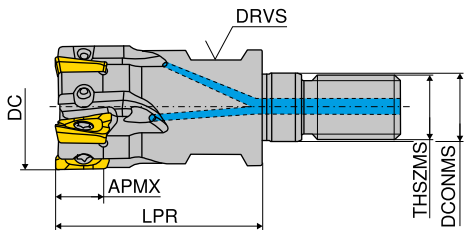
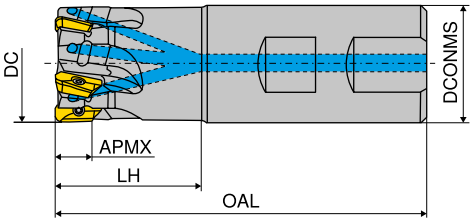
MaxiMill – Screw in cutter G 211-07



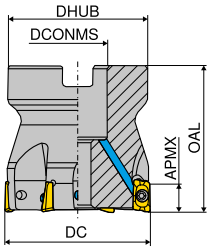
Designation	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	torque moment	Insert	2B/40 Article no. 50 751 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G211.16.R.04-07	16	4	6	27	8,5	M8	10	50400	1	XD.T 0703	268,00	016
G211.20.R.05-07	20	5	6	33	10,5	M10	15	44280	1	XD.T 0703	299,00	020
G211.25.R.06-07	25	6	6	35	12,5	M12	17	39480	1	XD.T 0703	348,80	025
G211.32.R.08-07	32	8	6	35	17,0	M16	24	36240	1	XD.T 0703	379,80	032

MaxiMill – End milling cutter C 211-07



Designation	DC	ZNF	APMX	OAL	LH	DCONMS	RPMX	torque moment	Insert	A 2B/40 Article no. 50 752 ...		B 2B/40 Article no. 50 752 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
C211.10.R.01-07-A-20	10	1	6	61,0	20	10	72000	1	XD.T 0703	212,00	010		
C211.12.R.02-07-A-20	12	2	6	66,5	20	12	66600	1	XD.T 0703	243,00	012		
C211.16.R.04-07-A/B-25	16	4	6	74,5	25	16	50400	1	XD.T 0703	268,00	016	268,00	216
C211.16.R.03-07-A-32-165	16	3	6	165,0	32	16	17760	1	XD.T 0703	249,20	116		
C211.20.R.05-07-A/B-25	20	5	6	77,0	25	20	44280	1	XD.T 0703	299,00	020	299,00	220
C211.20.R.04-07-A-40-200	20	4	6	200,0	40	20	12600	1	XD.T 0703	280,30	120		
C211.25.R.06-07-A/B20-32	25	6	6	84,0	32	20	39840	1	XD.T 0703	348,80	025	348,80	225
C211.25.R.05-07-A20-50-225	25	5	6	225,0	50	20	11280	1	XD.T 0703	311,50	125		
C211.32.R.08-07-A/B25-40	32	8	6	98,0	40	25	36240	1	XD.T 0703	379,80	032	379,80	232

MaxiMill – Shell mill A 211-07

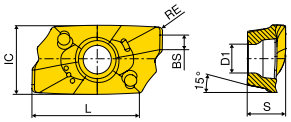


Designation	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	torque moment	Insert	2B/40 Article no. 50 753 ...		2B/40 Article no. 50 754 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.32.R.06-07	32	6	6	40	16	38	36240	1	XD.T 0703	317,90	**032**		
A211.32.R.08-07	32	8	6	40	16	38	36240	1	XD.T 0703			355,10	**032**
A211.40.R.08-07	40	8	6	40	16	38	33240	1	XD.T 0703	392,50	**040**		
A211.40.R.10-07	40	10	6	40	16	38	33240	1	XD.T 0703			429,90	**040**
A211.50.R.10-07	50	10	6	40	22	43	30480	1	XD.T 0703	467,20	**050**		
A211.50.R.12-07	50	12	6	40	22	43	30480	1	XD.T 0703			504,50	**050**

Spare parts DC	Y7 TORX® blade Article no. 80 950 ... EUR		Y7 Clamping key – T Article no. 80 397 ... EUR		Y7 Key D Article no. 80 950 ... EUR		2A/28 Power Screw Article no. 70 950 ... EUR		2A/28 Molykote Article no. 70 950 ... EUR		2A/28 Clamping screw Article no. 70 950 ... EUR		Y7 Torque screwdriver Article no. 80 950 ... EUR	
10 - 32	5,26	**051**			10,22	**124**			4,38	**303**	3,18	**137**	118,90	**191**
32	5,26	**051**	3,91	**040**	10,22	**124**	12,48	**151**	4,38	**303**	3,18	**137**	118,90	**191**
40 - 50	5,26	**051**			10,22	**124**			4,38	**303**	3,18	**137**	118,90	**191**

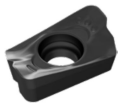
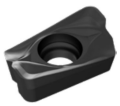
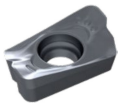
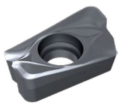
XDKT

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 0703..	4,9	2,5	7,8	1,2	3,18

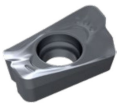
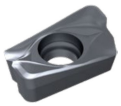
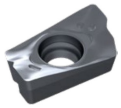


XDKT

XDKT

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 033 ...	Article no. 51 036 ...	Article no. 51 033 ...	Article no. 51 036 ...
	mm	EUR	EUR	EUR	EUR
070304SR	0,4	11,56 004	11,56 004	11,56 104	11,56 104
070308SR	0,8	11,56 008	11,56 008	11,56 108	11,56 108
Steel		●	●	●	●
Stainless steel		○	○	○	○
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

XDKT

		-F50 CTPM240	-M50 CTPM240	-F40 CTPM245	-F20 CTWN215	-F40 CTC5240	-F40 CTCS245
		-F50 DPX2240	-M50 DPX2240	-F40 DPX2245	-F20 CWK4615	-F40 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
							
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1H/17	1A/90	1H/D4	NEW 1H/D4
ISO	RE	Article no. 51 033 ...	Article no. 51 036 ...	Article no. 51 112 ...	Article no. 50 507 ...	Article no. 50 498 ...	Article no. 51 112 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
070304ER	0,4			13,81 454		13,81 544	
070304FR	0,4				13,31 504		
070304SR	0,4	11,56 404	11,56 404				
070308ER	0,8			13,81 458		13,81 548	13,81 558
070308FR	0,8				13,31 508		
070308SR	0,8	11,56 408	11,56 408				
Steel		○	○	●			
Stainless steel		●	●	●			
Cast iron					○		
Non ferrous metals					●		
Heat resistant alloys						●	●
hardened materials							

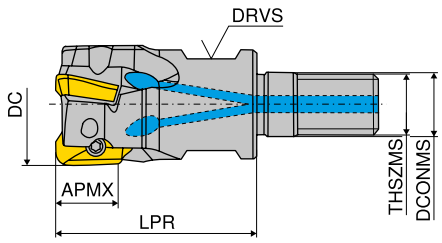
Milling guide

Machining strategy	→ 152	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 152
Starting Parameter	→ 152	Correction of the tooth load f_z	→ 157

15

MaxiMill – Screw in cutter G 211-11

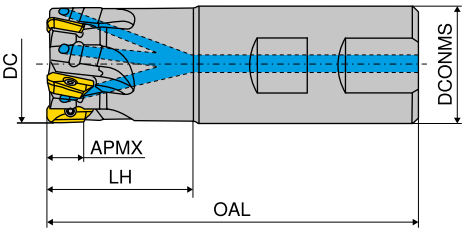
▲ Insert radius > 1,6 mm: Modify cutter body



