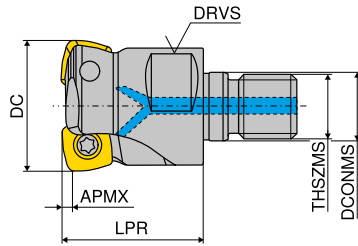
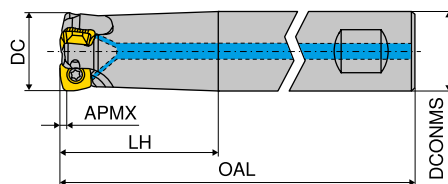


MaxiMill – Screw in cutter G HFC



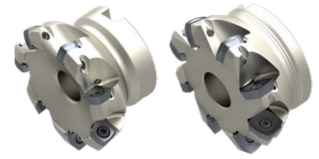
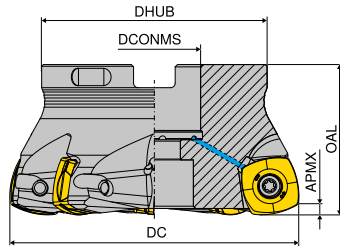
Designation	DC	ZNF	APMX	LPR	DCONMS	THSZMS	DRV	RPMX	torque moment	Insert	Article no. 50 682 ...	2B/40
	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
GHFC.16.R.02-06	16	2	0,8	27	8,5	M8	10	20800	1,2	XPLX 0603..	230,50	616
GHFC.20.R.03-06	20	3	0,8	33	10,5	M10	15	19800	1,2	XPLX 0603..	261,70	620
GHFC.25.R.04-06	25	4	0,8	35	12,5	M12	17	18700	1,2	XPLX 0603..	292,90	625
GHFC.32.R.05-06	32	5	0,8	35	17,0	M16	24	22000	1,2	XPLX 0603..	324,10	632
GHFC.42.R.07-06	42	7	0,8	35	17,0	M16	24	15000	1,2	XPLX 0603..	356,60	04207
GHFC.25.R.02-09	25	2	1,0	35	12,5	M12	17	30000	3,2	XDLX 09T3..	276,00	025
GHFC.25.R.03-09	25	3	1,0	35	12,5	M12	17	30000	3,2	XDLX 09T3..	296,30	125
GHFC.32.R.03-09	32	3	1,0	35	17,0	M16	24	27000	3,2	XDLX 09T3..	309,50	032
GHFC.42.R.05-19	42	5	1,0	35	17,0	M16	24	26100	3,2	XDLX 09T3..	346,70	04205
GHFC.32.R.02-12	32	2	2,0	35	17,0	M16	24	21600	5	XOLX 1204..	289,50	132
GHFC.35.R.03-12	35	3	2,0	35	17,0	M16	24	21360	5	XOLX 1204..	309,50	035
GHFC.42.R.04-12	42	4	2,0	35	17,0	M16	24	20800	5	XOLX 1204..	334,30	04204

MaxiMill – End milling cutter C HFC



Designation	DC	ZNF	APMX	OAL	LH	DCONMS _{h6}	RPMX	torque moment	Insert	Article no. 50 681 ...	2B/40	Article no. 50 681 ...	2B/40
	mm		mm	mm	mm	mm	1/min.	Nm		EUR		EUR	
CHFC.16.R.02-06-A-40-200	16	2	0,8	200	40	16	4600	1,2	XPLX 0603..	230,50	716	230,50	616
CHFC.16.R.02-06-B-40	16	2	0,8	89	40	16	17300	1,2	XPLX 0603..			261,70	620
CHFC.20.R.03-06-B-50	20	3	0,8	101	50	20	14500	1,2	XPLX 0603..			292,90	625
CHFC.20.R.03-06-A-50-225	20	3	0,8	225	50	20	4200	1,2	XPLX 0603..	261,70	720	324,10	632
CHFC.25.R.04-06-B-50	25	4	0,8	107	50	25	15600	1,2	XPLX 0603..				
CHFC.25.R.04-06-A-50-225	25	4	0,8	225	50	25	4600	1,2	XPLX 0603..	292,90	725		
CHFC.32.R.05-06-B-25-60	32	5	0,8	117	60	25	11000	1,2	XPLX 0603..				
CHFC.32.R.05-06-A-25-60-225	32	5	0,8	225	60	25	3900	1,2	XPLX 0603..	324,10	732		
CHFC.25.R.02-09-A-50-225	25	2	1,0	225	50	25	9000	3,2	XDLX 09T3..	276,00	025		
CHFC.25.R.03-09-A-50-225	25	3	1,0	225	50	25	9000	3,2	XDLX 09T3..	296,30	125		
CHFC.32.R.03-09-A-63-250	32	3	1,0	250	63	32	8100	3,2	XDLX 09T3..	309,50	032		
CHFC.32.R.02-12-A-63-250	32	2	2,0	250	63	32	6480	5	XOLX 1204..	289,50	132		
CHFC.35.R.03-12-A-63-250	35	3	2,0	250	63	32	6480	5	XOLX 1204..	309,50	035		

