 Cast Iron	XDKT150508SR-R50	CTCK215	825	Dry
Heat-resistant	S.2.2	Inconel 718	XDKT150508ER-F40	CTC5240	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

System MaxiMill 211-20

Machining strategy

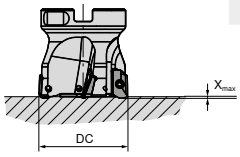
Helical plunge milling



DC inch	D_{max} / RE 0.016 inch	D_{min} inch	$\alpha_{R\,max}$ °
2.50	4.882	4.213	2.2
3.00	6.220	5.630	1.7
4.00	7.795	7.205	1.3

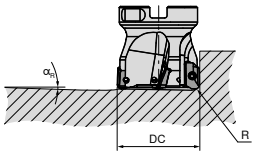
a_p inch $= D * \pi * \tan \alpha_R$

Axial plunging



DC inch	X_{max} inch
2.50	0.80
3.00	0.80
4.00	0.80

Angled ramping

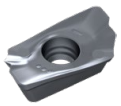


DC inch	α °
2.50	2.2
3.00	1.7
4.00	1.3

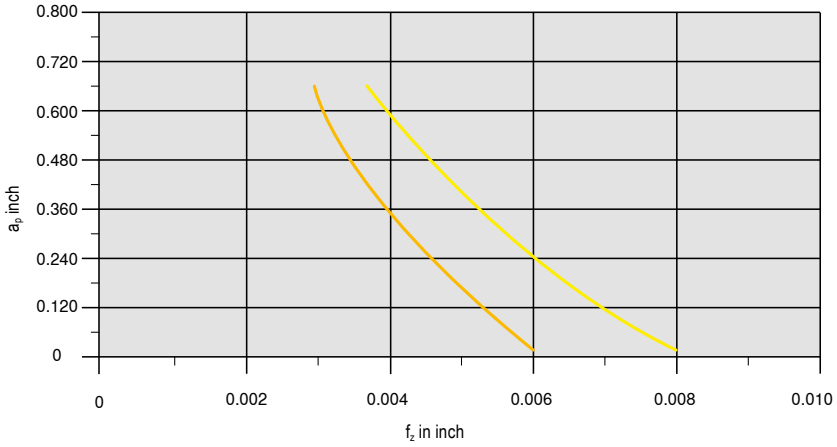
$D = D_{max} - DC / D_{min} - DC$

$D_{max.}$ in inch = largest diameter for flat bottom hole
$D_{min.}$ in inch = smallest hole diameter for flat bottom surface

Starting Parameter



XDKT 20



Material			Inserts		v_c in ft/min	Cooling
Stainless steel	**M.2.1**	316Ti	**XDKT200708ER-F40**	**CTPM240**	320	Emulsion
Heat-resistant	**S.2.2**	Inconel 718	**XDKT200708ER-F40**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

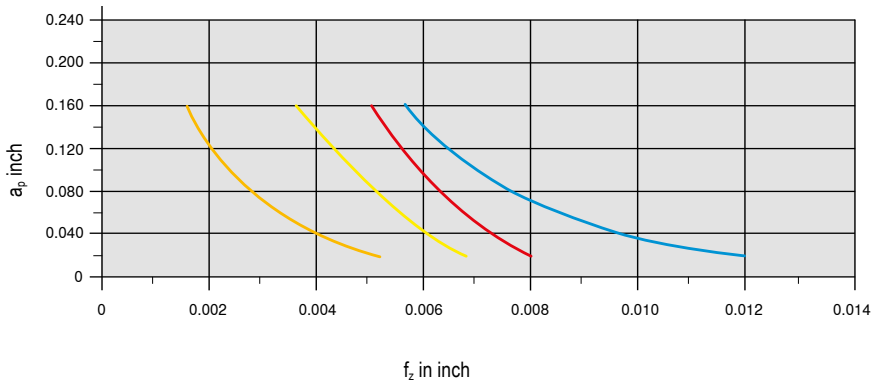
System MaxiMill 490-09

Machining strategy

System MaxiMill 490-09 is not suitable for plunging!

Starting Parameter

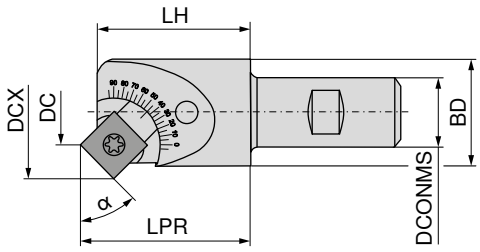
SDNT 09



Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SDNT09T308SR-29**	**CTCP230**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SDNT09T308SR-33**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SDNT09T308SR-31**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**SDNT09T308ER-M31**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.

MaxiMill 490-09 adjustable angle milling cutter – dimensions



Constant dimensions			Angle-dependent dimensions*			
BD	DCONMS	LH	α	DC*	DCX	LPR*
18.6	16	32	**0°**	**9.35/1.60****	**20.14**	**33.07**
			5°	3.81	20.82	33.40
			10°	4.59	21.44	33.69
			15°	**5.42**	**21.98**	**33.95**
			20°	6.30	22.45	34.17
			25°	7.23	22.85	34.35
			30°	**8.18**	**23.16**	**34.49**
			35°	9.15	23.39	34.58
			40°	10.14	23.53	34.64
			45°	**11.13**	**23.59**	**34.65**
			50°	12.12	23.56	34.61
			55°	13.09	23.44	34.54
			60°	**14.04**	**23.24**	**34.42**
			65°	14.96	22.96	34.26
			70°	15.84	22.60	34.06
			75°	**16.68**	**22.16**	**33.83**
			80°	17.46	21.65	33.56
			85°	18.19	21.07	33.25
			90°	**10.07/1.90****	**20.44**	**32.93**

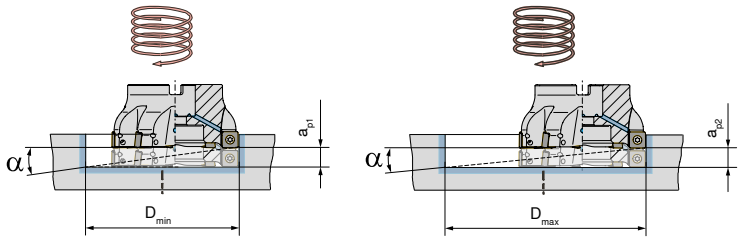
* Tangential cutting point at deepest engagement point

** Smallest diameter in centre

System MaxiMill 490-12

Machining strategy

Helical plunging (without pilot hole)



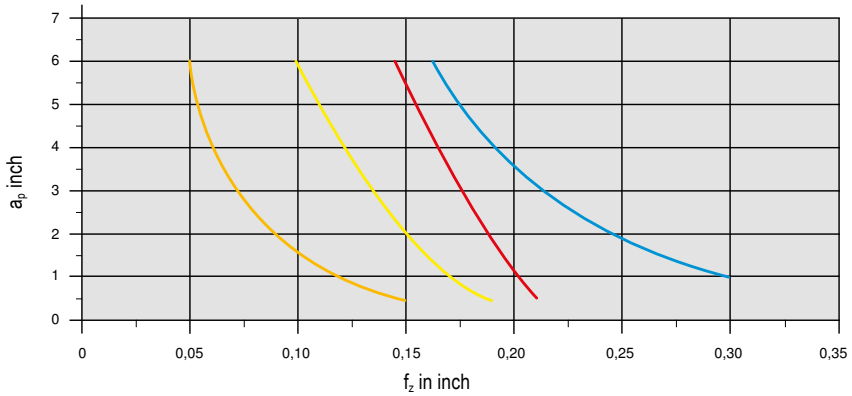
$$B = (D_W - DC) \times \pi \times \tan \alpha$$

DC inch	$D_{w\text{-}min}$ inch	$B_{1\,max}$ inch	$D_{w\text{-}max}$ inch	$B_{2\,max}$ inch	α °
2.00	3.031	0.098	3.858	0.189	2.0

D_w = Diameter of the hole to be produced
DC = Nominal diameter of the milling tool
B = Axial feed to 360° circular movement

Starting Parameter

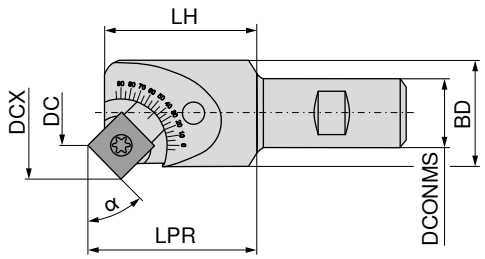
SDMT 12



Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**SDMT1205ZZSN-29**	**CTCP230**	660	Dry
Stainless steel	**M.2.1**	316Ti	**SDMT120512SR-33**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**SDMT1205ZZSN-31**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**SDMT120508ER-M31**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.

MaxiMill 490-12 adjustable angle milling cutter – dimensions



Constant dimensions			Angle-dependent dimensions*			
BD	DCONMS	LH	α	DC*	DCX	LPR*
25	20	37	**0°**	**25.07/1.12****	**26.64**	**38.36**
			5°	3.72	27.61	38.79
			10°	4.84	28.48	39.21
			15°	**6.03**	**29.25**	**39.58**
			20°	7.27	29.92	39.90
			25°	8.57	30.48	40.16
			30°	**9.91**	**30.92**	**40.37**
			35°	11.28	31.25	40.51
			40°	12.67	31.45	40.60
			45°	**14.08**	**31.54**	**40.62**
			50°	15.48	31.50	40.58
			55°	16.86	31.34	40.48
			60°	**18.23**	**31.06**	**40.33**
			65°	19.56	30.66	40.11
			70°	20.85	30.15	39.83
			75°	**22.08**	**29.52**	**39.51**
			80°	23.26	28.79	39.12
			85°	24.35	27.95	38.69
			90°	**25.37/1.42****	**26.94**	**38.21**

* Tangential cutting point at deepest engagement point
** Smallest diameter in centre

HSC/HPC machining

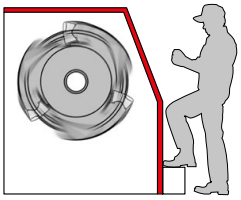
Safety advice

Suitability of the tool for HSC machining

HSC tools from CERATIZIT have been specially developed for this machining strategy and guarantee maximum operational reliability.

Observation of safety precautions of the machine manufacturer

Make sure that all safety precautions of the machine-manufacturer are observed (e.g.: closed machine guards).

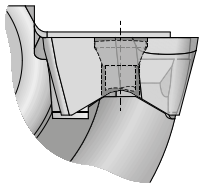


Suitability of the adapters for HSC machining

According to the milling situation, choose the optimum tool/clamping device combination. For high speed milling applications it is necessary to dynamically balance tool and tool adapter together (see ISO 1940 directives).

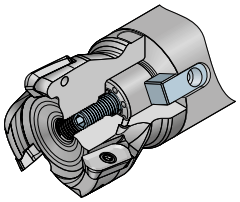
Mounting the indexable insert with centrifugal force protection

Insert clamping: EURO-patent EP 1083017A1
Make sure that the insert pocket is cleaned and the threading bore for the clamping screw is in good condition.
Check the axial and radial contact points of the insert in the pocket.
The clamping screws for positive insert clamping must be tightened with a torque of (XDHT11 = 1.8 Nm; XDH.19 = 6.0 Nm).



Optimum mounting of HSC milling cutters (DC = Ø 40–63) to milling arbors using power screw

The power screw guarantees a stable connection of tool and milling adapter and is easy to use.



Power Screw

Maximum admissible number of revolutions

Please note the maximum number of revolutions stated on the tool. This number is exclusively valid for the specific tool and must be adapted according to the selected tool adapter, total overhang length and the respective machining situation.

Optimum application range of the tool (a_e, a_p, f_z, n)

In order to guarantee productive milling, please observe the recommendations regarding the cutting parameters.