Designation	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	torque moment	Insert	2B/40 Article no. 50 736 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G211.16.R.02-11	16	2	10	27	8,5	M8	10	42000	1,2	XD.T 11T3	230,50	016
G211.20.R.03-11	20	3	10	33	10,5	M10	15	36900	1,2	XD.T 11T3	261,70	020
G211.25.R.03-11	25	3	10	35	12,5	M12	17	33200	1,2	XD.T 11T3	274,10	12500
G211.25.R.04-11	25	4	10	35	12,5	M12	17	33200	1,2	XD.T 11T3	292,90	025
G211.32.R.04-11	32	4	10	35	17,0	M16	24	30200	1,2	XD.T 11T3	305,30	13200
G211.32.R.05-11	32	5	10	35	17,0	M16	24	30200	1,2	XD.T 11T3	324,10	032
G211.40.R.06-11	40	6	10	35	17,0	M16	27	27700	1,8	XD.T 11T3	355,10	040

MaxiMill – End milling cutter C 211-11

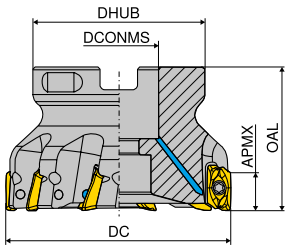
▲ Insert radius > 1,6 mm: Modify cutter body

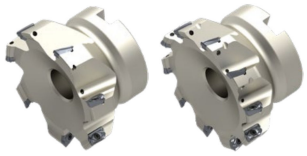


Designation	DC	ZNF	APMX	OAL	LH	DCONMS h6	RPMX	torque moment	Insert	A 2B/40 Article no. 50 737 ...		B 2B/40 Article no. 50 737 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
C211.12.R.01-11-B-20	12	1	10	75	20	16	55000	1,2	XD.T 11T3			205,60	012
C211.16.R.02-11-A/B-25	16	2	10	75	25	16	42000	1,2	XD.T 11T3	230,50	116	230,50	016
C211.16.R.02-11-A15-32-165	16	2	10	165	32	15	14800	1,2	XD.T 11T3	230,50	316		
C211.16.R.02-11-A-32-165	16	2	10	165	32	16	14800	1,2	XD.T 11T3	230,50	216		
C211.20.R.03-11-A-25	20	3	10	77	25	20	36900	1,2	XD.T 11T3	261,70	120		
C211.20.R.02-11-B-25	20	2	10	77	25	20	36900	1,2	XD.T 11T3			243,00	02002
C211.20.R.02-11-A-25	20	2	10	77	25	20	36900	1,2	XD.T 11T3	243,00	12002		
C211.20.R.03-11-B-25	20	3	10	77	25	20	36900	1,2	XD.T 11T3			261,70	020
C211.20.R.03-11-A-32-165	20	3	10	165	32	20	15800	1,2	XD.T 11T3	261,70	320		
C211.20.R.02-11-A-40-200	20	2	10	200	40	20	10500	1,2	XD.T 11T3	243,00	420		
C211.20.R.02-11-A19-40-200	20	2	10	200	40	19	10500	1,2	XD.T 11T3	243,00	620		
C211.25.R.03-11-A/B-32	25	3	10	90	32	25	33200	1,2	XD.T 11T3	274,20	625	274,20	725
C211.25.R.04-11-A/B-32	25	4	10	90	32	25	33200	1,2	XD.T 11T3	292,90	125	292,90	025
C211.25.R.04-11-A-40-165	25	4	10	165	40	25	19900	1,2	XD.T 11T3	292,90	325		
C211.25.R.03-11-A-50-225	25	3	10	225	50	25	9400	1,2	XD.T 11T3	274,20	425		
C211.25.R.02-11-A-50-225	25	2	10	225	50	25	9400	1,2	XD.T 11T3	255,60	02502		
C211.25.R.03-11-A24-50-225	25	3	10	225	50	24	9400	1,2	XD.T 11T3	274,20	825		
C211.32.R.04-11-A-40	32	4	10	102	40	32	30200	1,2	XD.T 11T3	305,30	13204		
C211.32.R.05-11-B5-40	32	5	10	102	40	25	30200	1,2	XD.T 11T3			324,10	73200
C211.32.R.04-11-B-25	32	4	10	102	40	32	30200	1,2	XD.T 11T3			305,30	83200
C211.32.R.04-11-A25-40	32	4	10	102	40	25	30200	1,2	XD.T 11T3	305,30	53204		
C211.32.R.05-11-A/B-40	32	5	10	102	40	32	30200	1,2	XD.T 11T3	324,10	132	324,10	032
C211.32.R.05-11-A-50-165	32	5	10	165	50	32	20900	1,2	XD.T 11T3	324,10	332		
C211.32.R.04-11-A-64-250	32	4	10	250	64	32	8500	1,2	XD.T 11T3	305,30	432		
C211.40.R.06-11-B32-50	40	6	10	110	50	32	27700	1,8	XD.T 11T3			355,10	04000
C211.40.R.06-11-B-50	40	6	10	122	50	40	27700	1,8	XD.T 11T3			355,10	14000

MaxiMill – Shell mill A 211-11

▲ Insert radius > 1,6 mm: Modify cutter body





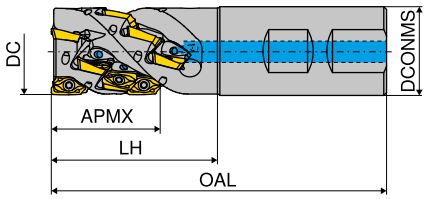
Designation	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	torque moment	Insert	2B/40 Article no. 50 738 ...		2B/40 Article no. 50 739 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.40.R.04-11	40	4	10	40	16	38	27700	1,8	XD.T 11T3	317,90	**040**		
A211.40.R.06-11	40	6	10	40	16	38	27700	1,8	XD.T 11T3			355,10	**040**
A211.50.R.05-11	50	5	10	40	22	43	25400	1,8	XD.T 11T3	373,80	**050**		
A211.50.R.08-11	50	8	10	40	22	43	25400	1,8	XD.T 11T3			430,00	**050**
A211.63.R.06-11	63	6	10	40	22	48	23300	1,8	XD.T 11T3	430,00	**063**		
A211.63.R.10-11	63	10	10	40	22	48	23300	1,8	XD.T 11T3			504,70	**063**
A211.80.R.07-11	80	7	10	50	27	58	21300	1,8	XD.T 11T3	486,10	**080**		
A211.80.R.10-11	80	10	10	50	27	58	21300	1,8	XD.T 11T3			542,10	**180**
A211.100.R.08-11	100	8	10	50	32	78	19600	1,8	XD.T 11T3	542,10	**10000**		
A211.125.R.10-11	125	10	10	63	40	88	17900	1,8	XD.T 11T3	591,90	**12500**		

Spare parts DC	Y7 TORX® blade Article no. 80 950 ...		Y7  Clamping key – T Article no. 80 397 ...		Y7 Key D Article no. 80 950 ...		2A/28  Power Screw Article no. 70 950 ...		2A/28  Molykote 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	
12	4,76	**043**			10,20	**125**			4,38	**303**	2,57	**116**	118,90	**191**
16 - 32	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**128**	118,90	**191**
40	4,76	**043**	3,91	**040**	10,20	**125**	12,48	**151**	4,38	**303**	4,09	**131**	118,90	**191**
50	4,76	**043**	4,24	**050**	10,20	**125**	17,14	**154**	4,38	**303**	4,09	**131**	118,90	**191**
63 - 125	4,76	**043**			10,20	**125**			4,38	**303**	4,09	**131**	118,90	**191**