MaxiMill – Shell mill A HFC



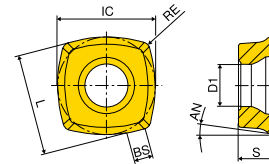
Designation	DC	ZNF	APMX	OAL	DCONMS _{H6}	DHUB	RPMX	torque moment Nm	Insert	2B/40	
										Article no. 50 683 ...	Article no. 50 683 ...
	mm		mm	mm	mm	mm	1/min.			EUR	EUR
AHFC.32.R.03-09	32	3	1,0	40	16	38	27700	3,2	XDLX 09T3..	309,50	032
AHFC.35.R.04-09	35	4	1,0	40	16	38	26700	3,2	XDLX 09T3..	329,70	035
AHFC.40.R.04-09	40	4	1,0	40	16	38	26400	3,2	XDLX 09T3..	343,20	140
AHFC.42.R.05-09	42	5	1,0	40	16	38	26100	3,2	XDLX 09T3..	363,30	142
AHFC.50.R.05-09	50	5	1,0	40	22	43	23500	3,2	XDLX 09T3..	403,80	150
AHFC.52.R.06-09	52	6	1,0	40	22	43	23000	3,2	XDLX 09T3..	424,00	152
AHFC.63.R.06-09	63	6	1,0	40	22	48	20500	3,2	XDLX 09T3..	464,30	163
AHFC.66.R.07-09	66	7	1,0	40	22	48	20000	3,2	XDLX 09T3..	484,50	16600
AHFC.40.R.03-12	40	3	2,0	40	16	38	21120	5	XOLX 1204..	323,10	040
AHFC.42.R.04-12	42	4	2,0	40	16	38	20880	5	XOLX 1204..	343,20	042
AHFC.50.R.04-12	50	4	2,0	40	22	43	18800	5	XOLX 1204..	383,50	050
AHFC.52.R.05-12	52	5	2,0	40	22	43	18400	5	XOLX 1204..	403,80	052
AHFC.63.R.05-12	63	5	2,0	40	22	48	16400	5	XOLX 1204..	444,00	063
AHFC.66.R.06-12	66	6	2,0	40	22	48	16000	5	XOLX 1204..	464,30	066
AHFC.80.R.07-12	80	7	2,0	50	27	58	14000	5	XOLX 1204..	524,90	080
AHFC.100.R.08-12	100	8	2,0	50	32	78	12000	5	XOLX 1204..	585,60	100
AHFC.63.R.05-19	63	5	3,3	40	22	48	5500	5	XOLX 1906..		464,90 263
AHFC.80.R.06-19	80	6	3,3	50	27	58	4700	5	XOLX 1906..		564,90 280
AHFC.100.R.08-19	100	8	3,3	52	32	78	4100	5	XOLX 1906..		672,40 300
AHFC.125.R.10-19	125	10	3,3	63	40	88	3600	5	XOLX 1906..		844,60 325
AHFC.160.R.11-19	160	11	3,3	63	40	98	3100	5	XOLX 1906..		1.021,00 360 ¹⁾

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

Spare parts	Y7		Y7		Y7		2A/28		2A/28		2A/28		Y7	
	TORX® blade		Clamping key – T		Key D		Power Screw		Molykote		Clamping screw		Torque screwdriver	
	Article no. 80 950 ...		Article no. 80 397 ...		Article no. 80 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
XDLX 09T3..	4,76	036			9,28	113			4,38	303	3,14	110	128,60	192
XDLX 09T3.. (Ø32 – Ø42)	4,76	036	3,91	040	9,28	113	12,48	151	4,38	303	3,14	110	128,60	192
XOLX 1204..	4,76	037			9,95	114			4,38	303	2,52	280	131,90	193
XOLX 1204.. (Ø40 – Ø42)	4,76	037	3,91	040	9,95	114	12,48	151	4,38	303	2,52	280	131,90	193
XOLX 1906..	4,76	037			9,95	114			4,38	303	4,09	302	131,90	193
XPLX 0603..	4,76	033			7,80	110			4,38	303	2,57	116	128,60	192