Failure to comply with these safety regulations automatically excludes CERATIZIT from any liability

System MaxiMill HSC-11

Cutting data standard values

	Workpiece material	Treatment / alloy		VDI 3323 Group	Hardness HB	H216T (CTWN215) v_c in ft/min	H216T (CTWN215) v_c in ft/min
N	Aluminum alloys	non hardenable		21	60		660–9840
		hardenable		22	100		660–6560
	Cast aluminum alloy	non hardenable	< 12% Si	23	80		660–6560
		hardenable	< 12% Si	24	90		660–5900
		non hardenable	> 12% Si	25	130		660–3280
	Copper and copper alloys (Bronze, Brass)		Free-cutting steel alloy (1% Pb)	26			660–1970
			brass, red bronze	27	90	820–3280	820–3280
			bronze	28	100		490–1310
			lead-free copper and electrolytic copper	29	100		980–2620
O	Non metal materials		Duroplastics	29		260–3280	260–3280
			Fibre-reinforced plastics	29		230–1640	230–1640
			hard rubber	30		260–1000	260–1000

= full lubricant = Minimum quantity lubrication = dry machining

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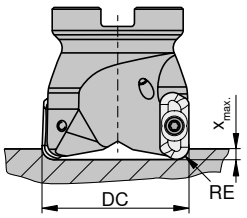
System MaxiMill HSC-11

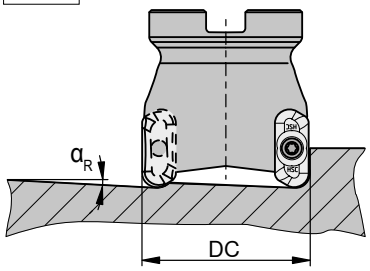
Machining strategy

Axial ramping



DC inch	11 RE 0.008–0.157 $x_{max.}$ inch
0.63	0.07
0.75	0.09
1.00	0.10
1.25	0.09
1.50	0.09
2.00	0.09
2.50	0.08
3.00	0.07
4.00	0.07
63	2.10
80	1.75
100	1.79

Linear ramping



DC inch	α_R °
0.63	18.8
0.75	15.3
1.00	10.3
1.25	6.8
1.50	4.8
2.00	3.5
2.50	2.5
3.00	1.8
4.00	1.3
63	2.5
80	1.8
100	1.3

Milling strategy for roughing and finishing

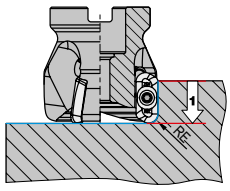
With maximum chip volume

Indexable Insert	RE inch	a_p inch	$a_{p\,max.}$ inch
XDHT 11T302FR-ALP	0.008	0.39	0.39
XDHT 11T304FR-ALP	0.016	0.39	0.38
XDHT 11T308FR-ALP	0.031	0.39	0.36
XDHT 11T312FR-ALP	0.047	0.39	0.35
XDHT 11T316FR-ALP	0.063	0.39	0.33
XDHT 11T320FR-ALP	0.079	0.39	0.31
XDHT 11T325FR-ALP	0.098	0.39	0.30
XDHT 11T332FR-ALP	0.126	0.39	0.27
XDHT 11T340FR-ALP	0.157	0.39	0.24
XDHT 11T350FR-ALP	0.197	0.39	0.20

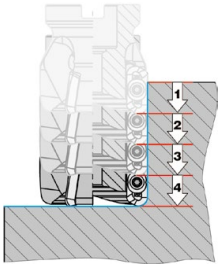
With maximum side wall quality

Indexable Insert	RE inch	$a_{p\,max.}$ inch
XDHT 11T302FR-ALP	0.008	0.31
XDHT 11T304FR-ALP	0.016	0.30
XDHT 11T308FR-ALP	0.031	0.28
XDHT 11T312FR-ALP	0.047	0.26
XDHT 11T316FR-ALP	0.063	0.27
XDHT 11T320FR-ALP	0.079	0.25
XDHT 11T325FR-ALP	0.098	0.22
XDHT 11T332FR-ALP	0.126	0.19
XDHT 11T340FR-ALP	0.157	0.16
XDHT 11T350FR-ALP	0.197	0.12

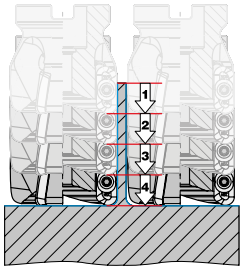
Shoulder milling



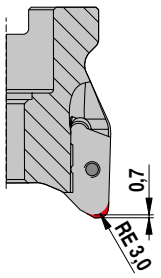
Pocket milling

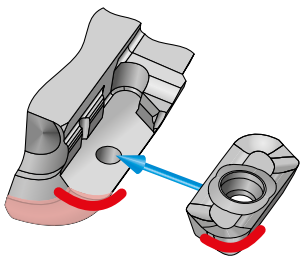


Pocket milling with thin walled components



Modification to front profile



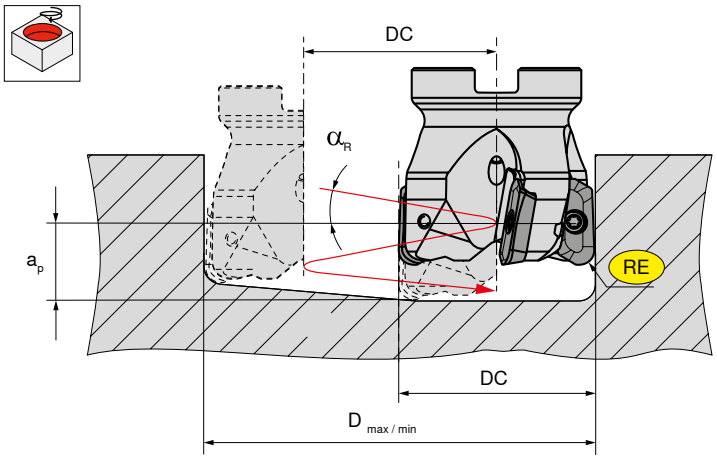


For inserts with a corner radius larger than 0.125" the basic body of the tool must be modified according to the drawing above.

System MaxiMill HSC-11

Machining strategy

Helical plunging



RE = Insert radius
α_R iinch = Maximum ramping angle (related to centre of tool)

a_p inch = pitch → D x π x tan (α_R)

D in inch = → D_{max} – DC and/or D_{min} – DC

For flat bottom hole

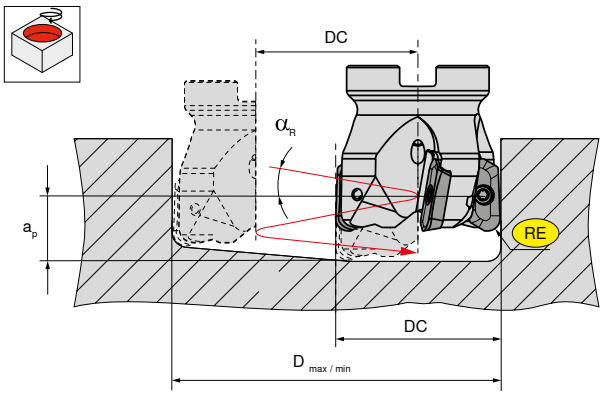
$D_{max.}$ in inch = largest drilling diameter
$D_{min.}$ in inch = smallest drilling diameter
$DN_{max.}$ inch = Maximum hole diameter for non flat bottom

DC inch		XDHT-11 (HSC-11)								
(DN_{max})		RE = 0.008	RE = 0.016	RE = 0.032	RE = 0.048	RE = 0.064	RE = 0.080	RE = 0.100	RE = 0.125	RE = 0.160
	α_R	9.7°	10.0°	9.9°	9.4°	8.9°	8.4°	7.9°	7.0°	6.1°
	$D_{max.}$	1.18	1.18	1.14	1.1	1.06	1.06	1.02	0.94	0.91
(1.22)	$D_{min.}$	0.71	0.71	0.71	0.71	0.71	0.71	0.71	0.71	0.71
.708	α_R	9.4°	9.1°	8.7°	8.3°	7.9°	7.5°	6.9°	6.2°	5.3°
	$D_{max.}$	1.34	1.34	1.3	1.26	1.22	1.22	1.18	1.1	1.06
(1.38)	$D_{min.}$	0.87	0.87	0.87	0.87	0.87	0.87	0.87	0.87	0.87
.750	α_R	8.8°	8.6°	8.3°	7.9°	7.5°	7.5°	6.5°	5.9°	5.1°
	$D_{max.}$	1.42	1.42	1.38	1.34	1.3	1.3	1.26	1.18	1.14
(1.45)	$D_{min.}$	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95
.787	α_R	8.4°	8.2°	7.8°	7.4°	7.7°	6.7°	6.2°	5.5°	4.8°
	$D_{max.}$	1.5	1.5	1.46	1.42	1.38	1.38	1.34	1.26	1.22
(1.53)	$D_{min.}$	1.02	1.02	1.02	1.02	1.02	1.02	1.02	1.02	1.02
.866	α_R	7.6°	1.65	7.4°	1.65	7.8°	1.61	6.7°	1.57	6.4°
	$D_{max.}$	1.65	1.65	1.61	1.57	1.53	1.53	1.49	1.41	1.37
(1.69)	$D_{min.}$	1.18	1.18	1.18	1.18	1.18	1.18	1.18	1.18	1.18
1.00	α_R	6.7°	6.5°	6.2°	5.9°	5.6°	5.3°	4.9°	4.4°	3.8°
	$D_{max.}$	1.89	1.89	1.85	1.81	1.77	1.77	1.73	1.65	1.61
(1.93)	$D_{min.}$	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42
1.25	α_R	4.7°	2.44	4.7°	2.44	4.8°	2.40	4.6°	2.36	4.3°
	$D_{max.}$	2.44	2.44	2.4	2.36	2.32	2.32	2.28	2.2	2.17
(2.48)	$D_{min.}$	1.97	1.97	1.97	1.97	1.97	1.97	1.97	1.97	1.97
1.50	α_R	3.3°	3.3°	3.4°	3.4°	3.5°	3.3°	3.0°	2.7°	2.3°
	$D_{max.}$	3.07	3.07	3.03	2.99	2.95	2.95	2.91	2.83	2.8
(3.11)	$D_{min.}$	2.59	2.59	2.59	2.59	2.59	2.59	2.59	2.59	2.59
2.00	α_R	2.4°	3.86	2.5°	3.86	2.5°	3.82	2.5°	3.78	2.6°
	$D_{max.}$	3.86	3.86	3.82	3.78	3.74	3.74	3.7	3.62	3.58
(3.89)	$D_{min.}$	3.38	3.38	3.38	3.38	3.38	3.38	3.38	3.38	3.38
2.50	α_R	1.7°	1.7°	1.7°	1.8°	1.8°	1.8°	1.8°	1.7°	1.5°
	$D_{max.}$	4.88	4.88	4.84	4.8	4.76	4.76	4.72	4.65	4.61
(4.92)	$D_{min.}$	4.41	4.41	4.41	4.41	4.41	4.41	4.41	4.41	4.41
3.00	α_R	1.1°	1.1°	1.1°	1.1°	1.1°	1.1°	1.1°	1.2°	1.2°
	$D_{max.}$	6.22	6.22	6.18	6.14	6.1	6.1	6.06	5.98	5.94
(6.25)	$D_{min.}$	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75	5.75
4.00	α_R	0.8°	0.8°	0.9°	0.9°	0.9°	0.9°	0.9°	0.9°	0.9°
	D_{max}	7.8	7.8	7.76	7.72	7.68	7.68	7.64	7.56	7.52
(7.83)	$D_{min.}$	7.32	7.32	7.32	7.32	7.32	7.32	7.32	7.32	7.32

System MaxiMill HSC/HPC-19

Machining strategy

Helical plunging



RE = Insert radius
α_R iinch = Maximum ramping angle (related to centre of tool)

a_p inch = pitch → D x π x tan (α_R)

D in inch = → D_{max} – DC and/or D_{min} – DC

For flat bottom hole

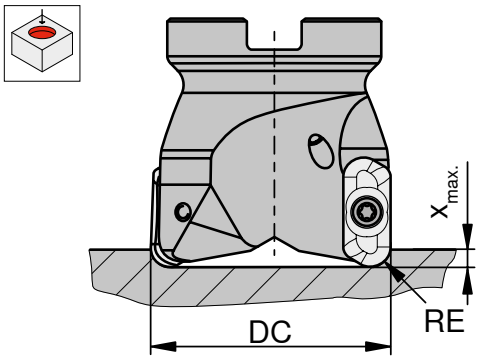
$D_{max.}$ in inch = largest drilling diameter
$D_{min.}$ in inch = smallest drilling diameter
$DN_{max.}$ inch = Maximum hole diameter for non flat bottom

	DC inch	DN_{max} inch	α_R °	D_{max} inch	D_{min} inch
RE = 0.008“	**1.00**	1.93	7°02‘	1.89	1.26
	1.25	2.48	4°34‘	2.44	1.81
	1.50	3.11	3°47‘	3.07	2.44
	2.00	3.90	3°01‘	3.82	3.19
	2.50	4.92	2°17‘	4.88	4.21
	3.00	6.26		6.22	5.55
	4.00	7.83		7.80	7.13
RE = 0.016“	**1.00**	0.98	7°08‘	1.89	1.26
	1.25	1.26	4°37‘	2.44	1.81
	1.50	1.57	3°49‘	3.07	2.44
	2.00	1.97	3°02‘	3.86	3.19
	2.50	2.48	2°18‘	4.88	4.21
	3.00	3.15		6.22	5.55
	4.00	3.94		7.80	7.13
RE = 0.032“	**1.00**	1.93	7°21‘	1.85	1.26
	1.25	2.48	4°44‘	2.40	1.81
	1.50	3.11	3°53‘	3.03	2.44
	2.00	3.90	3°05‘	3.82	3.19
	2.50	4.92	2°20‘	4.84	4.21
	3.00	6.26		6.18	5.55
	4.00	7.83		7.76	7.13
RE = 0.078“	**1.00**	0.98	8°40‘	1.77	1.26
	1.25	1.26	5°04‘	2.32	1.81
	1.50	1.57	4°06‘	2.95	2.44
	2.00	1.97	3°13‘	3.74	3.19
	2.50	2.48	2°25‘	4.76	4.21
	3.00	3.15		6.10	5.55
	4.00	3.94		7.68	7.13
RE = 0.098“	**1.00**	1.93	8°24‘	1.73	1.26
	1.25	2.48	5°13‘	2.28	1.81
	1.50	3.11	4°12‘	2.91	2.44
	2.00	3.90	3°17‘	3.70	3.19
	2.50	4.92	2°27‘	4.72	4.21
	3.00	6.26		6.06	5.55
	4.00	7.83		7.64	7.13
RE = 0.128“	**1.00**	0.98	8°54‘	1.65	1.26
	1.25	1.26	5°26‘	2.20	1.81
	1.50	1.57	4°20‘	2.83	2.44
	2.00	1.97	3°21‘	3.62	3.19
	2.50	2.48	2°30‘	4.65	4.21
	3.00	3.15		5.98	5.55
	4.00	3.94		7.56	7.13
RE = 0.157“	**1.00**	1.93	9°32‘	1.61	1.26
	1.25	2.48	5°42‘	2.17	1.81
	1.50	3.11	4°30‘	2.80	2.44
	2.00	3.90	3°28‘	3.58	3.19
	2.50	4.92	2°33‘	4.61	4.21
	3.00	6.26		5.94	5.55
	4.00	7.83		7.52	7.13
RE = 0.196“	**1.00**	0.98	6°49‘	1.54	1.26
	1.25	1.26	3°59‘	2.09	1.81
	1.50	1.57	3°20‘	2.72	2.44
	2.00	1.97	2°13‘	3.50	3.19
	2.50	2.48	1°52‘	4.53	4.21
	3.00	3.15		5.87	5.55
	4.00	3.94		7.44	7.13