15

MaxiMill – Extended flute cutter C 211-11K

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



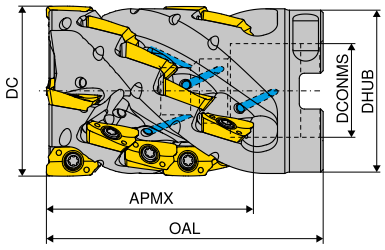
B

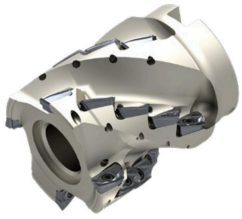
Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	torque moment Nm	Insert	2B/40 Article no. 50 758 ... EUR	
C211.25.R.02K3-11-B-40	25	2	27,0	97	40	25	6	3	1,2	XD.T 11T3	635,30	025
C211.25.R.02K4-11-B-50	25	2	37,0	107	50	25	8	4	1,2	XD.T 11T3	672,60	125
C211.25.R.02K5-11-B-60	25	2	45,5	117	60	25	10	5	1,2	XD.T 11T3	717,40	225 1)
C211.32.R.02K4-11-B-50	32	2	37,0	111	50	32	8	4	1,2	XD.T 11T3	696,80	032
C211.32.R.03K5-11-B-60	32	3	45,5	121	60	32	15	5	1,2	XD.T 11T3	840,70	132
C211.40.R.03K4-11-B32-50	40	3	37,0	110	50	32	12	4	1,8	XD.T 11T3	799,60	040
C211.40.R.04K5-11-B32-60	40	4	45,5	120	60	32	20	5	1,8	XD.T 11T3	964,00	140

1) only for profile milling

MaxiMill – Extended flute cutter A 211-11K

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





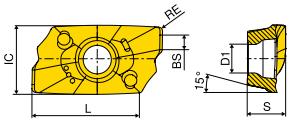
Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS H6 mm	DHUB mm	torque moment Nm	Insert	2B/40 Article no. 50 757 ... EUR	
A211.40.R.03K4-11	40	3	37,0	12	4	56	16	38	1,8	XD.T 11T3	799,60	040
A211.40.R.04K4-11	40	4	37,0	16	4	55	16	38	1,8	XD.T 11T3	874,20	140
A211.40.R.04K5-11	40	4	45,5	20	5	65	16	38	1,8	XD.T 11T3	964,00	240 1)
A211.50.R.04K5-11	50	4	45,5	20	5	65	22	43	1,8	XD.T 11T3	1.054,00	150
A211.50.R.05K5-11	50	5	45,5	25	5	65	22	43	1,8	XD.T 11T3	1.148,00	050
A211.50.R.05K6-11	50	5	54,5	30	6	74	22	43	1,8	XD.T 11T3	1.258,00	250 1)

1) only for profile milling

Spare parts	2A/28  Cylindrical screw Article no. 70 950 ... EUR		Y7 TORX® blade Article no. 80 950 ... EUR		Y7  Key D Article no. 80 950 ... EUR		2A/28  Molykote Article no. 70 950 ... EUR		2A/28  Clamping screw Article no. 70 950 ... EUR		2A/28  Socket head screw Article no. 70 950 ... EUR		Y7  Torque screwdriver Article no. 80 950 ... EUR	
25 (50758...)			4,76	043	10,20	125	4,38	303	4,09	128			118,90	191
32 - 40 (50758...)			4,76	043	10,20	125	4,38	303	4,09	131			118,90	191
40 (50757...)	9,36	001	4,76	043	10,20	125	4,38	303	4,09	131	3,14	179	118,90	191
50 (50757...)	11,50	002	4,76	043	10,20	125	4,38	303	4,09	131	5,44	180	118,90	191

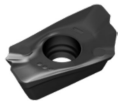
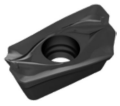
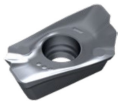
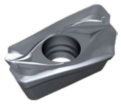
XDKT

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 11T302..	6,8	2,8	10,6	2	3,80
XDKT 11T304..	6,8	2,8	10,6	1,8	3,80
XDKT 11T308..	6,8	2,8	10,6	1,4	3,80
XDKT 11T312..	6,8	2,8	10,6	1,4	3,80
XDKT 11T316..	6,8	2,8	10,6	1,4	3,80
XDKT 11T320..	6,8	2,8	10,6	1,4	3,80
XDKT 11T325..	6,8	2,8	10,6	1,4	3,80
XDKT 11T332..	6,8	2,8	10,6	-	3,80
XDKT 11T332..	6,8	2,8	10,6	1,4	3,80
XDKT 11T332..	6,8	2,8	10,6	0,8	3,80
XDKT 11T340..	6,8	2,8	10,6	-	3,80

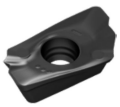
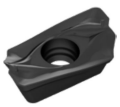
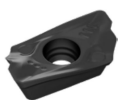
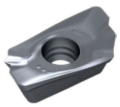
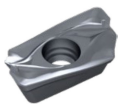
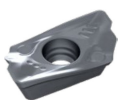


XDKT

XDKT

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 034 ...	Article no. 51 037 ...	Article no. 51 034 ...	Article no. 51 037 ...
	mm	EUR	EUR	EUR	EUR
11T308SR	0,8	14,06 258	14,06 258	14,06 058	14,06 058
Steel		●	●	●	●
Stainless steel					
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

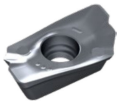
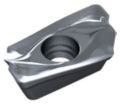
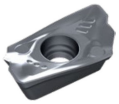
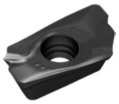
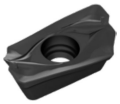
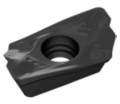
XDKT

		-F50 CTCP230	-M50 CTCP230	-R50 CTCP230	-F50 CTPP235	-M50 CTPP235	-R50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-R50 DCX1230	-F50 DPX1235	-M50 DPX1235	-R50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 034 ...	Article no. 51 037 ...	Article no. 51 039 ...	Article no. 51 034 ...	Article no. 51 037 ...	Article no. 51 039 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
11T304SR	0,4	14,06 004	14,06 004	14,06 004	14,06 104	14,06 104	14,06 104
11T308SR	0,8	14,06 008	14,06 008	14,06 008	14,06 108	14,06 108	14,06 108
11T312SR	1,2		14,06 012			14,06 112	
11T320SR	2,0	14,06 020 1)	14,06 020 1)	14,06 020 1)	14,06 120 1)	14,06 120 1)	14,06 120 1)
11T325SR	2,5	14,06 025 1)	14,06 025 1)	14,06 025 1)	14,06 125 1)	14,06 125 1)	14,06 125 1)
11T332SR	3,2				14,06 13200		
11T340SR	4,0				14,06 14000		
Steel		●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○
Cast iron							
Non ferrous metals							
Heat resistant alloys							
hardened materials							

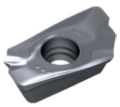
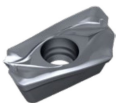
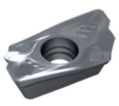
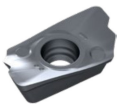
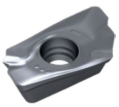
1) Insert radius > 1.6 mm: Modify cutter body

15

XDKT

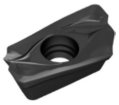
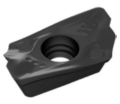
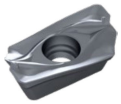
		-F50 CTPM225		-M50 CTPM225		-R50 CTPM225		-F50 CTCM235		-M50 CTCM235		-R50 CTCM235	
		-F50 DPX2225		-M50 DPX2225		-R50 DPX2225		-F50 DCX2235		-M50 DCX2235		-R50 DCX2235	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
		XDKT		XDKT		XDKT		XDKT		XDKT		XDKT	
		1B/61		1B/61		1B/61		1B/61		1B/61		1B/61	
ISO	RE	Article no. 51 034 ...		Article no. 51 037 ...		Article no. 51 039 ...		Article no. 51 034 ...		Article no. 51 037 ...		Article no. 51 039 ...	
	mm	EUR		EUR		EUR		EUR		EUR		EUR	
11T308SR	0,8	14,06	208	14,06	208	14,06	208	14,06	308	14,06	308	14,06	308
Steel		○		○		○		○		○		○	
Stainless steel		●		●		●		●		●		●	
Cast iron													
Non ferrous metals													
Heat resistant alloys													
hardened materials													

