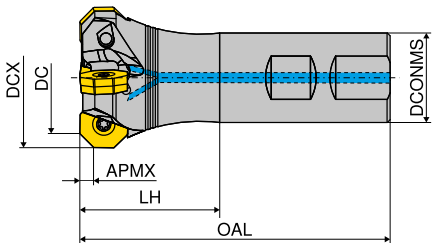
MaxiMill – End milling cutter C 273

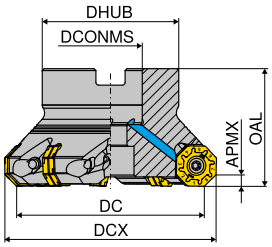
▲ 16 cutting edges per insert

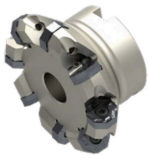


Designation	DC	DCX	ZNF	APMX	DCONMS $_{h6}$	LH	OAL	torque moment	Insert	2B/40 Article no. 50 762 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
C273.32.R.03-06-B-40	32	42,1	3	3,5	32	40	101	5	OAKU / XAHT 0605	387,10	032
C273.40.R.04-06-B32-50	40	50,1	4	3,5	32	50	111	5	OAKU / XAHT 0605	400,00	040

MaxiMill – Shell mill A 273

▲ 16 cutting edges per insert





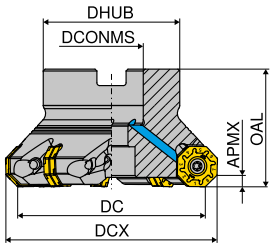
Designation	DC	DCX	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	torque moment	Insert	2B/40 Article no. 50 741 ...		2B/40 Article no. 50 741 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR		EUR	
A273.40.R.04-06	40	50,2	3	3,5	40	16	38	5	OAKU / XAHT 0605	381,40	040		
A273.40.R.04-06	40	50,2	4	3,5	40	16	38	5	OAKU / XAHT 0605	400,00	140 [5]		
A273.50.R.05-06	50	60,2	5	3,5	40	22	43	5	OAKU / XAHT 0605	448,50	050		
A273.63.R.07-06	63	73,2	7	3,5	40	22	48	5	OAKU / XAHT 0605	538,40	063		
A273.80.R.08-06	80	90,2	8	3,5	50	27	58	5	OAKU / XAHT 0605	628,10	080		
A273.80.R.10-06	80	90,2	10	3,5	50	27	58	5	OAKU / XAHT 0605			957,10	180 [1]
A273.100.R.10-06	100	110,2	10	3,5	50	32	78	5	OAKU / XAHT 0605	740,30	100		
A273.100.R.14-06	100	110,2	14	3,5	50	32	78	5	OAKU / XAHT 0605			1.223,00	200 [1]
A273.125.R.12-06	125	135,2	12	3,5	63	40	88	5	OAKU / XAHT 0605	830,00	125		
A273.125.R.17-06	125	135,2	17	3,5	63	40	88	5	OAKU / XAHT 0605			1.419,00	225 [1]
A273.160.R.14-06	160	170,2	14	3,5	63	40	104	5	OAKU / XAHT 0605	983,90	160 [4]		
A273.160.R.20-06	160	170,2	20	3,5	63	40	104	5	OAKU / XAHT 0605			1.679,00	260 [2]
A273.200.R.25-06	200	210,2	25	3,5	63	60	153	5	OAKU / XAHT 0605			2.099,00	300 [3]
A273.250.R.31-06	250	260,2	31	3,5	63	60	153	5	OAKU / XAHT 0605			2.567,00	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 IDNR	Y7 TORX® blade Article no. 80 950 ...		Y7 Clamping key – T Article no. 80 397 ...		2A/28 Clamping wedge screw Article no. 70 950 ...		2A/28 Clamping wedge Face mill Article no. 70 950 ...		Y7 Key D Article no. 80 950 ...		2A/28 Power Screw Article no. 70 950 ...		2A/28 Clamping screw Article no. 70 950 ...		Y7 Torque screwdriver Article no. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR		EUR	
50741040	4,76	037	3,91	040					9,95	114	12,48	151	4,09	302	131,90	193
50741050	4,76	037	4,24	050					9,95	114	17,14	154	4,09	302	131,90	193
50741063 - 50741125	4,76	037							9,95	114			4,09	302	131,90	193
50741140	4,76	037	3,91	040					9,95	114	12,48	151	4,09	302	131,90	193
50741160	4,76	037							9,95	114			4,09	302	131,90	193
50741180 - 50741300	4,76	036			5,90	844	23,55	845	9,28	113					131,90	193
50762032 - 50762040	4,76	037							9,95	114			4,09	302	131,90	193
5074125031	4,76	036			5,90	844	23,55	845	9,28	113					131,90	193