System MaxiMill HSC/HPC-19

Machining strategy

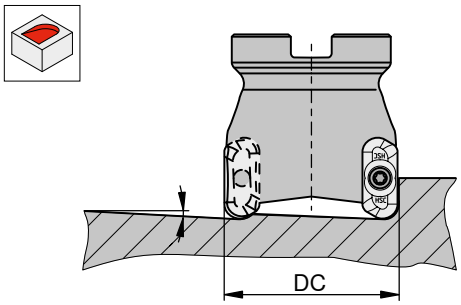
Axial ramping



HSC 19	DC mm	19 RE 0.008–0.157 $x_{max.}$ mm	19 RE 0.196 $x_{max.}$ mm
CHSC 19 / GHSC 19 / MHSC 19	1.00	0.196	0.157
CHSC 19 / GHSC 19 / MHSC 19	1.25–1.50	0.157	0.118
AHSC 19	1.50–4.00	0.157	0.118

HPC 19	DC mm	19 RE 0.008–0.157 $x_{max.}$ mm	19 RE 0.196 $x_{max.}$ mm
CHPC 19 / MHPC 19	1.00	0.196	0.157
CHPC 19 / MHPC 19	1.25–1.50	0.236	0.196
AHPC 19	1.50–2.50	0.236	0.196

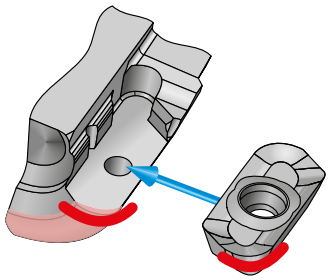
Linear ramping

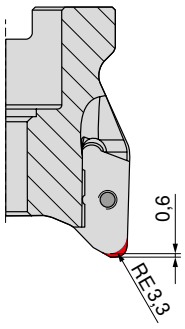


DC mm	α ideal HSC 19	HPC 19
1.00	11°	11°
1.25	7°	7°
1.50	5°	5°
2.00	4°	4°
2.50	3°	3°
3.00	2°	
4.00	2°	

Modification to basic body

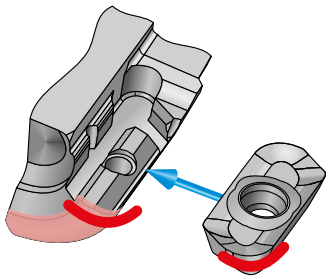
HSC 19





Modification to front profile

HPC 19

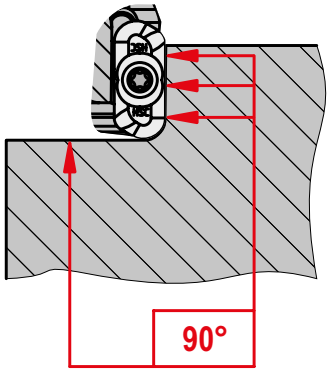


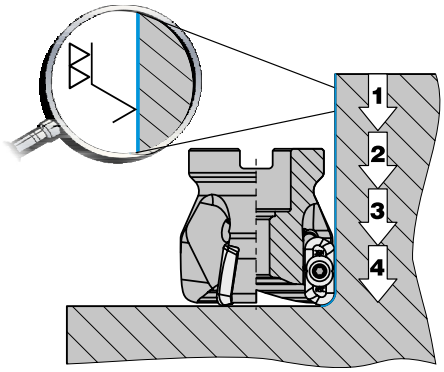
For inserts with a corner radius larger than 4.0 mm the basic body of the tool must be modified according to the drawing above.

System MaxiMill HSC/HPC-19

Machining strategy

Excellent side wall quality after roughing operation.
Additional finishing operations minimized or no longer required.





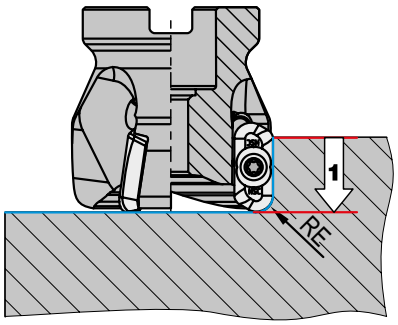
With maximum chip volume

Indexable Insert	RE inch	a_p inch	$a_{p\,max.}$ inch
XDH. 190402FR-ALP	0.008	0.71	0.70
XDH. 190404FR-ALP	0.016	0.71	0.69
XDH. 190408FR-ALP	0.032	0.71	0.68
XDH. 190420FR-ALP	0.078	0.71	0.63
XDH. 190425FR-ALP	0.098	0.71	0.59
XDH. 190432FR-ALP	0.128	0.71	0.58
XDH. 190440FR-ALP	0.157	0.71	0.55
XDH. 190450FR-ALP	0.196	0.67	0.51

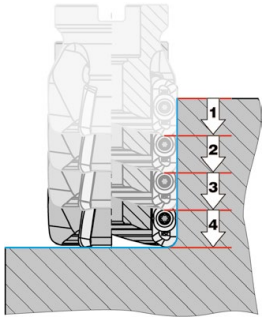
With maximum side wall quality

Indexable Insert	RE inch	$a_{p\,max.}$ inch
XDH. 190402FR-ALP	0.008	0.46
XDH. 190404FR-ALP	0.016	0.46
XDH. 190408FR-ALP	0.032	0.44
XDH. 190420FR-ALP	0.078	0.39
XDH. 190425FR-ALP	0.098	0.37
XDH. 190432FR-ALP	0.128	0.35
XDH. 190440FR-ALP	0.157	0.31
XDH. 190450FR-ALP	0.196	0.28

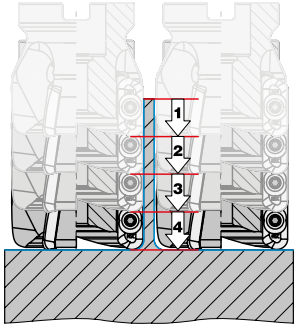
Shoulder milling



Pocket milling



Pocket milling with
thin walled components



This information applies to the inserts type XDHT 19 and XDHX 19.

System MaxiMill HPC-04/12

Machining strategy

What do you have to take into account?

- ▲ Machine stability.
- ▲ Stable work piece clamping and tool adapter.
- ▲ Use of coolant generally not necessary, however, this will facilitate the removal of the chips - also improved surface quality.
- ▲ Take into account thermal stress and critical temperature of 600°C! If required for material, work with coolant.
- ▲ Avoid vibration.
- ▲ Observe balancing quality class.
- ▲ Observe chemical reactions of diamond to carbide forming elements (Fe, Ti, Ta, Co, Ni)

Excellent suitability

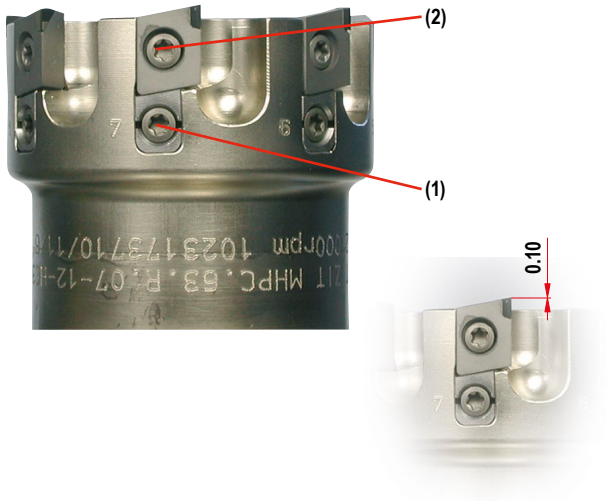
- ▲ for components made of light metals and non-ferrous metals, plastic, fibre composite materials, graphite ...
- ▲ when the simplest setting method saves cost for tool presetting.
- ▲ for high-volume production.
- ▲ for high surface quality of the work pieces.
- ▲ when long tool life is necessary to reduce tool changes and expensive machine downtime.
- ▲ when the tool is already on site (presetting, etc.)

Quality class check

After assembly, clamping of the inserts and adjustment of the axial run-out the balancing quality class of the tools should be checked. When applying shell milling cutters, after assembly with an adapter balancing is necessary.

Setting trailing edge inserts

As in the setting procedure described above the standard inserts are adjusted to a radial run-out of = 0.02 mm. The inserts with Masterfinish edge are then set to 0.02–0.03 mm above the highest cutting edge.



The adjustment procedure

1 Mount Adjustment wedgesin the tools (as delivered). Tighten adjustment screw (1) without deforming the wedges.

2 Mount the PCD inserts and tighten the clamping screws (2) with 1.0 Nm.

3 Mark " highest edge" with the help of pre-setting equipment.

4 Adjust the PCD insert by 0.02 mm turning the clamping screw (1) clockwise.

Pre-loading must be reached. Use the angled TORX screwdrivers

5 Set other cutting edges to this level, maximum deviation of 0.005 mm. Maximum length adjustment = 0.10 mm.

6 Tighten all insert tightening screws (2) to 5.0 Nm.

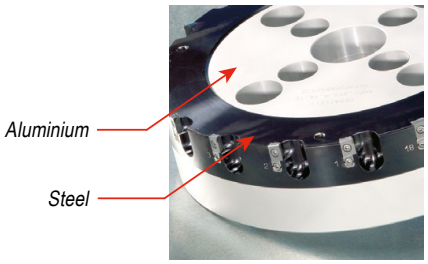
7 Check axial run-out of all inserts: Target = 0.005 mm.

Perfect precision – MaxiMill HPC-12

The adjustable high-performance tool for the finishing of aluminium components

Tool body made of steel

- For highest stability
- Maximum abrasion resistance
- Bimetallic version from diameter 160 mm easier handling and spindle protection with large tools



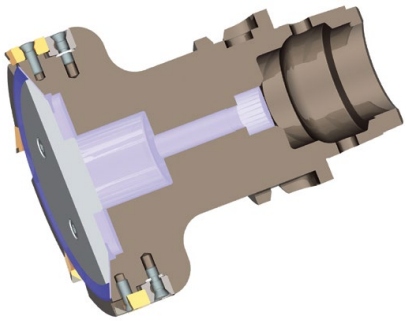
Picture shows bimetallic version

Available as shell milling cutters and monobloc type

- Direct HSK63 connection as monobloc type
- Monobloc tools balanced to G2.5 at n=20,000 min^{-1} (ISO1940)

Particularly for HSC applications with internal coolant supply

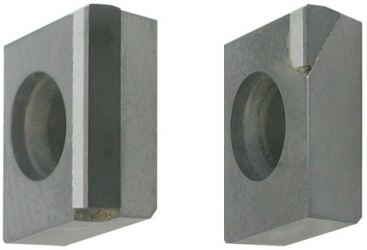
- Improved chip evacuation
- High surface quality
- Optimum application conditions
- Suitability for minimum quantity lubrication



Time is money – the system MaxiMill HPC-12 is simple and quick to adjust!

Highly positive rake angle of +25°

- Low cutting forces
- Increased parallelism of surfaces
- Minimised component deformation



Tangential concept

- Stable location for the PCD segment and maximum process security

Adapted PCD cutting edge

- High impact strength when milling!
- Maximum edge stability
- Reduced built-up edge on the work piece
- The machining of Al-Si alloys with over 12 % silicon is possible without problems

Inserts Selection

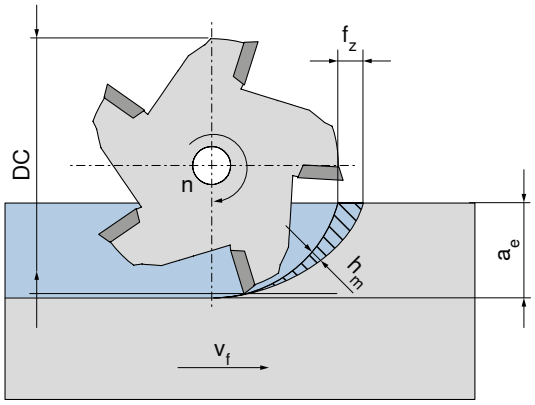
- Standard insert
- Insert with corner radius
- Insert with trailing edge

Average chip thickness [h_m] – the approach

Shoulder milling

1 Select appropriate average chip thickness [h_m] for the steel from the table.

Material	Tensile strength N/mm²	h_m mm
for steel	...–800	0.0063
for steel	800–1000	0.0055
for steel	1000–1200	0.0048
for steel	1200–...	0.0039
for stainless steel	...–750	0.0059
for stainless steel	750–900	0.0051
for stainless steel	900–1150	0.0043
for stainless steel	1150–...	0.0035*