XPLX / XDLX / XOLX

Designation	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
XPLX 0603..	6,35	2,8	6	1	2,75	11
XDLX 09T3..	9,52	4,4	9	1,9	3,97	15
XOLX 1204..	12,70	5,5	12	1,3	4,76	-
XOLX 1906..	19,14	6,0	19	-	6,35	10



XPLX

		-M50 CTCP220		-M50 CTPP225		-M50 CTPP235		-M50 CTPM225		-M50 CTPM240		-F40 CTPM245	
		-M50 DCX1220		-M50 DPX1225		-M50 DPX1235		-M50 DPX2225		-M50 DPX2240		-F40 DPX2245	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
		XPLX 1B/61		XPLX 1B/61		XPLX 1B/61		XPLX 1B/61		XPLX 1B/61		XPLX 1H/17	
ISO	RE	Article no. 51 019 ...		Article no. 51 019 ...		Article no. 51 019 ...		Article no. 51 019 ...		Article no. 51 019 ...		Article no. 51 116 ...	
	mm	EUR		EUR		EUR		EUR		EUR		EUR	
060305ER	0,5	12,34		255		12,34		055		12,34		105	
060305SR	0,5	12,34		205		12,34		205		12,34		405	
Steel		●		●		●		○		○		●	
Stainless steel						○		●		●		●	
Cast iron													
Non ferrous metals													
Heat resistant alloys													
hardened materials													

XPLX

		-M50 CTCK215 -M50 DCX3215 DRAGONSKIN  XPLX 1B/61 Article no. 51 019 ... EUR		-F40 CTC5240 -F40 HCF5240 DRAGONSKIN  XPLX 1H/D4 Article no. 50 518 ... EUR		-F40 CTCS245 DRAGONSKIN  XPLX 1H/D4 Article no. 51 116 ... EUR	
ISO	RE						
	mm						
060305ER	0,5						
060305SR	0,5						
Steel							
Stainless steel							
Cast iron							
Non ferrous metals							
Heat resistant alloys							
hardened materials							

XDLX

				-M50 CTCP220 -M50 DCX1220 DRAGONSKIN  XDLX 1B/61 Article no. 51 016 ... EUR 12,72 258	-M50 CTPP225 -M50 DPX1225 DRAGONSKIN  XDLX 1B/61 Article no. 51 016 ... EUR 12,72 058	-M50 CTCP230 -M50 DCX1230 DRAGONSKIN  XDLX 1B/61 Article no. 51 016 ... EUR 12,72 008	-M50 CTPP235 -M50 DPX1235 DRAGONSKIN  XDLX 1B/61 Article no. 51 016 ... EUR 12,72 108	
ISO	RE							
	mm							
09T308SR	0,8							
Steel				●	●	●	●	●
Stainless steel						○		○
Cast iron								
Non ferrous metals								
Heat resistant alloys								
hardened materials								

XDLX

		-M50 CTPM225		-M50 CTCM235		-M50 CTPM240		-F40 CTPM245		-M50 CTPM245	
		-M50 DPX2225		-M50 DCX2235		-M50 DPX2240		-F40 DPX2245		-M50 DPX2245	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		XDLX 1B/61		XDLX 1B/61		XDLX 1B/61		XDLX 1H/17		XDLX 1H/17	
ISO	RE	Article no. 51 016 ...		Article no. 51 016 ...		Article no. 51 016 ...		Article no. 51 115 ...		Article no. 51 016 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
09T308ER	0,8	12,72		12,72		12,72		15,36		15,36	
09T308SR	0,8	208		308		408		458		458	
Steel		○		○		○		●		●	
Stainless steel		●		●		●		●		●	
Cast iron											
Non ferrous metals											
Heat resistant alloys											
hardened materials											

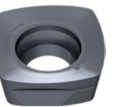
XDLX

		-M50 CTCK215		-F40 CTC5240		-F40 CTC5245	
		-M50 DCX3215		-F40 HCF5240			
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
							
		XDLX 1B/61		XDLX 1H/D4		XDLX 1H/D4 NEW	
ISO	RE	Article no. 51 016 ...		Article no. 50 503 ...		Article no. 51 115 ...	
	mm	EUR		EUR		EUR	
09T308ER	0,8	12,72		15,36		15,36	
09T308SR	0,8	508		558		558	
Steel		○					
Stainless steel							
Cast iron				●			
Non ferrous metals							
Heat resistant alloys						●	
hardened materials						●	

