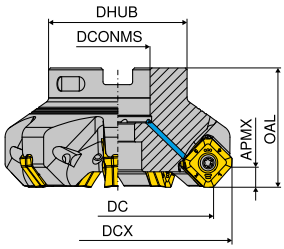
MaxiMill – A 271 Face mill

▲ 8 cutting edges per insert



Designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DCONMS mm	DHUB mm	torque moment Nm	Insert	2B/40 Article no. 50 767 ... EUR	
A271.50.R.04-17	50	66,1	4	8,4	40	22	43	5	SAKU 1706	397,70	**050**
A271.63.R.06-17	63	79,1	6	8,4	40	22	48	5	SAKU 1706	558,90	**063**
A271.80.R.07-17	80	96,1	7	8,4	50	27	58	5	SAKU 1706	639,50	**080**
A271.100.R.08-17	100	116,1	8	8,4	50	32	78	5	SAKU 1706	736,30	**100**
A271.125.R.10-17	125	141,1	10	8,4	63	40	88	5	SAKU 1706	849,00	**125**
A271.160.R.12-17	160	176,1	12	8,4	63	40	104	5	SAKU 1706	999,60	**16000** [1]
A271.200.R.13-17	200	216,1	13	8,4	63	60	134	5	SAKU 1706	1.236,00	**20000** [2]
A271.250.R.15-17	250	266,1	15	8,4	63	60	134	5	SAKU 1706	1.494,00	**25000** [2]

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

Spare parts DC	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		Y7 Torque screwdriver Article no. 80 950 ... EUR	
50 - 250	4,76	**037**	9,95	**114**	4,38	**303**	4,09	**302**	131,90	**193**

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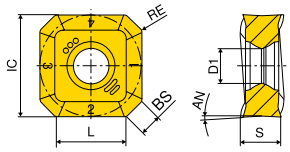
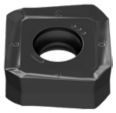
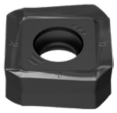
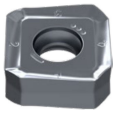
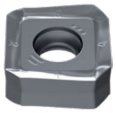
SAKU

Designation	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
SAKU 1706..	17	5,8	11,85	3,7	6,35	3



SAKU

SAKU

		-F50 CTCP220	-M50 CTCP220	-F50 CTPP225	-M50 CTPP225
		-F50 DCX1220	-M50 DCX1220	-F50 DPX1225	-M50 DPX1225
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
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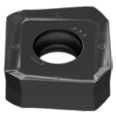
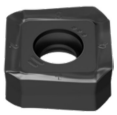
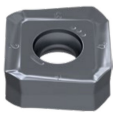
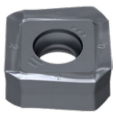
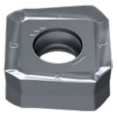
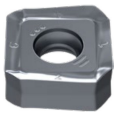
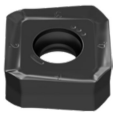
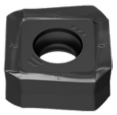
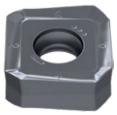
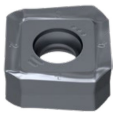
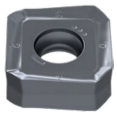
ISO	RE	Article no. 51 004 ...	Article no. 51 005 ...	Article no. 51 004 ...	Article no. 51 005 ...
	mm	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 270	29,13 270	29,13 070	29,13 070
Steel		●	●	●	●
Stainless steel					
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

SAKU

		-F50 CTCP230	-M50 CTCP230	-F50 CTPP235	-M50 CTPP235
		-F50 DCX1230	-M50 DCX1230	-F50 DPX1235	-M50 DPX1235
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		SAKU 1B/61	SAKU 1B/61	SAKU 1B/61	SAKU 1B/61
ISO	RE	Article no. 51 004 ...	Article no. 51 005 ...	Article no. 51 004 ...	Article no. 51 005 ...
	mm	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 020	29,13 020	29,13 120	29,13 120
Steel		●	●	●	●
Stainless steel		○	○	○	○
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