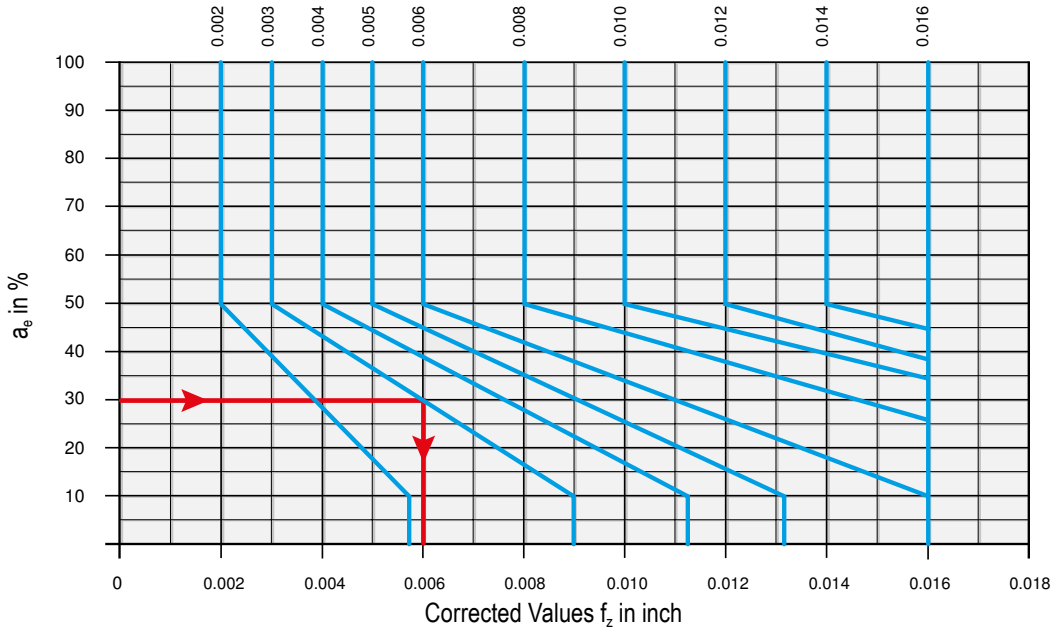


2 Select the corrected feed rate value from the table based on the appropriate chip thickness [h_m] and depth of cut [a_e].

h_m mm	Corrected feed value f_z for h_m				
0.0063	0.0142	0.0114	0.0098	0.0071	0.0063
0.0055	0.0122	0.0102	0.0087	0.0060	0.0055
0.0048	0.0106	0.0087	0.0075	0.0055	0.0047
0.0039	0.0087	0.0071	0.0063	0.0047	0.0039
0.0059	0.0134	0.0106	0.0094	0.0067	0.0059
0.0051	0.0114	0.0094	0.0083	0.0059	0.0051
0.0043	0.0098	0.0079	0.0067	0.0051	0.0043
0.0035*	0.0079	0.0063	0.0055	0.0039	0.0035
a_e =	**0.2 x DC**	**0.3 x DC**	**0.4 x DC**	**0.75 x DC**	**1 x DC**

* f_z < 0.032": Danger, as tool is not working and cutting

Start values f_z in inch from starting parameter diagram



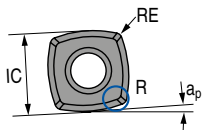
Example:
Start value (f_z) = 0.003"
a_e = 30 %
corrected value (f_z) = 0..006"

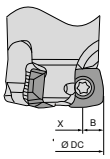
15

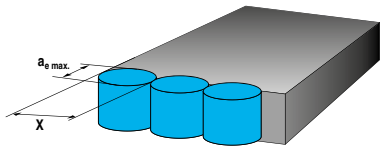
System MaxiMill HFC-06

Machining strategy

Programmed radius R = 0.047“



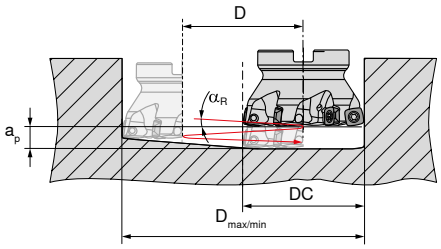




Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging				
IC in inch	RE in inch	$a_{p\ max.}$ in inch	DC in inch	X in inch	B in inch	$a_{e\ max.}$ in inch	f_z in inch			X
							initial	min.	max.	
0.25	0.020	0.032	0.625–1.25	DC–(2 x B)	0.169	0.209	0.004	0.003	0.006	<0.7 x DC

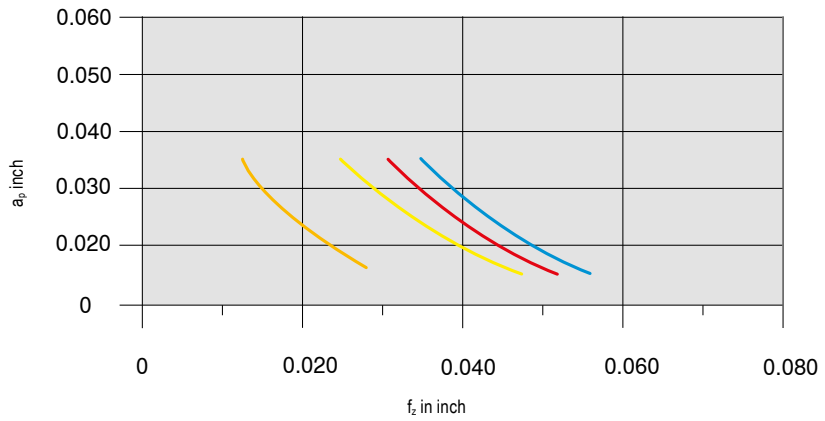
	circular		
	Helical plunging (helical plunging into solid material)		
DC inch	$D_{min.}$ inch	$D_{max.}$ inch	$\alpha_{R\ max.}$ °
0.625	0.866	1.22	4.5°
0.750	1.18	1.53	2.3°
1.00	1.57	1.93	1.3°
1.25	2.12	2.48	0.9°

	axial	Angled
	Plunging	
DC inch	$X_{max.}$ inch	$\alpha_{R\ max.}$ °
0.625	0.020	5.9°
0.750		3.2°
1.00		2.0°
1.25		1.3°



Starting Parameter

XPLX 06



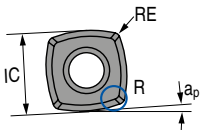
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XPLX 060305SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**XPLX 060305ER-M40**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**XPLX 060305ER-M50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**XPLX 060305SR-F40**	**CTC5240**	115	Emulsion

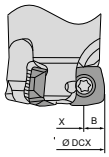
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

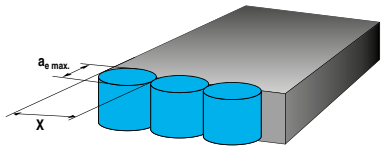
System MaxiMill HFC-09

Machining strategy

Programmed radius R = 0.078"

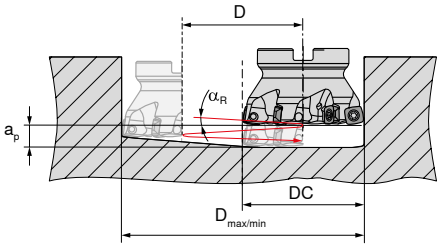






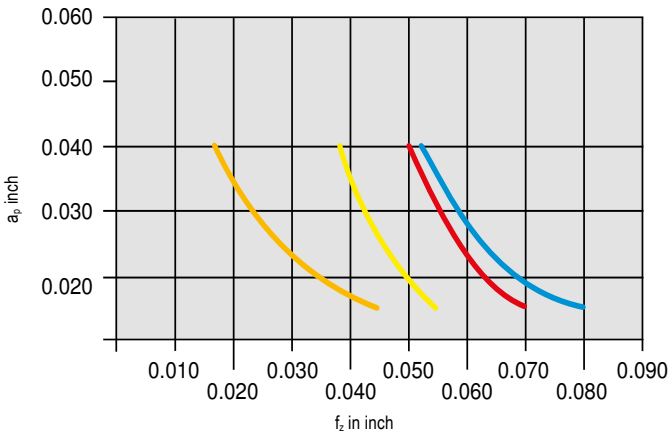
Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging				
IC in inch	RE in inch	$a_{p\,max.}$ in inch	DC in inch	X in inch	B in inch	$a_{e\,max.}$ in inch	f_z in inch			X
							initial	min.	max.	
0.354	0.032	0.040	1.00–2.50	DC–(2 x B)	0.232	0.295	0.004	0.003	0.006	<0.7 x DC

	circular			axial	Angled
	Helical plunging (helical plunging into solid material)			Plunging	
DC inch	$D_{min.}$ inch	$D_{max.}$ inch	$\alpha_{R\,max.}$ °	$X_{max.}$ inch	$\alpha_{R\,max.}$ °
1.00	1.37	1.89	3.1°		3.6°
1.25	1.93	2.44	1.7°		2.0°
1.37	2.16	2.67	1.4°		1.6°
1.50	2.56	3.07	1.0°		1.2°
1.62	2.71	4.01	0.9°	0.030	1.1°
2.00	3.34	3.85	0.8°		0.9°
2.12	3.50	4.01	0.7°		0.8°
2.50	4.37	4.88	0.7°		0.8°
2.62	4.60	5.11	0.6°		0.7°



Starting Parameter

XDLX 09



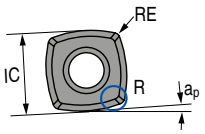
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XDLX09T308SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**XDLX09T308SR-M50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**XDLX09T308SR-M50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**XDLX09T308ER-F40**	**CTC5240**	115	Emulsion

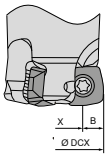
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

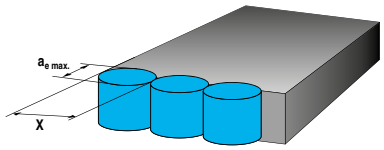
System MaxiMill HFC-12

Machining strategy

Programmed radius R = 0.118"



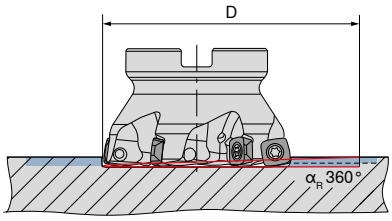




Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging				
IC in inch	RE in inch	$a_{p\,max.}$ in inch	DC in inch	X in inch	B in inch	$a_{e\,max.}$ in inch	f_z in inch			X
							initial	min.	max.	
0.472	0.040	0.080	1.25–4.00	DC–(2 x B)	0.326	0.393	0.006	0.004	0.008	<0.7 x DC

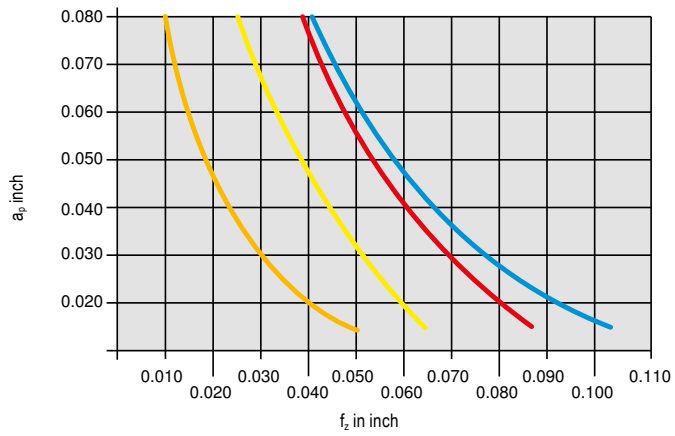
	circular		
	Helical plunging (helical plunging into solid material)		
DC inch	$D_{min.}$ inch	$D_{max.}$ inch	$\alpha_{R\,max.}$ °
1.00	1.73	2.45	6.1°
1.25	1.97	2.67	3.7°
1.50	2.56	3.07	2.5°
1.62	2.52	3.22	2.3°
2.00	3.15	3.86	1.3°
2.12	3.30	4.01	1.3°
2.50	4.17	4.88	0.9°
2.62	4.41	5.12	0.9°
3.00	5.51	6.22	1.1°
4.00	7.09	7.79	0.6°

	axial	Angled
	Plunging	
DC inch	$X_{max.}$ inch	$\alpha_{R\,max.}$ °
1.25	0.045	7.2°
1.37		4.4°
1.50		2.9°
1.62		2.7°
2.00 + 2.12		1.5°
2.50 + 2.62		1.1°
3.00		1.3°
4.00		0.7°



Starting Parameter

XOLX 12



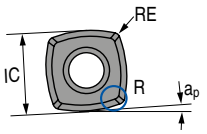
Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XOLX120410SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**XOLX120410ER-M50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**XOLX120410ER-M50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**XOLX120410ER-F40**	**CTC5240**	115	Emulsion

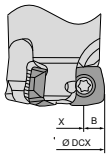
→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

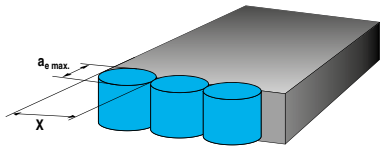
System MaxiMill HFC-19

Machining strategy

Programmed radius R = 0.196"



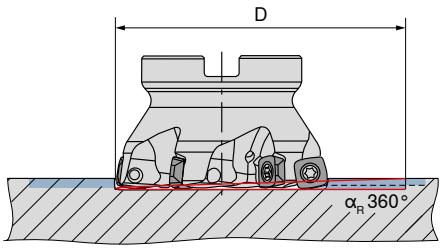




Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging				
IC in inch	RE in inch	$a_{p\ max.}$ in inch	DC in inch	X in inch	B in inch	$a_{e\ max.}$ in inch	f_z in inch			X
							initial	min.	max.	
0.753	0.060	0.129	2.50–6.00	DC–(2 x B)	0.516	0.472	0.008	0.004	0.010	<0.65 x DC