XDKT

		-F50 CTPM240		-M50 CTPM240		-R50 CTPM240		-F40 CTPM245		-F50 CTPM245	
		-F50 DPX2240		-M50 DPX2240		-R50 DPX2240		-F40 DPX2245		-F50 DPX2245	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		XDKT		XDKT		XDKT		XDKT		XDKT	
		1B/61		1B/61		1B/61		1H/17		1H/17	
ISO	RE	Article no. 51 034 ...		Article no. 51 037 ...		Article no. 51 039 ...		Article no. 51 113 ...		Article no. 51 034 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
11T304ER	0,4							18,09	454		
11T304SR	0,4			14,06	404						
11T308ER	0,8							18,09	458		
11T308SR	0,8	14,06	408	14,06	408	14,06	408			18,09	458
11T312ER	1,2							18,09	462		
11T312SR	1,2	14,06	412	14,06	412	14,06	412				
11T316ER	1,6							18,09	466		
11T320ER	2,0							18,09	470 1)		
11T320SR	2,0	14,06	420 1)	14,06	420 1)	14,06	420 1)				
11T325ER	2,5							18,09	475 1)		
11T332ER	3,2							18,09	482 1)		
11T332SR	3,2	14,06	432 1)	14,06	432 1)	14,06	432 1)				
11T340ER	4,0							18,09	490 1)		
Steel		○		○		○		●		●	
Stainless steel		●		●		●		●		●	
Cast iron											
Non ferrous metals											
Heat resistant alloys											
hardened materials											

1) Insert radius > 1.6 mm: Modify cutter body

XDKT

	-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-F20 CTWN215	-F40 CTC5240	-F40 CTCS245	-R60 CTP6215
	-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-F20 CWK4615	-F40 HCF5240		-R60 CCN6215
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	
							
	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT	XDKT
	1B/61	1B/61	1B/61	1A/90	1H/D4	NEW 1H/D4	1B/61
ISO / RE	Article no. 51 037 ...	Article no. 51 039 ...	Article no. 51 037 ...	Article no. 50 478 ...	Article no. 50 463 ...	Article no. 51 113 ...	Article no. 50 464 ...
mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
11T302FR 0,2				17,67 502			
11T304ER 0,4					18,09 504		
11T304FR 0,4				17,67 504			
11T304SR 0,4	14,06 504						
11T308ER 0,8					18,09 500	18,09 558	
11T308FR 0,8				17,67 508			
11T308SR 0,8	14,06 508	14,06 508	14,06 608				18,17 300
11T312ER 1,2					18,09 512	18,09 562	
11T316ER 1,6					18,09 516	18,09 566	
11T320ER 2,0					18,09 520 1)	18,09 570	
11T320FR 2,0				17,67 520 1)			
11T325ER 2,5					18,09 525 1)	18,09 57500 1)	
11T325FR 2,5				17,67 525 1)			
11T332ER 3,2					18,09 532 1)	18,09 582	
11T340ER 4,0					18,09 540 1)	18,09 59000 1)	
Steel	○	○	○				
Stainless steel							
Cast iron	●	●	●	○			●
Non ferrous metals				●			
Heat resistant alloys					●	●	
hardened materials							●

1) Insert radius > 1.6 mm: Modify cutter body

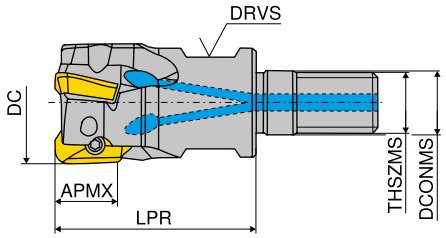
Milling guide

Machining strategy	→ 153	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 153
Starting Parameter	→ 155	Correction of the tooth load f_z	→ 157

15

MaxiMill – Screw in cutter G 211-15

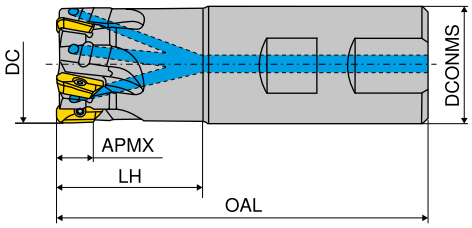
▲ Insert radius > 2,5 mm: Modify cutter body



Designation	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRVS	RPMX	torque moment	Insert	2B/40 Article no. 50 746 ...	
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G211.25.R.02-15	25	2	14	35	12,5	M12	17	26560	3,2	XD.T 1505	264,70	025
G211.32.R.03-15	32	3	14	35	17,0	M16	24	30200	3,2	XD.T 1505	294,70	032
G211.40.R.04-15	40	4	14	40	17,0	M16	27	27700	3,2	XD.T 1505	325,00	040

MaxiMill – End milling cutter C 211-15

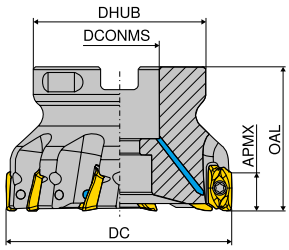
▲ Insert radius > 2,5 mm: Modify cutter body

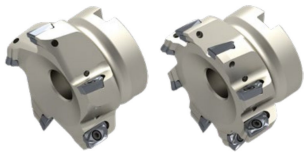


Designation	DC	ZNF	APMX	OAL	LH	DCONMS	RPMX	torque moment	Insert	A 2B/40 Article no. 50 747 ...		B 2B/40 Article no. 50 747 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
C211.25.R.02-15-B20-32	25	2	14	83	32	20	26560	3,2	XD.T 1505			264,70	125
C211.25.R.02-15-B/A-32	25	2	14	90	32	25	26560	3,2	XD.T 1505	264,70	225	264,70	025
C211.25.R.02-15-A-50-225	25	2	14	225	50	25	7520	3,2	XD.T 1505	246,70	325		
C211.32.R.03-15-B25-40	32	3	14	96	40	25	22160	3,2	XD.T 1505			294,70	132
C211.32.R.03-15-A-40	32	3	14	103	40	32	24160	3,2	XD.T 1505	294,70	232		
C211.32.R.03-15-B-40	32	3	14	103	40	32	24160	3,2	XD.T 1505			294,70	032
C211.32.R.03-15-A-63-250	32	3	14	250	63	32	6800	3,2	XD.T 1505	276,80	332		
C211.40.R.04-15-A-50	40	4	14	110	50	32	22160	3,2	XD.T 1505	325,00	240		
C211.40.R.04-15-B32-50	40	4	14	110	50	32	22160	3,2	XD.T 1505			325,00	040
C211.40.R.03-15-A-50-275	40	3	14	275	50	32	6120	3,2	XD.T 1505	306,70	340		

MaxiMill – Shell mill A 211-15

▲ Insert radius > 2,5 mm: Modify cutter body





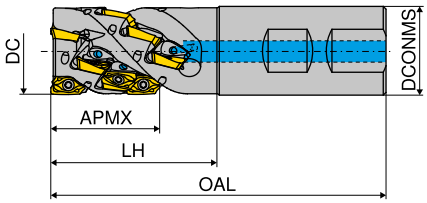
Designation	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	torque moment	Insert	2B/40 Article no. 50 748 ...		2B/40 Article no. 50 749 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
A211.40.R.03-15	40	3	14	40	16	38	22160	3,2	XD.T 1505	288,80	**040**		
A211.40.R.04-15	40	4	14	40	16	38	22160	3,2	XD.T 1505			325,00	**040**
A211.50.R.03-15	50	3	14	40	22	43	20320	3,2	XD.T 1505	342,90	**050**		
A211.50.R.05-15	50	5	14	40	22	43	20320	3,2	XD.T 1505			379,00	**050**
A211.63.R.04-15	63	4	14	45	22	48	18640	3,2	XD.T 1505	415,00	**063**		
A211.63.R.06-15	63	6	14	45	22	48	18640	3,2	XD.T 1505			451,50	**063**
A211.80.R.05-15	80	5	14	50	27	58	17040	3,2	XD.T 1505	469,20	**080**		
A211.80.R.08-15	80	8	14	50	27	58	17040	3,2	XD.T 1505			505,20	**080**
A211.100.R.06-15	100	6	14	50	32	78	15680	3,2	XD.T 1505	523,50	**100**		
A211.100.R.10-15	100	10	14	50	32	78	15680	3,2	XD.T 1505			559,50	**100**
A211.125.R.07-15	125	7	14	63	40	88	14320	3,2	XD.T 1505	553,40	**125**		
A211.125.R.11-15	125	11	14	63	40	88	14320	3,2	XD.T 1505			589,50	**125**
A211.160.R.08-15	160	8	14	63	40	93	13200	3,2	XD.T 1505	775,30	**160**		
A211.160.R.12-15	160	12	14	63	40	93	13200	3,2	XD.T 1505			811,40	**160**