MaxiMill – Shell mill A 273

- 16 cutting edges per indexable insert
- Axially adjustable



Designation	DC	DCX	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	torque moment	Insert	NEW 2B/40 Article no. 50 777 ...	
	mm	mm		mm	mm	mm	mm	Nm		EUR	
A273.80.R.10A10-06	80	90,2	10	3,5	50	27	58	5	OAKU / XAHT 0605	1.258,00	**08010** [1]
A273.100.R.14A14-06	100	110,2	14	3,5	50	32	78	5	OAKU / XAHT 0605	1.713,00	**10014** [1]
A273.125.R.17A17-06	125	135,2	17	3,5	63	40	88	5	OAKU / XAHT 0605	2.014,00	**12517** [1]
A273.160.R.20A20-06	160	170,2	20	3,5	63	40	104	5	OAKU / XAHT 0605	2.378,00	**16020** [2]
A273.200.R.25A25-06	200	210,2	25	3,5	63	60	153	5	OAKU / XAHT 0605	2.974,00	**20025** [3]
A273.250.R.31A31-06	250	260,2	31	3,5	63	60	153	5	OAKU / XAHT 0605	3.652,00	**25031** [3]

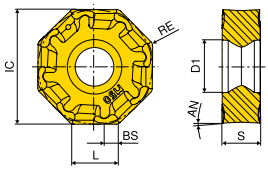
1) Version with Wedge, without internal coolant supply
2) Version with Wedge, without internal coolant supply / With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm
3) Version with Wedge, without internal coolant supply / With threaded holes M16 on the front face, pitch circle diameter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

Spare parts DC	Y7 TORX® blade	2A/28 Clamping wedge screw	2A/28 Clamping wedge Face mill	Y7 Key D	2A/28 Molykote	2A/28 Wedge	Y7 Torque screwdriver
							
	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 80 950 ...
	EUR	EUR	EUR	EUR	EUR	EUR	EUR
80 - 250	4,76 **036**	5,90 **844**	23,55 **845**	9,28 **113**	4,38 **303**	36,80 **199**	131,90 **193**

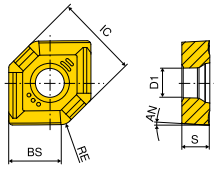
15

OAKU / XAHT

Designation	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
XAHT 0605..	17,08	6,0	-	11,95	5,56	3
OAKU 0605..	17,10	5,8	6	2,00	5,66	3

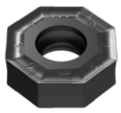
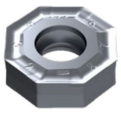


OAKU



XAHT

OAKU

	-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
	-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
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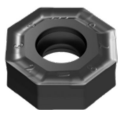
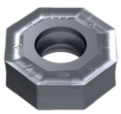
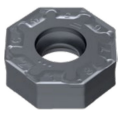
	1B/61	1B/61	1B/61	1B/61
ISO RE mm	**Article no. 51 000 ...** EUR	**Article no. 51 001 ...** EUR	**Article no. 51 000 ...** EUR	**Article no. 51 001 ...** EUR
060508SR 0,8	24,56 **258**	24,56 **258**	24,56 **058**	24,56 **058**
Steel	●	●	●	●
Stainless steel				
Cast iron				
Non ferrous metals				
Heat resistant alloys				
hardened materials				

OAKU

	-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
	-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	OAKU	OAKU	OAKU	OAKU
	1B/61	1B/61	1B/61	1B/61
ISO RE mm	**Article no. 51 000 ...** EUR	**Article no. 51 001 ...** EUR	**Article no. 51 000 ...** EUR	**Article no. 51 001 ...** EUR
060508SL 0,8				24,56 **10900**
060508SR 0,8	24,56 **008**	24,56 **008**	24,56 **108**	24,56 **108**
Steel	●	●	●	●
Stainless steel	○	○	○	○
Cast iron				
Non ferrous metals				
Heat resistant alloys				
hardened materials				

OAKU

		-F50 CTPM225		-M50 CTPM225		-F50 CTCM235		-M50 CTCM235		-F50 CTPM240		-M50 CTPM240		-F40 CTPM245	
		-F50 DPX2225		-M50 DPX2225		-F50 DCX2235		-M50 DCX2235		-F50 DPX2240		-M50 DPX2240		-F40 DPX2245	
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		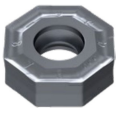				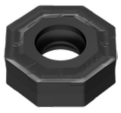		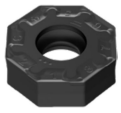						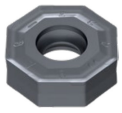	
		OAKU		OAKU		OAKU		OAKU		OAKU		OAKU		OAKU	
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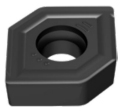
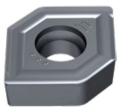
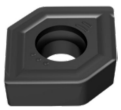
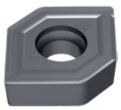
	mm	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
060508ER	0,8													30,71	458
060508SR	0,8	24,56	208	24,56	208	24,56	308	24,56	308	24,56	408	24,56	408		
Steel		○		○		○		○		○		○		●	
Stainless steel		●		●		●		●		●		●		●	
Cast iron															
Non ferrous metals															
Heat resistant alloys															
hardened materials															