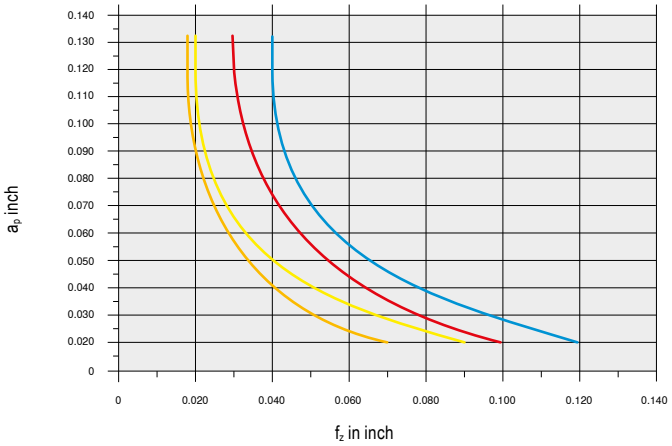
	circular		
	Helical plunging (helical plunging into solid material)		
DC inch	$D_{min.}$ inch	$D_{max.}$ inch	$\alpha_{R\ max.}$ °
2.50	3.82	4.84	2.5
3.00	5.15	6.18	1.4
4.00	6.73	7.75	1.0
5.00	8.70	9.72	0.7
6.00	11.45	12.48	0.5

	axial	Angled	
		Plunging	
DC inch	$X_{max.}$ inch	$\alpha_{R\ max.}$ °	$a_{p\ max}$ inch
2.50		2.9	
3.00		1.8	
4.00	0.067	1.3	0.129
5.00		1.0	
6.00		0.7	



Starting Parameter

XOLX 19



Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XOLX190615SR-M50**	**CTPP235**	660	Dry
Stainless steel	**M.2.1**	316Ti	**XOLX190615SR-M50**	**CTPM240**	320	Emulsion
Cast iron	**K.1.1**	GG25 Cast Iron	**XOLX190615SR-M50**	**CTCK215**	825	Dry
Heat-resistant	**S.2.2**	Inconel 718	**XOLX190615ER-F40**	**CTC5240**	115	Emulsion

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

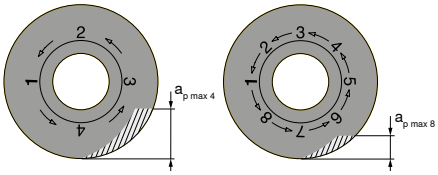
MaxiMill 251 RS system

Technical data

Recommended cutting depth

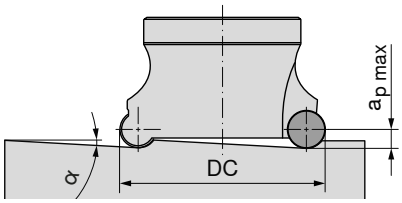
Ø inch	4-position $a_{p\,max.}$ inch	4-position $a_{p\,max}$ theoretical inch	8-face $a_{p\,max.}$ inch
0.196	0.040	0.080	0.028
0.314	0.060	0.140	0.043
0.393	0.100	0.180	0.055
0.472	0.120	0.220	0.067
0.629	0.160	0.300	0.090
0.787	0.160	0.380	0.114

Average depth for the 4/8 index use of the insert



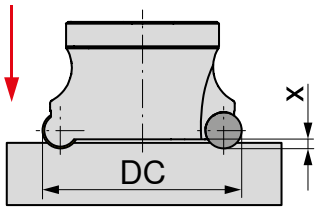
→ **Page 155–157**
Here you will find detailed information on cutting speed.

Linear ramping

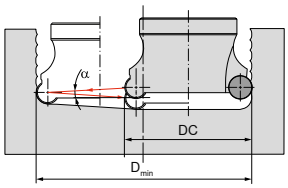


Ø DC inch	05 α °	08 α °	10 α °	12 α °	16 α °	20 α °
0.37	3.4					
0.50	16.0					
0.62	8.0	5.0				
0.75	5.5	20.0	1.3			
1.00	4.0	13.0	2.0	6.0		
1.25	3.0	8.0	3.0	4.0		
1.50			3.3	2.8		
1.62			3.1			
2.00			2.4	2.6	4.0	
2.12			2.2	2.3		
2.50				1.9	2.8	
2.62				1.6		
3.00				1.3	2.0	3.2
4.00				1.0	1.5	2.3
5.00						1.7

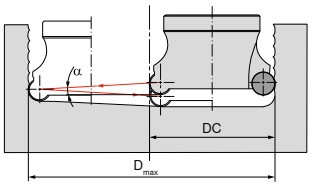
Axial ramping



Ø DC inch	05 $X_{max.}$ inch	08 $X_{max.}$ inch	10 $X_{max.}$ inch	12 $X_{max.}$ inch	16 $X_{max.}$ inch	20 $X_{max.}$ inch
0.37	0.020					
0.50	0.050					
0.62	0.050	0.020				
0.75	0.050	0.106	0.008			
1.00	0.050	0.106	0.016	0.040		
1.25	0.050	0.106	0.030	0.043		
1.50			0.060	0.047		
1.62			0.060	0.060		
2.00			0.060	0.060	0.080	
2.12			0.060	0.060	0.080	
2.50				0.060	0.080	
2.62				0.060	0.080	
3.00				0.060	0.080	0.120
4.00				0.060	0.080	0.120
5.00						0.120



$D_{min.}$ = smallest drilling diameter depending on the tool diameter



$D_{max.}$ = Maximum hole diameter Depending on the tool diameter

maximum possible hole diameter = 2 x DC – 0.040“

Ø DC inch	05 D_{min} inch	05 D_{max} inch	05 α_R °	08 D_{min} inch	08 D_{max} inch	08 α_R °	10 D_{min} inch	10 D_{max} inch	10 α_R °	12 D_{min} inch	12 D_{max} inch	12 α_R °	16 D_{min} inch	16 D_{max} inch	16 α_R °	20 D_{min} inch	20 D_{max} inch	20 α_R °
0.37	0.47	0.59	2.5															
0.50	0.63	0.75	2.1															
0.62	0.94	1.06	1.5	0.83	0.94	2.4												
0.75	1.26	1.38	1.2	1.06	1.26	1.9	1.02	1.18	1.3									
1.00	1.65	1.77	1.0	1.46	1.65	1.5	1.46	1.57	1.8	1.22	1.50	2.2						
1.25	2.20	2.32	0.7	2.01	2.20	1.2	1.97	2.13	1.5	1.81	2.05	1.7						
1.50							2.52	2.76	1.1	2.44	2.68	1.4						
1.62							2.68	2.91	1.1									
2.00							3.31	3.54	0.9	3.19	3.46	1.1	2.95	3.31	1.5			
2.12							3.46	3.70	0.9	3.39	3.62	1.0						
2.50										4.21	4.49	0.9	3.98	4.33	1.1			
2.62										4.45	4.72	0.8						
3.00										5.59	5.83	0.7	5.31	5.67	0.9	5.04	5.51	1.1
4.00										7.13	7.40	0.5	6.89	7.24	0.7	6.61	7.09	0.9
5.00																8.58	9.06	0.7

System MaxiMill 252

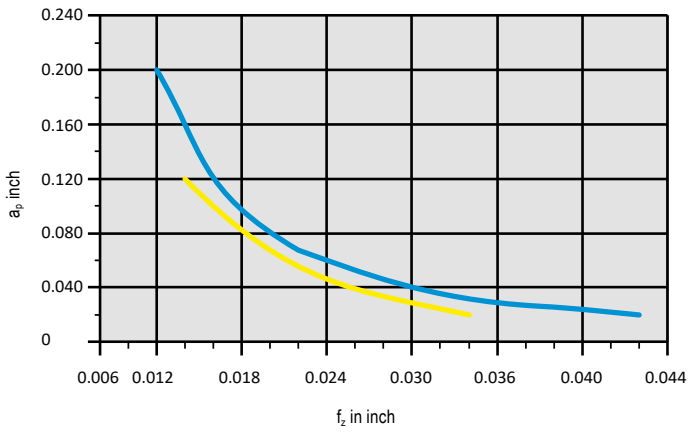
Machining strategy

Recommended cutting depth

Ø inch	4-position $a_{p\,max}$ inch	inch
0.393	0.100	0.180
0.472	0.120	0.220

Starting Parameter

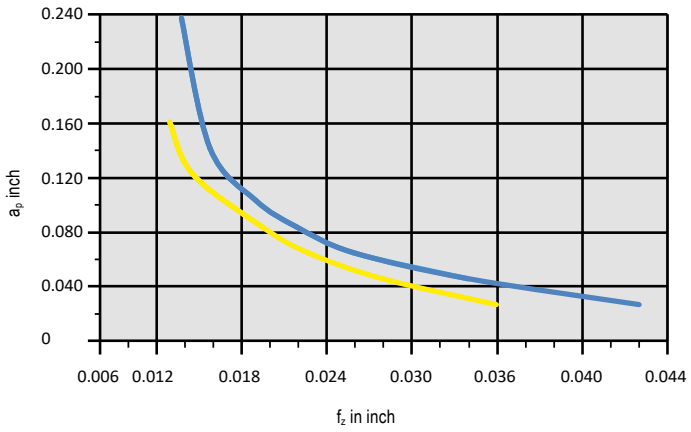
RNHU 10



Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XOLX120410SR-M50**	**CTPP235**	600	Dry
Stainless steel	**M.2.1**	316Ti	**XOLX120410ER-M50**	**CTPM240**	320	Emulsion

Starting Parameter

RNHU 12



Material			Inserts		v_c in ft/min	Cooling
Steel	**P.4.1**	P20	**XOLX120410SR-M50**	**CTPP235**	600	Dry
Stainless steel	**M.2.1**	316Ti	**XOLX120410ER-M50**	**CTPM240**	320	Emulsion

15

→ **Page 155–157**
Here you will find detailed information on cutting speed.
From v_c > 1300 SFM, the tool must be balanced!

Cutting data standard values for MaxiMill Slot-SX saws

Index	CTCP335	CTP1340	H216T
	v_c in ft/min.		
P.1.1	240	190	
P.1.2	210	160	
P.1.3	180	140	
P.1.4	160	130	
P.1.5	140	120	
P.2.1	220	170	
P.2.2	160	130	
P.2.3	140	120	
P.2.4	100	80	
P.3.1	130	120	
P.3.2	110	100	
P.3.3	90	80	
P.4.1	140	120	
P.4.2	120	110	
M.1.1	110	130	
M.2.1	100	120	
M.3.1	80	100	
K.1.1	300	200	140
K.1.2	240	180	115
K.2.1	200	120	150
K.2.2	160	100	110
K.3.1	190	120	170
K.3.2	160	100	140
N.1.1		300	500
N.1.2		200	330
N.2.1		250	370
N.2.2		220	330
N.2.3		200	280
N.3.1		300	350
N.3.2		300	350
N.3.3		200	320
N.4.1		200	320
S.1.1		70	
S.1.2		60	
S.2.1		35	
S.2.2		25	
S.2.3		30	
S.3.1		60	
S.3.2		50	
S.3.3		40	
H.1.1			
H.1.2			
H.1.3			
H.1.4			
H.2.1			
H.3.1			
O.1.1			160
O.1.2			
O.2.1			240
O.2.2			
O.3.1			

average chip thickness

h_m in mm

$$h_m = f_z \sqrt{\frac{a_e}{DC}}$$

Feed per tooth

f_z in inch

$$f_z = h_m \sqrt{\frac{DC}{a_e}}$$

Feed rate

v_f in mm/min

$$v_f = f_z \times ZNF \times n$$

DC = Ø of the disc cutters

ZNF = Number of teeth of the cutter

	Reference tool 50 386 12504 – ASLOT.125.R.8.32.DC-SX4											
	SX4 -F2				SX4 -M1				SX4 -M7			
	a_e	10	20	30	a_e	10	20	30	a_e	10	20	30
	hm	f_z in inch			hm	f_z in inch			hm	f_z in inch		
P	**0.0031**	0.011	0.0079	0.0063	**0.0039**	0.0118	0.0098	0.0079	**0.0035**	0.0118	0.0091	0.0071
M	**0.002**	0.0071	0.0051	0.0039					**0.0024**	0.0083	0.0059	0.0047
K					**0.0047**	0.0118	0.0118	0.0094	**0.0035**	0.0118	0.0091	0.0071
N	**0.0031**	0.011	0.0079	0.0063								
S	**0.0016**	0.0055	0.0039	0.0031								
H												
O												

	Reference tool 50 386 12504 – ASLOT.125.R.8.32.DC-SX4							
	SX4 -M8				SX4 -27P			
	a_e	10	20	30	a_e	10	20	30
	hm	f_z in inch			hm	f_z in inch		
P	**0.0031**	0.011	0.0079	0.0063				
M	**0.002**	0.0071	0.0051	0.0039				
K					**0.0024**	0.0083	0.0059	0.0047
N	**0.0031**	0.011	0.0079	0.0063	**0.0035**	0.0118	0.0091	0.0071
S	**0.0016**	0.0055	0.0039	0.0031				
H								
O					**0.002**	0.0071	0.0051	0.0039

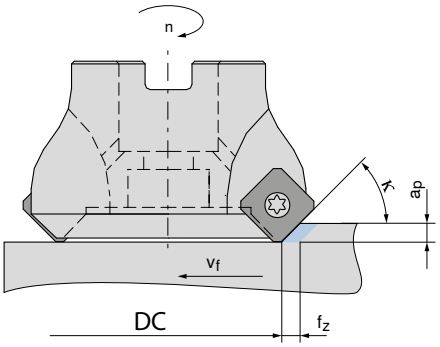
Caution: For narrower and wider indexable inserts, reduce or increase the feed per tooth accordingly!