Spare parts DC	Y7 TORX® blade Article no. 80 950 ...		Y7  Clamping key – T Article no. 80 397 ...		Y7  Key D Article no. 80 950 ...		2A/28  Power Screw Article no. 70 950 ...		2A/28  Molykote 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	
25 - 32	5,26	**054**			11,89	**128**			4,38	**303**	3,18	**839**	131,90	**193**
40	5,26	**054**	3,91	**040**	11,89	**128**	12,48	**151**	4,38	**303**	3,18	**839**	131,90	**193**
50	5,26	**054**	4,24	**050**	11,89	**128**	17,14	**154**	4,38	**303**	3,18	**839**	131,90	**193**
63 - 160	5,26	**054**			11,89	**128**			4,38	**303**	3,18	**839**	131,90	**193**

15

MaxiMill – Extended flute cutter C 211-15K

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



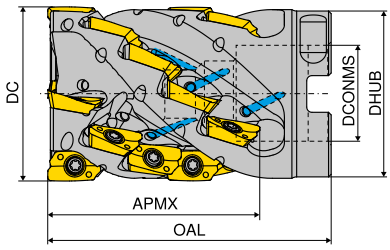
B

Designation	DC mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS mm	ZEFP	ZNP	torque moment Nm	Insert	NEW 2B/40 Article no. 50 782 ... EUR	
C211.40.R.02K3-15-B32-60	40	2	38,0	120	60	32	6	3	3,2	XD.T 1505	773,60	**04002**
C211.50.R.03K4-15-B40-64	50	3	50,5	134	64	40	12	4	3,2	XD.T 1505	904,40	**05003**

Spare parts DC	Y7 Key D Article no. 80 950 ... EUR		2A/28 Clamping screw Article no. 70 950 ... EUR	
40 - 50	9,15	**120**	3,18	**839**

MaxiMill – Extended flute cutter A 211-15K

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

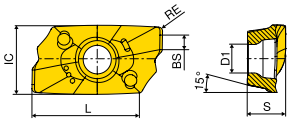


Designation	DC mm	ZNF	APMX mm	ZEFP	ZNP	OAL mm	DCONMS H6 mm	DHUB mm	torque moment Nm	Insert	2B/40 Article no. 50 759 ... EUR	
A211.50.R.03K4-15	50	3	50,5	12	4	74	22	43	3,2	XD.T 1505	904,40	**050**
A211.50.R.03K5-15	50	3	63,0	15	5	88	22	43	3,2	XD.T 1505	960,40	**150**
A211.63.R.03K4-15	63	3	50,5	12	4	74	27	58	3,2	XD.T 1505	986,00	**063**
A211.63.R.04K6-15	63	4	75,5	24	6	102	27	58	3,2	XD.T 1505	1.210,00	**163**
A211.80.R.04K5-15	80	4	63,0	20	5	88	32	78	3,2	XD.T 1505	1.216,00	**080**
A211.80.R.05K6-15	80	5	75,5	30	6	102	32	78	3,2	XD.T 1505	1.404,00	**180**

Spare parts DC	2A/28 Cylindrical screw Article no. 70 950 ... EUR		Y7 TORX® blade Article no. 80 950 ... EUR		Y7 Key D Article no. 80 950 ... EUR		2A/28 Molykote Article no. 70 950 ... EUR		2A/28 Clamping screw Article no. 70 950 ... EUR		2A/28 Socket head screw Article no. 70 950 ... EUR		Y7 Torque screwdriver Article no. 80 950 ... EUR	
50	11,50	**002**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	5,44	**180**	131,90	**193**
63	15,95	**003**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	8,45	**181**	131,90	**193**
80	25,73	**004**	5,26	**054**	11,89	**128**	4,38	**303**	3,18	**839**	11,50	**234**	131,90	**193**

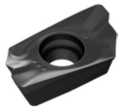
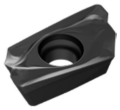
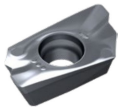
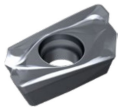
XDKT

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 150508..	9,3	4,4	14,8	1,6	5,56
XDKT 150512..	9,3	4,4	14,8	1,6	5,56
XDKT 150516..	9,3	4,4	14,8	1,6	5,56
XDKT 150520..	9,3	4,4	14,8	1,6	5,56
XDKT 150530..	9,3	4,4	14,8	1,6	5,56
XDKT 150532..	9,3	4,4	14,8	1,9	5,56
XDKT 150540..	9,3	4,4	14,8	1,2	5,56

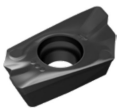
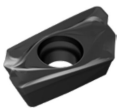
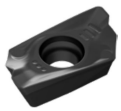
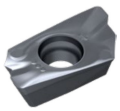
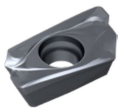
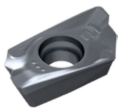


XDKT

XDKT

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		XDKT	XDKT	XDKT	XDKT
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 035 ...	Article no. 51 038 ...	Article no. 51 035 ...	Article no. 51 038 ...
	mm	EUR	EUR	EUR	EUR
150508SR	0,8	18,75 258	18,75 258	18,75 058	18,75 058
Steel		●	●	●	●
Stainless steel					
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

XDKT

		-F50 CTCP230	-M50 CTCP230	-R50 CTCP230	-F50 CTPP235	-M50 CTPP235	-R50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-R50 DCX1230	-F50 DPX1235	-M50 DPX1235	-R50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
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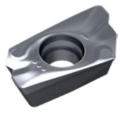
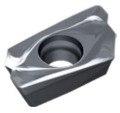
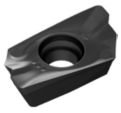
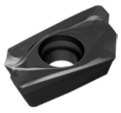
		1B/61	1B/61	1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 035 ...	Article no. 51 038 ...	Article no. 51 040 ...	Article no. 51 035 ...	Article no. 51 038 ...	Article no. 51 040 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
150508SR	0,8	18,75 008	18,75 008	18,75 008	18,75 108	18,75 108	18,75 108
150512SR	1,2		18,75 012			18,75 112	
150516SR	1,6		18,75 016			18,75 116	
150520SR	2,0			18,75 020		18,75 120	18,75 120
150530SR	3,0		18,75 030			18,75 130	
150540SR	4,0		18,75 040			18,75 140	
Steel		●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○
Cast iron							
Non ferrous metals							
Heat resistant alloys							
hardened materials							

15

XDKT

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-M50 DCX2235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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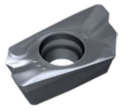
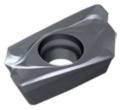
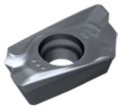
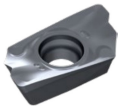
		1B/61	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 035 ...	Article no. 51 038 ...	Article no. 51 035 ...	Article no. 51 038 ...
	mm	EUR	EUR	EUR	EUR
150508SR	0,8	18,75 208	18,75 208	18,75 308	18,75 308
Steel		○	○	○	○
Stainless steel		●	●	●	●
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