SAKU

		-F50 CTPM225	-M50 CTPM225	-F50 CTCM235	-M50 CTCM235	-F50 CTPM240	-M50 CTPM240	-F50 CTPM245
		-F50 DPX2225	-M50 DPX2225	-F50 DCX2235	-M50 DCX2235	-F50 DPX2240	-M50 DPX2240	-F50 DPX2245
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
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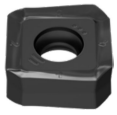
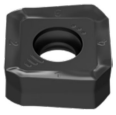
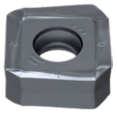
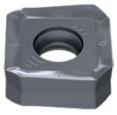
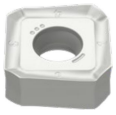
		1B/61	1B/61	1B/61	1B/61	1B/61	1B/61	1H/17
ISO	RE	Article no. 51 004 ...	Article no. 51 005 ...	Article no. 51 004 ...	Article no. 51 005 ...	Article no. 51 004 ...	Article no. 51 005 ...	Article no. 51 004 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 220	29,13 220	29,13 320	29,13 320	29,13 420	29,13 420	35,84 470
Steel		○	○	○	○	○	○	●
Stainless steel		●	●	●	●	●	●	●
Cast iron								
Non ferrous metals								
Heat resistant alloys								
hardened materials								

SAKU

		-M50 CTCK215	-R50 CTCK215	-M50 CTPK220	-R50 CTPK220	-F50 CTC5240	-F50 CTCS245
		-M50 DCX3215	-R50 DCX3215	-M50 DPX3220	-R50 DPX3220	-F50 HCF5240	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		SAKU	SAKU	SAKU	SAKU	SAKU	SAKU
		1B/61	1B/61	1B/61	1B/61	1H/D4	NEW 1H/D4
ISO	RE	Article no. 51 005 ...	Article no. 51 058 ...	Article no. 51 005 ...	Article no. 51 058 ...	Article no. 50 306 ...	Article no. 51 004 ...
	mm	EUR	EUR	EUR	EUR	EUR	EUR
1706ABSR	0,8	29,13 520	29,13 520	29,13 620	29,13 620	35,84 520	35,84 570
Steel		○	○	○	○		
Stainless steel							
Cast iron		●	●	●	●		
Non ferrous metals							
Heat resistant alloys						●	●
hardened materials							

Milling guide

Starting Parameter	→ 144	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 144

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System MaxiMill 271

Cutting data appoximate values

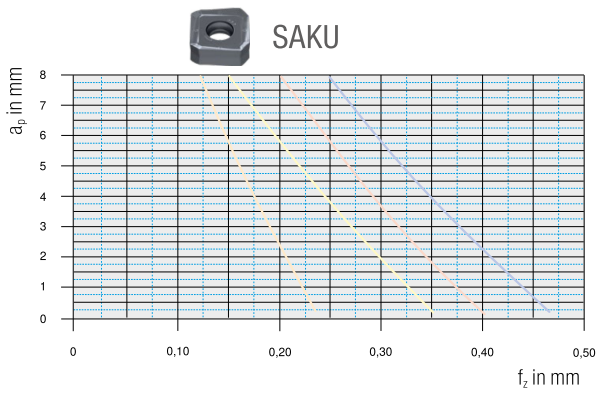
MaxiMill 271

	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	0,2–0,3	8,4	50–340	0,2–0,5	8,4	50–340	0,2–0,5	8,4
Stainless steel	60–270	0,2–0,3	8,4	60–270	0,2–0,5	8,4	60–270	0,2–0,5	8,4
Cast iron				130–360	0,2–0,5	8,4	130–360	0,2–0,5	8,4
Non-ferrous metals									
Heat resistant alloys	25–80	0,2–0,3	8,4	25–80	0,2–0,3	8,4	25–80	0,2–0,3	8,4
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	**SAKU 1706ABSR-M50**	**CTPP235** (DPX1235)	200	Dry
Stainless steel	1.4571	**SAKU 1706ABSR-F50**	**CTPM240** (DPX2240)	180	Dry
Cast iron	5.1301	**SAKU 1706ABSR-R50**	**CTCK215** (DCX3215)	250	Dry
Heat resistant alloys	2.4856	**SAKU 1706ABSR-F50**	**CTC5240** (HCF5240)	35	Emulsion

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