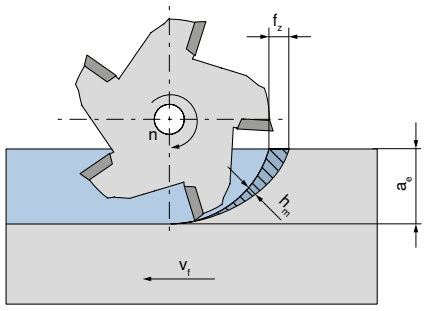
The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

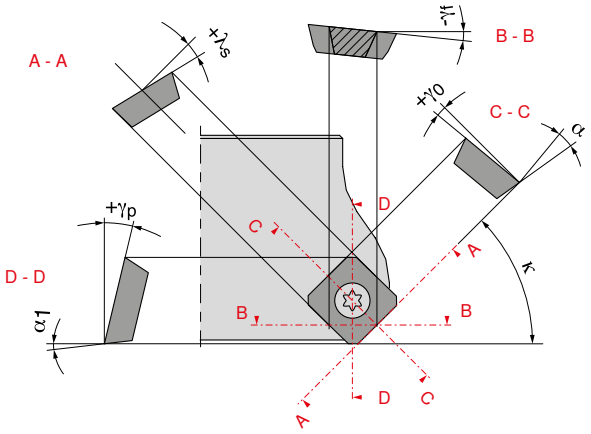
Abbreviations & dimensions

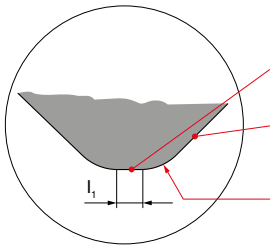
a_e	cutting width	inch
a_p	Cutting depth	inch
DC	Tool diameter	inch
D_w	Workpiece diameter	inch
f_z	Feed per tooth	inch
h_m	Average Chip Thickness	inch
k	Number of teeth	
k_c	Specific cutting force	N/inch²
$k_{c1.1}$	Specific cutting force for 1 mm ² chip area	N/inch²
BS	Length of trailing edge land	inch
m_c	Increase of specific cutting force	
n	rpm	rpm
Q	Chip volume	in³/min
v_c	Cutting speed	ft/min
v_f	Feed rate	in/min.
ZNF	Number of Effective Teeth	

γ_0	Effective cutting angle	degree
γ_f	Side clearance angle	degree
γ_p	Axial cutting angle	degree
κ	Cutting edge angle	degree
λ_s	Angle of inclination	degree
α	Clearance angle	degree
α_1	Side clearance angle	degree









Trailing edge land

Main cutting edge

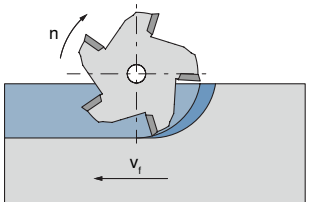
Corner radius

15

Engagement conditions

Recommended

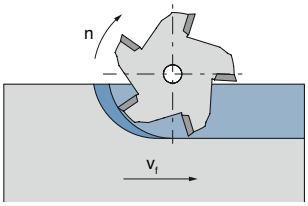
Climb milling



The feed direction of the workpiece is the same as the direction of rotation of the milling cutter in the cutting zone. The chips have maximum thickness at the beginning, chip thickness then decreases until it becomes zero at the end of the cut.

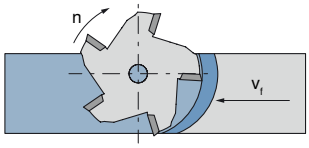
Unsuitable

Conventional milling

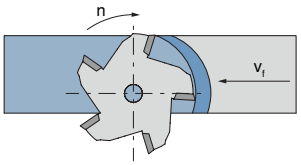


The feed direction of the workpiece is opposite to the direction of rotation of the milling cutter in the cutting zone. Chip thickness is zero at the beginning and increases until it reaches its maximum at the end of the cut.

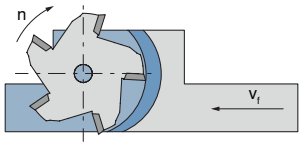
Cutter positioning



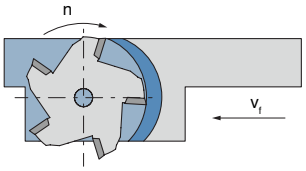
If possible the cutter should exit tangentially of the workpiece.



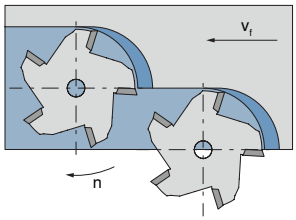
Workpiece situation



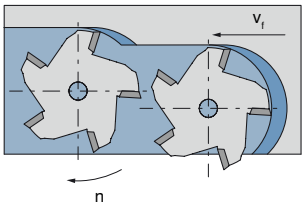
The workpiece should be clamped in such a way as to allow the cutter to emerge tangentially of the workpiece along the whole machining length.



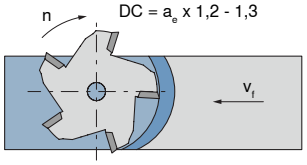
Overlapping



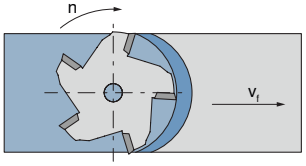
Either employ climb milling or ensure that the cutter comes out of the workpiece tangentially, as in the illustration on the left.



Cutter size



When face milling the diameter of the cutter should be 20–30 % larger than that of the workpiece.



ISO designation indexable milling inserts – inch

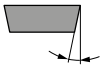
X	D	K	T	11	T3	08	S	R	-	F50
1	2	3	4	5	6	7	8	9		10

Z	N	H	W	12	05	PO	S	R	-	15	06	-	R
1	2	3	4	5	6	7	8	9		11	12		13

1 Insert shape

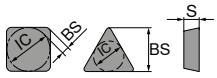
A	85°	
B	82°	
K	55°	
H	120°	
L	90°	
O	135°	
P	108°	
C	80°	
D	55°	
E	75°	
M	86°	
V	35°	
R		
S	90°	
T	60°	
W	80°	
X Z	Special version	

2 Clearance angle

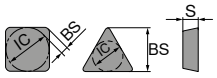


	α
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Special version

3 Tolerances

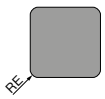


	IC ±inch	BS ±inch	S ±inch	IC = 1/4 / 3/8	IC = 1/2	IC = 5/8 / 3/4
A	0.0010	0.0002	0.0001	●	●	●
C	0.0010	0.0005	0.0001	●	●	●
E	0.0010	0.0010	0.0001	●	●	●
F	0.0005	0.0002	0.0001	●	●	●
G	0.0010	0.0010	0.0005	●	●	●
H	0.0005	0.0005	0.0010	●	●	●
J	0.0020	0.0002	0.0010	●		
	0.0031	0.0002	0.0010		●	
	0.0039	0.0002	0.0010			●
K	0.0020	0.0005	0.0010	●		
	0.0031	0.0005	0.0008		●	
	0.0039	0.0005	0.0008			●



	IC ±inch	BS ±inch	S ±inch	IC = 1/4 / 3/8	IC = 1/2	IC = 5/8 / 3/4
M	0.0020	0.0031	0.0051	●		
	0.0031	0.0051	0.0051		●	
	0.0039	0.0059	0.0051			●
N	0.0020	0.0031	0.0010	●		
	0.0031	0.0051	0.0010		●	
	0.0039	0.0059	0.0010			●
U	0.0031	0.0051	0.0051	●		
	0.0051	0.0079	0.0051		●	
	0.0071	0.0071	0.0051			●

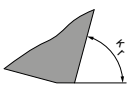
7 Trailing edge land / corner radius



Radius

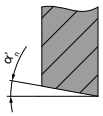
	RE in inch
M0*	
02	0.008
04	0.016
08	0.031
12	0.047

* Only with insert type "R"



1. Designation

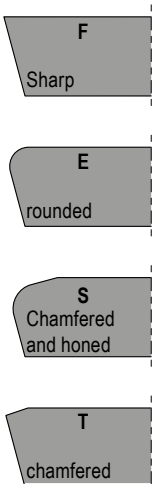
	K_r
A	45°
D	60°
E	75°
F	85°
P	90°
Z	Alternative



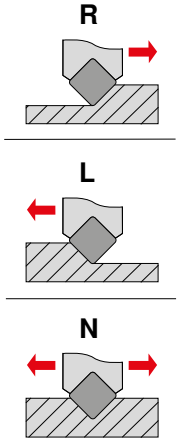
2. Designation

	α'_n
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z O	Alternative

8 Cutting edge



9 Direction of cut

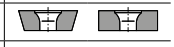


15

ISO designation indexable milling inserts – inch

4

Characteristics

A	
F	
G	
M	
N	
Q	
R	
T	
U	
W	
X	Special version

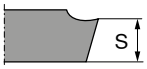
5

Cutting length

IC inch	A	T	C/S	H	L	R	V	W	O	X	Z
0.193										07	
0.196						05					
0.219			05		08			03			
0.236											
1 / 4		11	06		10			04		06	
0.262	10										
0.267										11	
0.275											04
0.313			07								
0.315						08					
0.354					12						
0.366										15	
3 / 8	16	16	09		15			06	04		
0.376	15										
0.378										09	
0.394			10		11	10					12
0.472						12					
0.492										20	
1 / 2		12/22	12		20		22	08		12	
0.622			15		22			10			
0.630						16					
0.638				09							
0.659			16								
0.670			17								
0.676									06		
0.716									07		
3 / 4			19					13			
0.787						20					

6

Insert thickness



	S inch
01	0.063
T1	0.078
02	0.094
03	0.125
T3	0.156
04	0.187
05	0.219
06	0.250
07	0.312
09	0.375

10

Chip groove

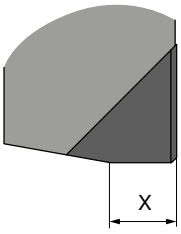
Chip breaker designation
F.. = fine
M.. = medium
R.. roughing

Additional characteristics:
R = transition radius main/ secondary cutting edge
Q = Masterfinish

11

Manufacturer specification

Length of the finishing cutting edge

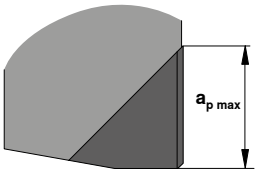


00 = 0.0 mm / 0.00 in
10 = 1.0 mm / 0.039 in
12 = 1.2 mm / 0.047 in
15 = 1.5 mm / 0.059 in
30 = 3.0 mm / 0.118 in
50 = 5.0 mm / 0.197 in

12

Manufacturer specification

$a_{p\,max}$



02 = 2.0 mm / 0.078 in
03 = 3.0 mm / 0.118 in
04 = 4.0 mm / 0.157 in
06 = 6.0 mm / 0.236 in
07 = 7.0 mm / 0.275 in
11 = 11.0 mm / 0.433 in

13

Manufacturer specification

F = Fine
M = Medium
R = Rough

ISO designation indexable milling inserts – metric

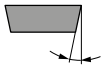
X	D	K	T	11	T3	08	S	R	-	F50
1	2	3	4	5	6	7	8	9		10

Z	N	H	W	12	05	PO	S	R	-	15	06	-	R
1	2	3	4	5	6	7	8	9		11	12		13

1 Insert shape

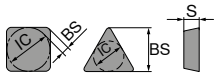
A	85°	
B	82°	
K	55°	
H	120°	
L	90°	
O	135°	
P	108°	
C	80°	
D	55°	
E	75°	
M	86°	
V	35°	
R		
S	90°	
T	60°	
W	80°	
X Z	Special version	

2 Clearance angle

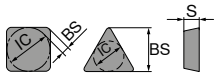


	α
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Special version

3 Tolerances

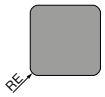


	IC ±mm	BS ±mm	S ±mm	IC = 6.35 / 9.52	IC = 12.7	IC = 15.8 / 19.05
A	0.025	0.005	0.025	●	●	●
C	0.025	0.013	0.025	●	●	●
E	0.025	0.025	0.025	●	●	●
F	0.013	0.005	0.025	●	●	●
G	0.025	0.025	0.13	●	●	●
H	0.013	0.013	0.025	●	●	●
J	0.05	0.005	0.025	●		
	0.08	0.005	0.025		●	
	0.10	0.005	0,025			●
K	0.05	0.013	0.025	●		
	0.08	0.013	0.02		●	
	0.10	0.013	0.02			●



	IC ±mm	BS ±mm	S ±mm	IC = 6.35 / 9.52	IC = 12.7	IC = 15.8 / 19.05
M	0.05	0.08	0.13	●		
	0.08	0.13	0.13		●	
	0.10	0.15	0.13			●
N	0.05	0.08	0.025	●		
	0.08	0.13	0.025		●	
	0.10	0.15	0.025			●
U	0.08	0.13	0.13	●		
	0.13	0.20	0.13		●	
	0.18	0.27	0.13			●

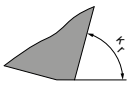
7 Trailing edge land / corner radius



Radius

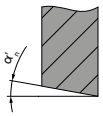
	RE in inch
M0*	
02	0.2
04	0.4
08	0.8
12	1.2

* Only with insert type "R"



1. Designation

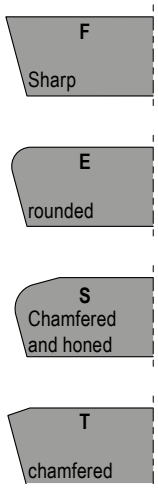
	K_r
A	45°
D	60°
E	75°
F	85°
P	90°
Z	Alternative