XDKT

		-F50 CTPM240	-M50 CTPM240	-R50 CTPM240	-F40 CTPM245
		-F50 DPX2240	-M50 DPX2240	-R50 DPX2240	-F40 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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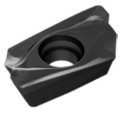
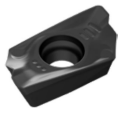
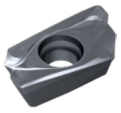
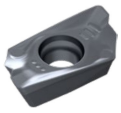
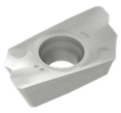
		1B/61	1B/61	1B/61	1H/17
ISO	RE	Article no. 51 035 ...	Article no. 51 038 ...	Article no. 51 040 ...	Article no. 51 114 ...
	mm	EUR	EUR	EUR	EUR
150508ER	0,8				22,57 458
150508SR	0,8	18,75 408	18,75 408	18,75 408	
150512SR	1,2		18,75 412		
150516SR	1,6		18,75 416		
150530SR	3,0		18,75 430		
150532ER	3,2				22,57 482 1)
150540ER	4,0				22,57 490 1)
150540SR	4,0		18,75 440		
Steel		○	○	○	●
Stainless steel		●	●	●	●
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

1) Insert radius >1.6 mm: Modify cutter body

XDKT

		-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F20 CTWN215
		-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-R50 DPX3220	-F20 CWK4615
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
						
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		1B/61	1B/61	1B/61	1B/61	1A/90
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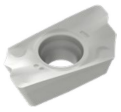
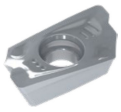
	mm	EUR	EUR	EUR	EUR	EUR
150508FR	0,8					22,16 508
150508SR	0,8	18,75 508	18,75 508	18,75 608	18,75 608	
Steel		○	○	○	○	
Stainless steel						
Cast iron		●	●	●	●	○
Non ferrous metals						●
Heat resistant alloys						
hardened materials						

XDKT

		-F40 CTC5240	-F40 CTCS245	-R60 CTP6215
		-F40 HCF5240		-R60 CCN6215
		DRAGONSKIN	DRAGONSKIN	
				
		XDKT	XDKT	XDKT
		1H/D4	NEW 1H/D4	1B/61
ISO	RE	Article no. 50 473 ...	Article no. 51 114 ...	Article no. 50 469 ...
	mm	EUR	EUR	EUR
150508ER	0,8	22,57 508	22,57 558	
150508SR	0,8			18,75 300
150532ER	3,2	22,57 532 [1)]		
150540ER	4,0	22,57 540 [1)]	22,57 59000 [1)]	
Steel				
Stainless steel				
Cast iron				●
Non ferrous metals				
Heat resistant alloys		●	●	
hardened materials				●

1) Insert radius >2.5 mm: Modify cutter body

Milling guide

Machining strategy	→ 154	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 154
Starting Parameter	→ 155	Correction of the tooth load f_z	→ 157

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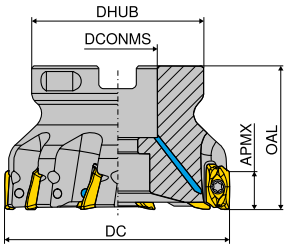
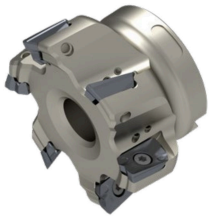
MaxiMill – Shell mill A 211-20

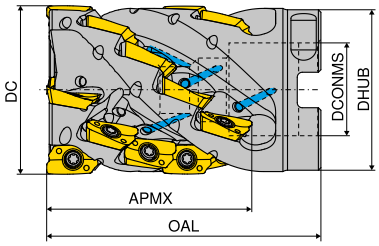




Designation	DC	ZNF	APMX	OAL	DCONMS $_{H6}$	DHUB	RPMX	torque moment	Insert	NEW 2B/40 Article no. 50 778 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm			
A211.63.R.05-20	63	5	19	45	22	48	14400	5	XD.. 2007..	434,10	**06305**
A211.80.R.06-20	80	6	19	50	27	58	12400	5	XD.. 2007..	464,30	**08006**
A211.100.R.07-20	100	7	19	50	32	78	10900	5	XD.. 2007..	498,20	**10007**

MaxiMill – Extended flute cutter A 211-20K

- ZEFP = Number of Inserts
- ZNP = Number of rows

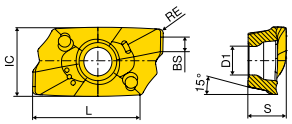


Designation	DC	ZNF	APMX	ZEFP	ZNP	OAL	DCONMS $_{H6}$	DHUB	torque moment	Insert	NEW 2B/40 Article no. 50 780 ... EUR	
	mm		mm			mm	mm	mm	Nm			
A211.63.R.04K4-20	63	4	68	16	4	92	27	58	3,2	XD.. 2007..	961,40	**06304**
A211.80.R.05K4-20	80	5	68	20	4	92	32	76	3,2	XD.. 2007..	1.078,00	**08005**

	2A/28		Y7		Y7		2A/28		2A		2A/28		Y7	
														
	Cylindrical screw		TORX® blade		Key D		Molykote		Clamping screw		Socket head screw		Torque screwdriver	
Spare parts DC	**Article no. 70 950 ...** EUR		**Article no. 80 950 ...** EUR		**Article no. 80 950 ...** EUR		**Article no. 70 950 ...** EUR		**Article no. 70 950 ...** EUR		**Article no. 70 950 ...** EUR		**Article no. 80 950 ...** EUR	
63	15,95	**003**	4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**	8,45	**181**	131,90	**193**
80	25,73	**004**	4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**	11,50	**234**	131,90	**193**
100			4,76	**037**	7,52	**106**	4,38	**303**	2,52	**280**			131,90	**193**

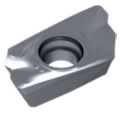
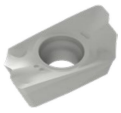
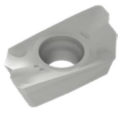
XDKT

Designation	IC	D1	L	S
	mm	mm	mm	mm
XDKT 200708..	12,5	5,5	18,8	6,93
XDKT 200732..	12,5	5,5	18,8	6,82



XDKT

XDKT

ISO	RE	-F40 CTPM245		-F40 CTC5240		-F40 CTCS245	
				DRAGONSKIN		DRAGONSKIN	
		 XDKT		 XDKT		 XDKT	
		NEW 1H/17		NEW 1H/D4		NEW 1H/D4	
		Article no. 51 127 ...		Article no. 51 127 ...		Article no. 51 127 ...	
	mm	EUR		EUR		EUR	
200708ER	0,8	26,69	45800	26,69	15800	26,69	55800
200732ER	3,2			26,69	18200		
Steel		●					
Stainless steel		●					
Cast iron							
Non ferrous metals							
Heat resistant alloys				●		●	
hardened materials							

Milling guide

Machining strategy	→ 156	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 156
Starting Parameter	→ 156	Correction of the tooth load f_z	→ 157

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System MaxiMill 211-07

Cutting data recommendations/Technology data

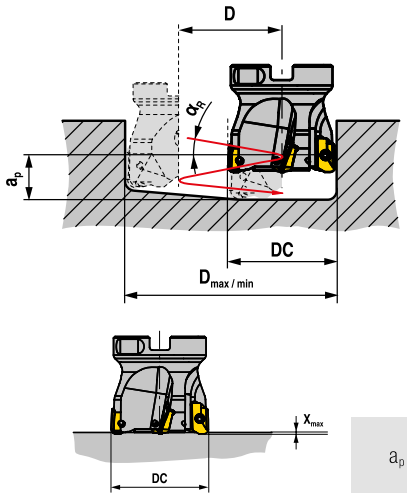
for standard inserts

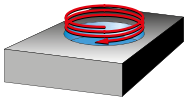
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	50–340	0,1–0,2	6	50–340	0,1–0,2	6	50–340	0,1–0,2	6
Stainless steel	60–280	0,05–0,2	6	60–280	0,05–0,3	6	60–280	0,1–0,3	6
Cast iron				100–360	0,1–0,3	6	100–360	0,1–0,3	6
Non-ferrous metals	160–1500	0,1–0,2	6	160–1500	0,1–0,2	6	160–1500	0,1–0,2	6
Heat resistant alloys	25–75	0,05–0,15	6	25–75	0,05–0,15	6	25–75	0,05–0,15	6
hardened materials									