OAKU

		-M50 CTCK215		-R50 CTCK215		-M50 CTPK220		-R50 CTPK220		-F40 CTC5240	
		-M50 DCX3215		-R50 DCX3215		-M50 DPX3220		-R50 DPX3220		-F40 HCF5240	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		OAKU		OAKU		OAKU		OAKU		OAKU	
		1B/61		1B/61		1B/61		1B/61		1H/D4	
ISO	RE	Article no. 51 001 ...		Article no. 51 027 ...		Article no. 51 001 ...		Article no. 51 027 ...		Article no. 50 446 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
060508ER	0,8									30,71	550
060508SL	0,8	24,56	50900			24,56	60900				
060508SR	0,8	24,56	508	24,56	508	24,56	608	24,56	608		
Steel		○		○		○		○			
Stainless steel											
Cast iron		●		●		●		●			
Non ferrous metals											
Heat resistant alloys										●	
hardened materials											

XAHT

		-M50 CTCP220	-M50 CTPP225	-M50 CTCP230	-M50 CTPP235
		-M50 DCX1220	-M50 DPX1225	-M50 DCX1230	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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		1B/61	1B/61	1B/61	1B/61
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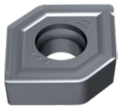
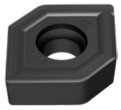
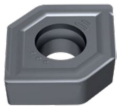
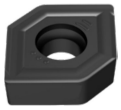
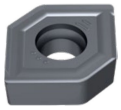
	mm	EUR	EUR	EUR	EUR
060525SR	2,5	30,41 275	30,41 075	30,41 025	30,41 125
Steel		●	●	●	●
Stainless steel				○	○
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

XAHT

		-M50 CTPM225	-M50 CTCM235	-M50 CTPM240	-M50 CTCK215	-M50 CTPK220
		-M50 DPX2225	-M50 DCX2235	-M50 DPX2240	-M50 DCX3215	-M50 DPX3220
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
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		1B/61	1B/61	1B/61	1B/61	1B/61
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	mm	EUR	EUR	EUR	EUR	EUR
060525SL	2,5				30,41 52600	
060525SR	2,5	30,41 225	30,41 325	30,41 425	30,41 525	30,41 625
Steel		○	○	○	○	○
Stainless steel		●	●	●		
Cast iron					●	●
Non ferrous metals						
Heat resistant alloys						
hardened materials						

Milling guide

Starting Parameter	→ 145	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 145

MaxiMill 273 / 273 XAHT system

Cutting data appoximate values

MaxiMill 273

	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	60–280	0,2–0,25	3,5	60–280	0,2–0,5	3,5	60–280	0,2–0,5	3,5
Stainless steel	130–240	0,2–0,5	3,5	60–270	0,2–0,5	3,5	60–270	0,2–0,5	3,5
Cast iron				130–360	0,2–0,5	3,5	130–360	0,2–0,5	3,5
Non-ferrous metals									
Heat resistant alloys	25–80	0,2–0,25	3,5	25–80	0,2–0,25	3,5	25–80	0,2–0,25	3,5
hardened materials									

Detailed information on cutting speed for each grade can be found on → page 138+139

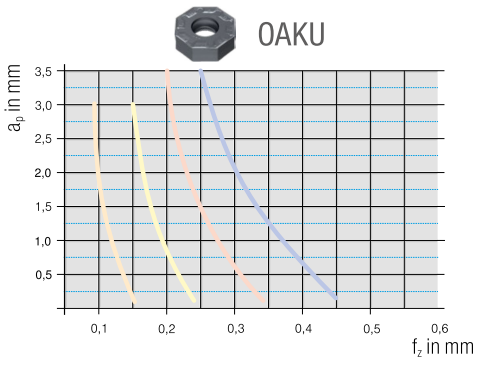
System MaxiMill 273 Wiper insert XAHT

	F			M			R		
Material	v_c m/min	f_z mm	a_p mm						
Steel	60–350	0,05–0,15	0,20–1,00						
Stainless steel	40–250	0,05–0,15	0,20–1,00						
Cast iron	70–280	0,05–0,15	0,20–1,00						
Non-ferrous metals									
Heat resistant alloys	10–100	0,05	0,20–1,00						
hardened materials									

Detailed information on cutting speed for each grade can be found on → page 138+139

Starting Parameter

Example materials				
Steel	1000 N/mm²	1.15	1.2312	40CrMnMoS 8-6
Stainless steel	600 N/mm²	2.6	1.4571	X6CrNiMoTi 1712 2
Cast iron	180 HB	3.1	EN-GJL-250	EN-GJL-250 (GG25)
Heat resistant alloys	1450 N/mm²	5.8	Inconel 625	Inconel 718



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	**OAKU 060508SR-M50**	**CTPP235** (DPX1235)	200	Dry
Stainless steel	1.4571	**OAKU 060508SR-F50**	**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301	**OAKU 060508SR-R50**	**CTCK215** (DCX3215)	250	Dry
Heat resistant alloys	2.4856	**OAKU 060508ER-F40**	**CTC5240** (HCF5240)	35	Emulsion

From v_c > 400 m/min, the tool must be balanced!