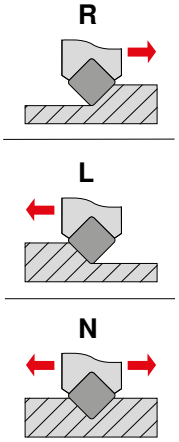
2. Designation

	α'_n
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
Z O	Alternative

8 Cutting edge



9 Direction of cut

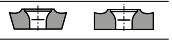


15

ISO designation indexable milling inserts – metric

4

Characteristics

A	
F	
G	
M	
N	
Q	
R	
T	
U	
W	
X	Special version

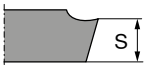
5

Cutting length

IC mm	A	T	C/S	H	L	R	V	W	O	X	Z
4.90										07	
5.00						05					
5.56			05		08			03			
6.00											
6.35		11	06		10			04		06	
6.65	10										
6.80										11	
7.00											04
7.94			07								
8.00						08					
9.00					12						
9.30										15	
9.52	16	16	09		15			06	04		
9.57	15										
9.60										09	
10.00			10		11	10					12
12.00						12					
12.50										20	
12.70		12/22	12		20		22	08		12	
15.81			15		22			10			
16.00						16					
16.20				09							
16.74			16								
17.00			17								
17.18									06		
18.18									07		
19.05			19					13			
20.00						20					

6

Insert thickness



	S mm
01	1.59
T1	1.98
02	2.38
03	3.18
T3	3.97
04	4.76
05	5.56
06	6.35
07	7.94
09	9.52

10

Chip groove

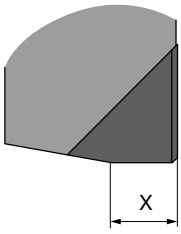
Chip breaker designation
F.. = fine
M.. = medium
R.. roughing

Additional characteristics:
R = transition radius main/ secondary cutting edge
Q = Smoothing edge

11

Manufacturer specification

Length of the finishing cutting edge

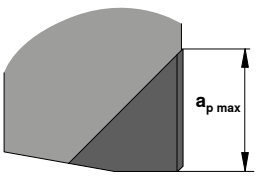


00 = 0.0 mm
10 = 1.0 mm
12 = 1.2 mm
15 = 1.5 mm
30 = 3.0 mm
50 = 5.0 mm

12

Manufacturer specification

$a_{p\,max}$



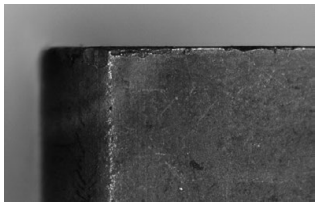
02 = 2.0 mm
03 = 3.0 mm
04 = 4.0 mm
06 = 6.0 mm
07 = 7.0 mm
11 = 11.0 mm

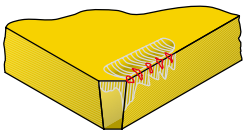
13

Manufacturer specification

F = Fine
M = Medium
R = Rough

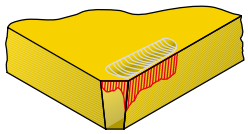
Cutting demands when milling





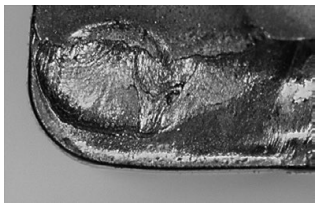
Edge chipping

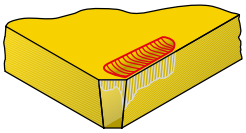
Cutting speed ↑
Feed per tooth ↓
Toughness of grade ↑
Cutting edge chamfer ↑



Wear on clearance face

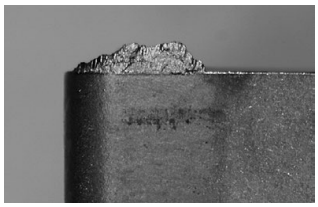
Cutting speed ↓
Feed per tooth ↑
Abrasion resistant grade ↑

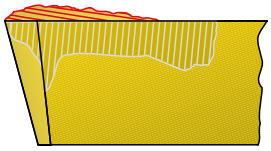




Cratering

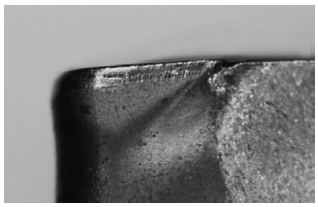
Cutting speed ↓
Feed per tooth ↓
Abrasion resistant grade ↑

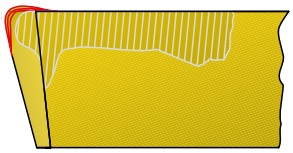




Built-up edge

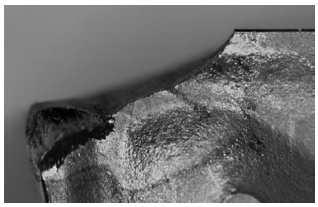
Cutting speed ↑
Feed per tooth ↑
Wear resistance ↑

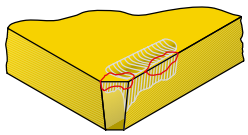




Cutting-edge deformation

Cutting speed ↓
Feed per tooth ↓
Abrasion resistant grade ↑



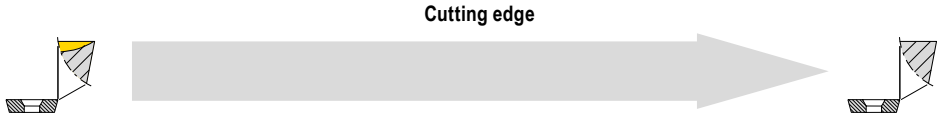


Cutting Edge Breakage

Cutting speed ↓
Toughness of grade ↑

15

Chip Breakers Overview



			Sharp		medium		stable	
			●		● ●		● ● ●	
			10	20	30	40	50	60
increasing wedge angle	fine	F	-F10 -27 -27P	-F20		-F40	-F50	-ER -FN -33P -33
	medium	M			-M31 -M30 -M32		-M50 -31	-EN -29
	rough	R			-R30		-R50	-SN -R60 -SR

Chip breaker code

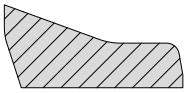
			Cutting edge		
			Sharp	medium	stable
			10–20	30–40	50–60
Application type	light	F	●	● ●	● ● ●
	universal	M	●	● ●	● ● ●
	difficult	R	●	● ●	● ● ●

Example: Chip breaker -M50

Chip breaker description

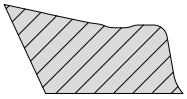
-27P

- Highly positive geometry
- Sharp cutting edges
- Reduced built up edge
- First choice for non-ferrous metals



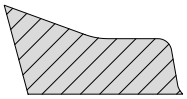
-F10

- Very positive geometry
- Sharp cutting edge
- Prevents sticking and edge build up
- First Choice for non-ferrous metal



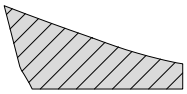
-27

- Highly positive geometry
- Sharp cutting edges
- First choice for non-ferrous metals



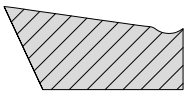
-F20

- Extremely positive geometry
- Lightly rounded cutting edge
- First choice for non-ferrous metals



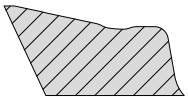
-F40

- Positive geometry
- Rounded cutting edge
- Finish and rough machining
- For unstable clamping situations
- For heat-resistant materials, titanium and super alloys



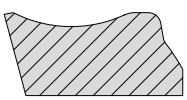
-F50

- Positive geometry with small positive protective chamfer
- Rounded cutting edge
- Low cutting force and good stability
- For unstable clamping situations
- Light rough machining
- First choice for stainless steels



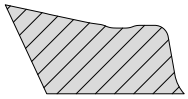
-33P

- Positive geometry with small neutral protective chamfer
- Low adhesion
- Rounded cutting edge
- Low cutting force and good stability
- For unstable clamping situations
- Light rough machining
- First choice for stainless steels



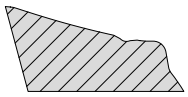
-M30

- Positive geometry
- Rounded cutting edge
- Medium rough machining
- First choice for martensitic stainless steels



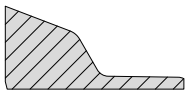
-M31

- Positive geometry
- Rounded cutting edge
- Finish and rough machining
- For unstable clamping situations
- For heat-resistant materials, titanium and super alloys



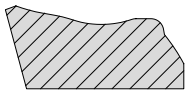
-M32

- Positive geometry
- Rounded cutting edge
- Low cutting force and good stability
- Medium rough machining
- First choice for martensitic stainless steels



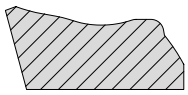
-M50

- Positive geometry with slightly negative protective chamfer
- Rounded cutting edge
- Low cutting force and good stability
- Light to medium rough machining
- First choice for general steels



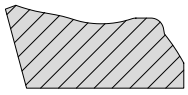
-31

- Positive geometry with neutral protective chamfer
- Rounded cutting edge
- Heavy rough machining
- Strongly interrupted cuts
- First choice for cast iron materials



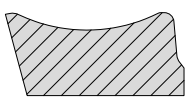
-29

- Positive geometry with slightly negative protective chamfer
- Rounded cutting edge
- Low cutting force and good stability
- Light to medium rough machining
- First choice for general steels



-33

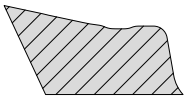
- Positive geometry with small neutral protective chamfer
- Rounded cutting edge
- Low cutting force and good stability
- For unstable clamping situations
- Light rough machining
- First choice for stainless steels



Chip breaker description

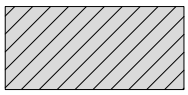
-29R

- Positive geometry with slightly negative protective chamfer
- Heavily rounded cutting edge
- Low cutting force and good stability
- Light to medium rough machining
- First choice for general steels



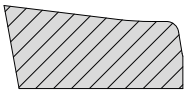
-ER

- Neutral Geometry
- Rounded cutting edge
- Universal application
- High surface quality due to face chamfer
- First choice for machining cast iron and non-ferrous metals



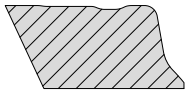
-R30

- Slightly positive geometry
- Rounded cutting edge
- Medium rough machining
- Strongly interrupted cuts
- First choice for cast iron materials



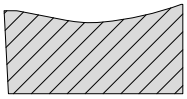
-EN

- Neutral geometry
- Rounded cutting edge
- High surface quality due to face chamfer (radial protective chamfer on indexable insert)
- First choice for machining cast iron and non-ferrous metals



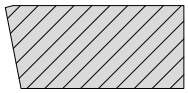
-R50

- Rugged geometry with protective chamfer
- Rounded cutting edge
- Rough machining
- Interrupted cuts
- Recommendation for cast iron materials



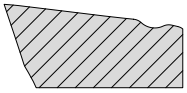
-SN

- Neutral geometry
- Rounded cutting edge
- High surface quality due to face chamfer (radial protective chamfer on indexable insert)
- Low cutting forces
- First choice for good flatness



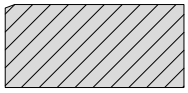
-R60

- Rugged geometry with protective chamfer
- Rounded cutting edge
- Rough machining
- For stable clamping situations
- Recommendation for high-strength steel materials



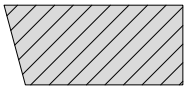
-SR

- Neutral geometry with negative protective chamfer
- Rounded cutting edge
- Robust indexable insert
- For poor machining conditions
- First choice for machining cast iron and steels



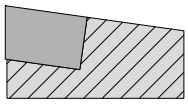
-FN

- Neutral and highly stable geometry
- Heavily rounded cutting edge
- For stable machining conditions
- First choice for hard machining up to approx. 50 HRC



-FR

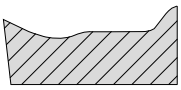
- Neutral Geometry
- Slightly rounded and stable cutting edge
- Associated with Ceramic and CBN cutting materials.
- For stable machining situations
- First choice for machining cast irons



Chip breaker description for MaxiMill Slot-SX

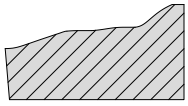
-27P

- Positive geometry
- Ground, sharp cutting edge
- Polished chip breaker
- Low cutting forces
- Fine to medium machining
- First choice for non-ferrous metals



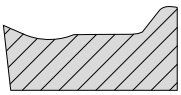
-M8

- Extremely positive geometry
- Ground cutting edge
- Low cutting forces
- Fine to medium machining
- First choice for difficult-to-machine and stainless materials
- Alternatively, can also be used for non-ferrous metals



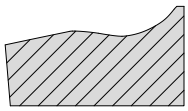
-F2

- Positive geometry
- Ground cutting edge
- Low cutting forces
- Fine to medium machining
- For stainless and steel materials



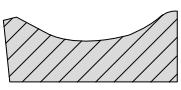
-M7

- Positive geometry
- Medium machining
- Universal application



-M1

- Stable cutting edge
- Medium to rough machining
- Best suited to steel materials



Grade description – Indexable insert countersink

BK8425

- Carbide, TiAlN/TiN-coated
- ISO | **P25** | **M25** | **K25**
- Universal grade with greater wear resistance thanks to innovative PVD multi-layer coating

K10

- Carbide, uncoated
- ISO | **K10**
- Uncoated carbide grade for machining grey cast iron or non-ferrous metals, depending on the cutting edge geometry

Chip breakers

-SM

- Rake angle 15°
- For universal use with medium machining
- Stable cutting edge

-U877

- Rake angle 6°
- circumferentially ground
- Three-ground chip breaker with second clearance angle for clearance with small tool diameters