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

Machining strategy

Helical plunge milling



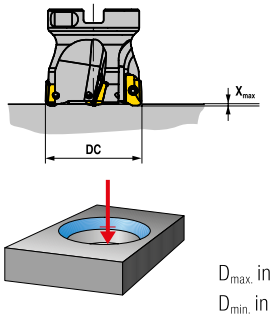


DC mm	D_{max} / RE 0,4 mm	D_{min} mm	$\alpha_{R\,max}$ °
10	19	13	5,5
12	23	17	6,0
16	31	25	3,0
20	39	33	2,0
25	49	43	1,5
32	63	57	1,2
40	79	73	0,8
50	99	93	0,7

DC mm	D mm	$\alpha_{R\,max\,360°}$ °
10	13	5,5
12	17	6,0
16	25	3,0
20	33	2,0
25	43	1,5
32	57	1,2
40	73	0,8
50	93	0,7

a_p in mm = $D * \pi * \tan \alpha_R$

Axial plunging

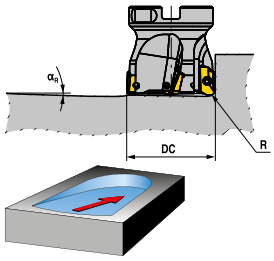


DC mm	X_{max} mm
10	0,8
12	0,8
16	0,8
20	0,8
25	0,8
32	0,8
40	0,8
50	0,8

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

$D_{min.}$ in mm = smallest hole diameter for flat bottom surface

Angled ramping



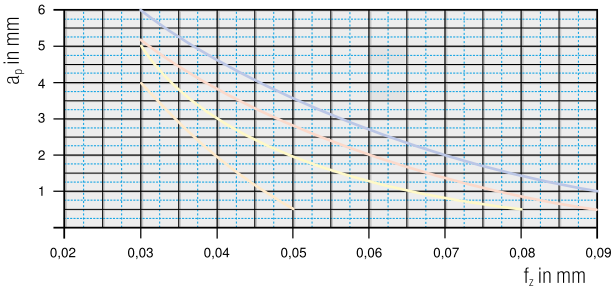
DC mm	α °
10	11,0
12	7,9
16	4,3
20	3,0
25	2,5
32	1,6
40	1,2
50	1,0

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

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

XDKT 07



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	**XDKT070308SR-M50**	**CTPP235** (DPX1235)	200	Dry
Stainless steel	1.4571	**XDKT070308SR-F50**	**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301		**CTCK215** (DCX3215)	250	Dry
Heat resistant alloys	2.4856	**XDKT070308ER-F40**	**CTC5240** (HCF5240)	35	Emulsion

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

System MaxiMill 211-11

Cutting data recommendations/Technology data

for standard inserts

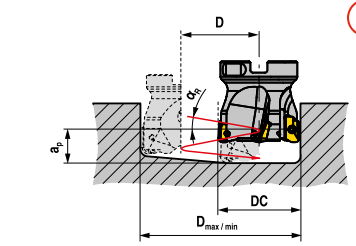
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	50–340	0,1–0,2	10	50–340	0,1–0,2	10	50–340	0,1–0,2	10
Stainless steel	60–280	0,05–0,2	10	60–280	0,05–0,25	10	60–280	0,1–0,25	10
Cast iron				100–360	0,1–0,25	10	100–360	0,1–0,25	10
Non-ferrous metals	160–1500	0,1–0,2	10	160–1500	0,1–0,2	10	160–1500	0,1–0,2	10
Heat resistant alloys	25–75	0,05–0,15	10	25–75	0,05–0,15	10	25–75	0,05–0,15	10
hardened materials				40–60	0,05–0,2	10			

for shell end mill

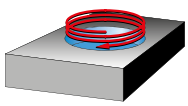
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	100–300	0,05–0,20	≤ APMX						
Stainless steel	80–200	0,05–0,20	≤ APMX						
Cast iron	110–300	0,05–0,20	≤ APMX						
Non-ferrous metals	300–2000	0,10–0,25	≤ APMX						
Heat resistant alloys	40–80	0,05–0,15	≤ APMX						
hardened materials	30–50	0,05–0,10	≤ APMX						

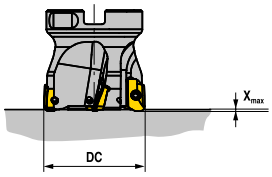
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

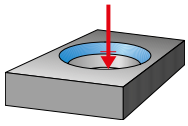


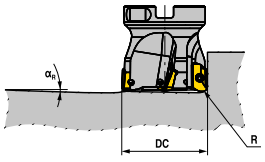
1 Helical plunge milling



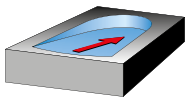


2 Axial plunging





3 Angled ramping



DC mm	1 Helical plunge milling RE = 0,8 mm		2 Axial plunging X_{max}	3 Angled ramping α_R
12	α_R	16°	1,3 mm	18°
	D_{max}	21 mm		
	D_{min}	14 mm		
16	α_R	9,5°	1,5 mm	10,8°
	D_{max}	29 mm		
	D_{min}	21 mm		
20	α_R	7°	2,0 mm	9,8°
	D_{max}	37 mm		
	D_{min}	30 mm		
25	α_R	4,5°	2,0 mm	7,5°
	D_{max}	47 mm		
	D_{min}	40 mm		
32	α_R	3,2°	1,0 mm	4,8°
	D_{max}	61 mm		
	D_{min}	53 mm		
40	α_R	2,2°	1,6 mm	2,9°
	D_{max}	77 mm		
	D_{min}	72 mm		
50	α_R	1,7°	1,6 mm	2,2°
	D_{max}	98 mm		
	D_{min}	93 mm		
63	α_R	1,5°	1,6 mm	1,8°
	D_{max}	123 mm		
	D_{min}	116 mm		
80	α_R	1,0°	1,6 mm	1,4°
	D_{max}	157 mm		
	D_{min}	153 mm		
100	α_R	0,8°	1,6 mm	1,1°
	D_{max}	107 mm		
	D_{min}	101 mm		

	maximum rpm based on overhang length. n_{max} in min^{-1}				
DC mm	l_a = 1–2 x Ø mm	l_a = 2,5 x Ø mm	l_a = 3 x Ø mm	l_a = 4 x Ø mm	l_a = 5 x Ø mm
12	55000	51500	47000	42000	37000
16	42000	38500	34100	28900	24200
20	36900	33000	28500	23900	19500
25	33200	29000	24400	19900	15400
32	30200	26000	20900	16600	11900
40	27700	23000	18000	13500	9000
50	25400	20400	15400	10800	6100
63	23300	18300	12900	8300	3700
80	21300	16100	10600	5800	
100	19600	14100	8400		

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

a_p in mm = D x π x tan (α_R) = Pitch

l_a in mm = Overhang length

System MaxiMill 211-15

Cutting data recommendations/Technology data

for standard inserts

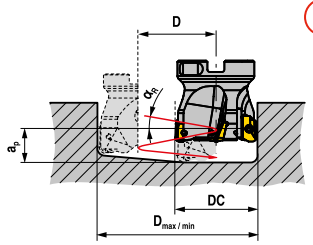
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	50-340	0,1-0,2	14	50-340	0,1-0,2	14	50-340	0,1-0,2	14
Stainless steel	60-280	0,05-0,2	14	60-280	0,05-0,25	14	60-280	0,1-0,25	14
Cast iron				100-360	0,1-0,25	14	100-360	0,1-0,25	14
Non-ferrous metals	160-1500	0,1-0,2	14	160-1500	0,1-0,2	14	160-1500	0,1-0,2	14
Heat resistant alloys	25-75	0,05-0,15	14	25-75	0,05-0,15	14	25-75	0,05-0,15	14
hardened materials				40-60	0,05-0,2	14			

for shell end mill

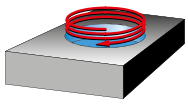
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel	120-300	0,08-0,35	≤ APMX						
Stainless steel	150-200	0,08-0,35	≤ APMX						
Cast iron	130-300	0,08-0,35	≤ APMX						
Non-ferrous metals	400-2500	0,12-0,40	≤ APMX						
Heat resistant alloys	25-80	0,08-0,20	≤ APMX						
hardened materials									

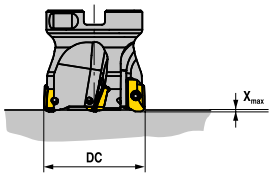
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

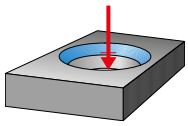


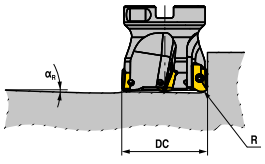
1 Helical plunge milling



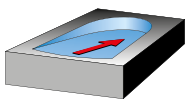


2 Axial plunging





3 Angled ramping



DC mm	1 Helical plunge milling	RE = 0,8 mm	2 Axial plunging X_{max}	3 Angled ramping α_R
25	α_R	7,5°	2,7 mm	9,5°
	D_{max}	48 mm		
	D_{min}	37 mm		
32	α_R	5°	2,5 mm	6,8°
	D_{max}	62 mm		
	D_{min}	47 mm		
40	α_R	3,2°	2,5 mm	5,1°
	D_{max}	78 mm		
	D_{min}	63 mm		
50	α_R	2,5°	2,5 mm	2,5°
	D_{max}	98 mm		
	D_{min}	86 mm		
63	α_R	1,5°	2,5 mm	2,5°
	D_{max}	124 mm		
	D_{min}	111 mm		
80	α_R	1,3°	2,5 mm	2,0°
	D_{max}	158 mm		
	D_{min}	147 mm		
100	α_R	1,1°	2,5 mm	1,5°
	D_{max}	198 mm		
	D_{min}	190 mm		
125	α_R	0,9°	2,5 mm	0,9°
	D_{max}	248 mm		
	D_{min}	240 mm		
160	α_R	0,6°	2,5 mm	0,7°
	D_{max}	318 mm		
	D_{min}	310 mm		

DC mm	maximum rpm based on overhang length. n_{max} in min^{-1} $l_a = 2 \times Ø$ mm	$l_a = 3 \times Ø$ mm	$l_a = 5 \times Ø$ mm
25	26560	19520	13320
32	24160	16720	9520
40	22160	14400	7200
50	20320	12320	4880
63	18640	10320	2960
80	17040	8480	
100	15680	6720	
125	14320		
160	13200		

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

a_p in mm = $D \times \pi \times \tan(\alpha_R)$ = Pitch

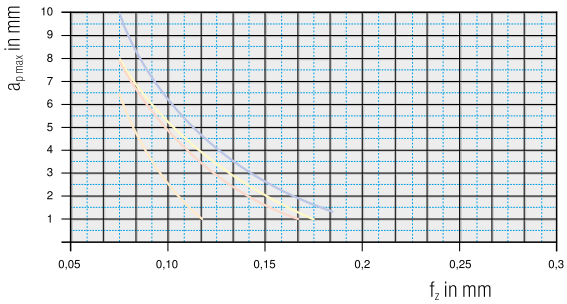
l_a in mm = Overhang length

System MaxiMill 211-11

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

XDKT 11



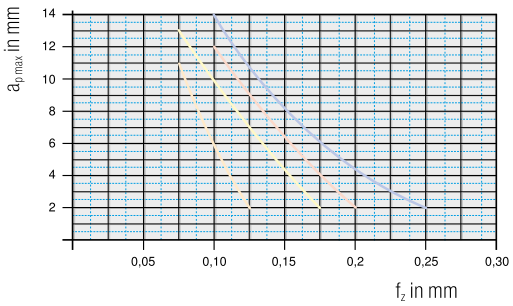
Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	**XDKT11T308SR-M50**	**CTPP235** (DPX1235)	200	Dry
Stainless steel	1.4571	**XDKT11T308SR-F50**	**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301	**XDKT11T308SR-R50**	**CTCK215** (DCX3215)	250	Dry
Heat resistant alloys	2.4856	**XDKT11T308ER-F50**	**CTC5240** (HCF5240)	35	Emulsion

System MaxiMill 211-15

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

XDKT 15



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	**XDKT150508SR-M50**	**CTPP235** (DPX1235)	200	Dry
Stainless steel	1.4571		**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301	**XDKT150508SR-R50**	**CTCK215** (DCX3215)	250	Dry
Heat resistant alloys	2.4856	**XDKT150508ER-F40**	**CTC5240** (HCF5240)	35	Emulsion

15

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

System MaxiMill 211-20

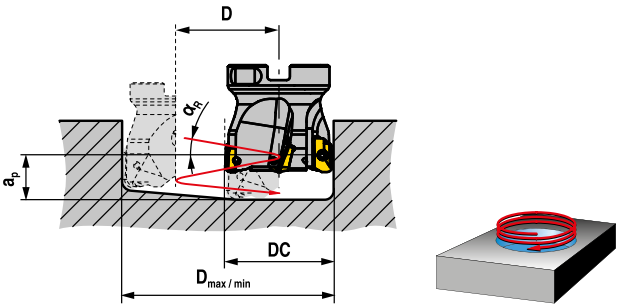
Cutting data recommendations/Technology data
for standard inserts

	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									
Stainless steel	130–280	0,08–0,2	19	130–280	0,08–0,3	19	180–280	0,1–0,25	19
Cast iron									
Non-ferrous metals									
Heat resistant alloys	25–80	0,08–0,2	19	25–80	0,08–0,3	19	25–80	0,1–0,15	19
hardened materials									

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

Machining strategy

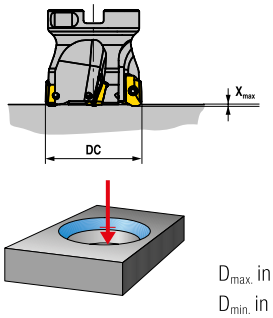
Helical plunge milling



DC mm	D_{max} / RE 0,4 mm	D_{min} mm	$\alpha_{R\,max}$ °
63	124	107	2,2
80	158	143	1,7
100	198	183	1,3

a_p in mm = $D * \pi * \tan \alpha_R$

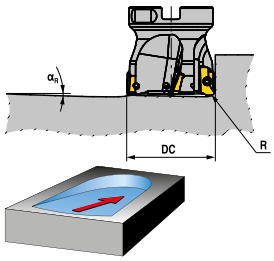
Axial plunging



DC mm	X_{max} mm
63	2,0
80	2,0
100	2,0

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

Angled ramping



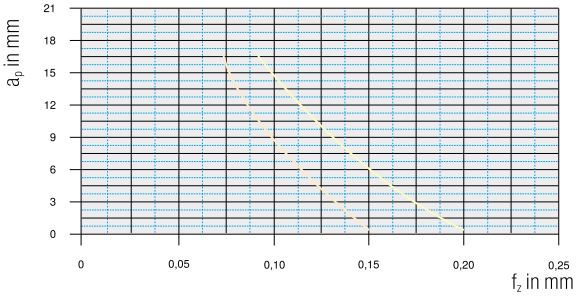
DC mm	α °
63	2,2
80	1,7
100	1,3

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

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

XDKT 20



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312				
Stainless steel	1.4571	**XDKT200708ER-F40**	**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301				
Heat resistant alloys	2.4856	**XDKT200708ER-F40**	**CTC5240** (HCF5240)	35	Emulsion

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