-G06

- Rake angle 6°
- Preferred application in P / M / K
- Characterized by a particularly stable wedge angle

-G12

- Rake angle 12°
- Preferred application in P / N / S
- is characterized by a particularly high cutting performance

Grades Overview

Grade designation	Standard designation	ISO application range	Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials
		01 05 10 15 20 25 30 35 40 45 50	P	M	K	N	S	H	O
CTEP210	HE-P10		●		●				
	HE-K05								
TCM10	HT-P15		●		○				
	HT-K10								
WTN1205	HC-P10		●	○	●			●	
	HC-M15								
	HC-K05								
	HC-H10								
CTPP211	HC-P10		●	○	○	○	○	○	○
	HC-M15								
	HC-K10								
	HC-N10								
	HC-S15								
	HC-H10								
	HC-O10								
CTPP216	HC-P10		●	○	●	○	○	●	○
	HC-M20								
	HC-K15								
	HC-N15								
	HC-S20								
	HC-H15								
	HC-O15								
CTCP220	HC-P20		●		●				
	HC-K20								
CTPP225	HC-P25		●		●				
	HC-K25								
CTCP230	HC-P30		●		●				
	HC-K25								
CTPP231	HC-P30		●		○				
	HC-K25								
CTPP235	HC-P35		●	○	○				
	HC-M30								
	HC-K30								
CTPP236	HC-P35		●	○	○				
	HC-M35								
	HC-K30								
WAN1240	HC-P40		●	○	○				
	HC-M35								
	HC-K30								
WAX1240	HC-P30		●	○	○				
	HC-M25								
	HC-K25								
CTPM225	HC-P25		●	●					
	HC-M25								
WAN2225	HC-M25			●			●		
	HC-S30								
CTCM235	HC-P40		●	●					
	HC-M35								
CTPM240	HC-P40		○	●					
	HC-M40								
CWK10	HC-N10					●			○
	HC-O10								

● **Main Application**
○ Extended application

wear-resistant v_c+ ⟷ v_c– tough

Grades Overview

Grade designation	Standard designation	ISO application range	Steel P	Stainless steel M	Cast iron K	Non-ferrous metals N	Heat-resistant S	Tempered steel H	Non-metal materials O
CTPM241	HC-P40	01 05 10 15 20 25 30 35 40 45 50	●	●			○		
	HC-M40								
	HC-S40								
CTPM245	HC-P45		●	●					
	HC-M50								
CTCM245	HC-P45		●	●			○		
	HC-M50								
	HC-S35								
CTN3105	CN-K05				●				
CTL3215	BC-K10				●			○	
	BC-H10								
CTCK215	HC-K15				●				
CTPK220	HC-K20				●				
CTPK221	HC-P15		○		●				
	HC-K10								
CTPK226	HC-P15		●	●	●			○	
	HC-M20								
	HC-K15								
	HC-H15								
CTPK231	HC-P30		●	●	●	○	○	○	
	HC-M35								
	HC-K30								
	HC-N30								
	HC-S35								
	HC-H30								
CTD4205	DP-N05					●			○
	DP-O05								
CTPX715	HC-P15		○	○	●	●	○		○
	HC-M15								
	HC-K15								
	HC-N15								
	HC-S20								
	HC-O10								
WUN4210	HT-K10				○	●			
	HT-N15								
CTCN211	HC-N10					○			●
	HC-O10								
CTWN215	HC-K15				○	●			○
	HC-N10								
	HC-O10								
H216T	HW-K15				○	●			○
	HW-N15								
	HW-O15								
CTC5240	HC-S35						●		
CTCS245	HC-S45						●		
CTP6215	HC-K15				●			●	
	HC-H15								
CWX500	HC-P15		●	●	○	●	○		○
	HC-M15								
	HC-K15								
	HC-N15								
	HC-S15								
	HC-O15								

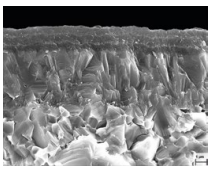
● **Main Application**
○ Extended application

wear-resistant v_c+ ⟷ v_c− tough

15

Grade description

CTEP210



P10 | **K05**

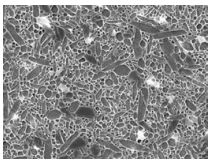
Specification:
Composition: Cermet Co/Ni 12.2%; mixed carbide 71.4%; others; WC balance | Fine grain size | Hardness: HV_{30} 1620 |
Layer system: CVD TiCN-Al_3O_3
Application:
Coated Cermet grade with reserves of toughness for finish machining at high cutting speeds

TCM10

P15 | K10

Specification:
Composition: Co/Ni 12.2%; WC 15; TaNbC10.0%; TiCn balance | Hardness: HV_{30} 1620 | Layer system: uncoated
Application:
Uncoated Cermet grade for the finishing of hardened steel

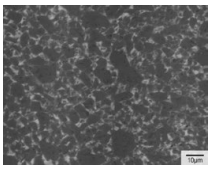
CTN3105



CN-K05

Specification:
Composition: ß – Si_3N_4 | Fine grain size | Hardness: HV_{30} 1620 | Layer system: uncoated
Application:
Universal silicon nitride for the machining of cast iron materials

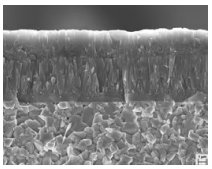
CTL3215



BC-K10 | BC-H10

Specification:
Composition: Cubic boron nitride (CBN) | 85 vol. + metallic binder phase | Cutting system: PVD
Application:
Coated cubic boron nitride with very good cutting toughness and good wear resistance for the machining of cast iron materials

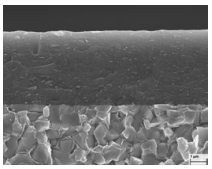
CTCP220



HC-P20 | **HC-K20**

Specification:
Composition: Co 8.0%; mixed carbide 2.0%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1500 |
Layer system: CVD TiCN-Al_3O_2
Application:
Dry machining, high cutting speed + more wear resistant grades to CTCP230
Material example:
Low material strength up to approx. 250 HB / 840 N/mm²

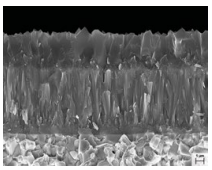
CTPP225



HC-P25 | **HC-K25**

Specification:
Composition: Co 8.0%; mixed carbide 2.0%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1500 | Layer system: PVD TiAlTaN
Application:
Dry or wet machining, face milling of steel materials, higher cutting speeds + more wear resistant grades to CTPP235
Material example:
Medium material strength up to approx. 300 HB / 1000 N/mm²

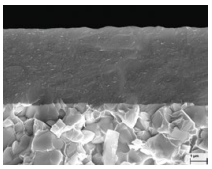
CTCP230



HC-P30 | HC-M25 | **HC-K25**

Specification:
Composition: Co 10.5%; mixed carbide 2.0%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1400 |
Layer system: CVD TiCN-Al_2O_3
Application:
Dry machining, universal grade for higher cutting speeds

CTPP235

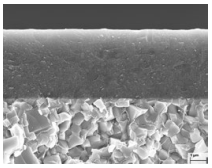


HC-P35 | HC-M30

Specification:
Composition: Co 10.5%; mixed carbide 2.0%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1400 | Layer system: PVD TiAlTaN
Application:
Wet machining, universal grade for medium cutting speeds

Grade description

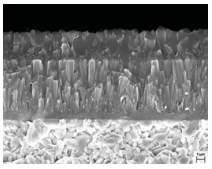
CTPM225



HC-P25 | **HC-M25**

Specification:
Composition: Co 9.0%; mixed carbide 0.75%; WC balance | Fine grain size 0.7-1µm | Hardness: HV_{30} 1590 | Layer system: PVD TiAlTaN
Application:
Dry or wet machining at medium cutting speeds
Material example:
Austenitic stainless steels

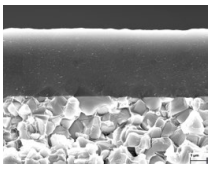
CTCM235



HC-P40 | **HC-M35**

Specification:
Composition: Co 12.5%; mixed carbide 2.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1380 | Layer system: CVD TiCN-Al_2O_3
Application:
Dry machining for medium cutting speeds
Material example:
Martensitic stainless steels

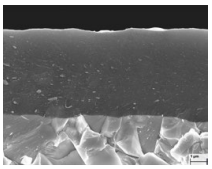
CTPM240



HC-P40 | **HC-M40**

Specification:
Composition: Co 12.0%; mixed carbide 2.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1380 | Layer system: PVD TiAlTaN
Application:
Wet machining, universal grade for higher cutting speeds
Material example:
Austenitic stainless steels

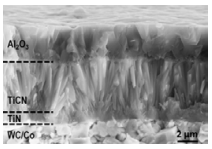
CTPM245



HC-P45 | **HC-M45**

Specification:
Composition: Co 10.0%; others 1.5%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1330 | Layer system: PVD TiAlTaN
Application:
Dry or wet machining
Material example:
High-alloy martensitic and austenitic stainless steel

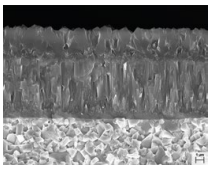
CTCM245



HC-P45 | **HC-M50** | HC-S35

Specification:
Composition: Co 10.0%; others 1.5%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1330 | Layer system: CVD TiCN-Al_2O_3
Application:
Dry machining
Material example:
High-alloy martensitic and austenitic stainless steel

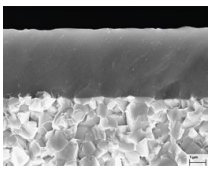
CTCK215



HC-K15

Specification:
Composition: Co 6.0%; mixed carbide 2.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1630 | Layer system: CVD TiCN-Al_2O_3
Application:
Special grade for the dry machining of cast iron materials at high cutting speeds
Material example:
Cast iron materials such as GG25 and GGG40

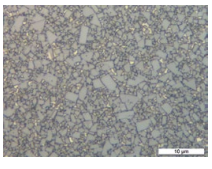
CTPK220



HC-K20

Specification:
Composition: Co 6.0%; mixed carbide 2.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1630 | Layer system: PVD TiAlTaN
Application:
Special grade for the wet machining of cast iron materials in demanding application ranges
Material example:
High-strength cast iron materials such as GGG50 and GGG70

CTWN215 (H216T)

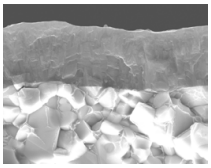


K15 | **N15** | O15

Specification:
Composition: Co 6.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1650 | Layer system: uncoated
Application:
Uncoated carbide for the machining of aluminium and non-ferrous metals
Material example:
Non-ferrous metals such as AlMgSi1

Grade description

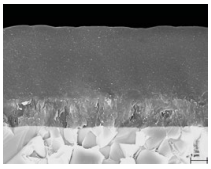
CTPX715



ISO | **P15** | **M15** | K15 | **N15** | **S20** | O10 ○ ○ ● ● ○ ○

Specification:
Composition: Co 6.0%; WC balance | Fine grain size 1µm | Hardness: HV_{30} 1650 | Layer system: PVD AlTiN
Application:
For the machining of aluminium and non-ferrous metals
Material example:
Non-ferrous metals such as AlMgSi1 or GGG30 cast iron

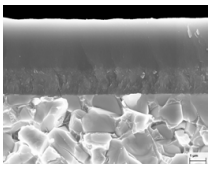
CTC5240



HC-S40

Specification:
Composition: Co 10.0%; WC balance | Medium grain size 2µm | Hardness: HV_{30} 1330 | Layer system: CVD TiN-TiB_2
Application:
Special wet machining grade for the machining of titanium materials
Material example:
Titanium Ti6Al4V

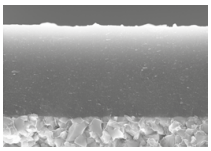
CTCS245



HC-S45

Specification:
Composition: Co 12.0%; mixed carbide 1.8%; WC balance | Medium grain size 1-2µm | Hardness: HV_{30} 1260 | Layer system: CVD TiN-TiB_2
Application:
Wet machining special grade for the machining of nickel-based alloys or the dry machining of austenitic stainless steels
Material example:
Heat-resistant materials such as Inconel, Rene, Nimonic, etc.

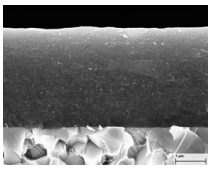
CTP6215



HC-H15 | HC-K15

Specification:
Composition: Co 12.0%; WC balance | Ultra-fine grain size 0.4µm | Hardness: HV_{30} 1630 | Layer system: PVD TiAlN
Application:
For the machining of high-strength martensitic tool steels 400HB / 1300 N/mm²
Material example:
Tool steel 1.2379, 1.2312

CTP1340

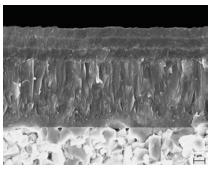


ISO | **P30** | **K30** | N30 | **S30** | O30 ● ● ○ ●

Specifications:
Composition: Co 9.0%; mixed carbide 0.75%; WC balance | grain size: 0.7–1 µm | Hardness: HV_{30} 1590 | Layer system: PVD TiAlTaN

Recommended use:
The universal high-performance grade for steels, austenitic steel, cast iron materials and heat-resistant alloys

CTCP335



ISO | **P35** | M30 | **K35** ● ○ ●

Specifications:
Composition: Co 10.5%; mixed carbide 1.9%; WC balance | grain size: 1 µm | Hardness: HV_{30} 1370 |
Layer system: CVD TiCN-Al_2O_3 Multilayer

Recommended use:
The reliable choice for machining steel and cast iron materials.

Grade description