XOLX

		-M50 CTCP220		-M50 CTPP225		-M50 CTCP230		-M50 CTPP235		-R50 CTPP235	
		-M50 DCX1220		-M50 DPX1225		-M50 DCX1230		-M50 DPX1235		-R50 DPX1235	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		XOLX 1B/61		XOLX 1B/61		XOLX 1B/61		XOLX 1B/61		XOLX 1B/61	
ISO	RE	Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 018 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
	120410SR	1,0	15,26 260	15,26 060	15,26 010	15,26 110	15,26 110	15,26 110	15,26 110	15,26 110	15,26 110
Steel		●		●		●		●		●	
Stainless steel		○		○		○		○		○	
Cast iron											
Non ferrous metals											
Heat resistant alloys											
hardened materials											

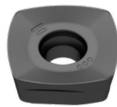
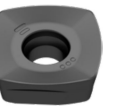
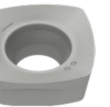
XOLX

		-M50 CTPM225		-M50 CTCM235		-M50 CTPM240		-F40 CTPM245		-M50 CTPM245	
		-M50 DPX2225		-M50 DCX2235		-M50 DPX2240		-F40 DPX2245		-M50 DPX2245	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		XOLX 1B/61		XOLX 1B/61		XOLX 1B/61		XOLX 1H/17		XOLX 1H/17	
ISO	RE	Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 022 ...		Article no. 51 017 ...	
	mm	EUR		EUR		EUR		EUR		EUR	
	120410ER	1,0	15,26 210	15,26 310	15,26 410	17,96 460	17,96 460	17,96 460	17,96 460	17,96 460	17,96 460
	120410SR	1,0	15,26 210	15,26 310	15,26 410	17,96 460	17,96 460	17,96 460	17,96 460	17,96 460	17,96 460
Steel		○		○		○		●		●	
Stainless steel		●		●		●		●		●	
Cast iron											
Non ferrous metals											
Heat resistant alloys											
hardened materials											

XOLX / XOHX

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XOLX

		-M50 CTCP230		-M50 CTPP235		-M50 CTPM240		-F40 CTPM245		-M50 CTCK215		-F40 CTC5240		-F40 CTCS245	
		-M50 DCX1230		-M50 DPX1235		-M50 DPX2240		-F40 DPX2245		-M50 DCX3215		-F40 HCF5240			
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		XOLX 1B/61		XOLX 1B/61		XOLX 1B/61		XOLX 1H/17		XOLX 1B/61		XOLX 1H/D4		XOLX 1H/D4 NEW	
ISO	RE	Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 017 ...		Article no. 51 022 ...		Article no. 51 017 ...		Article no. 50 504 ...		Article no. 51 022 ...	
	mm	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
190615ER	1,5							27,26 465				27,26 515			
190615SR	1,5	22,17 015		22,17 115		22,17 415				22,17 515				27,26 56500	
Steel		●		●		○		●		○					
Stainless steel		○		○		●		●							
Cast iron										●					
Non ferrous metals															
Heat resistant alloys												●		●	
hardened materials															

Milling guide

Machining strategy	→ 170-173	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data approximate values	→ 170-173
Starting Parameter	→ 170-173		

System MaxiMill HFC-06

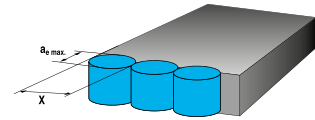
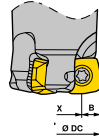
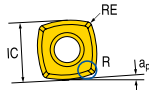
Cutting data recommendations/Technology data

Material	F			M			R		
	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm
Steel				60-280	0,2-1,25	0,8	60-280	0,2-1,25	0,8
Stainless steel				60-270	0,2-1,25	0,8	60-270	0,2-1,25	0,8
Cast iron				130-360	0,2-1,25	0,8	130-360	0,2-1,25	0,8
Non-ferrous metals									
Heat resistant alloys				25-75	0,2-1,25	0,8	25-75	0,2-1,25	0,8
hardened materials									

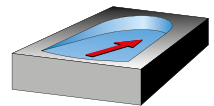
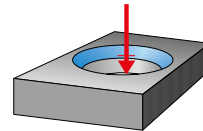
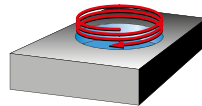
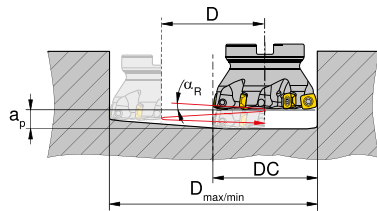
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

Programmed radius $R = 1.2$ mm



Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging			
IC in mm	RE in mm	$a_{p \max}$ in mm	DC in mm	X in mm	B in mm	$a_{e \max}$ in mm	f_z in mm	X	
6,35	0,5	0,8	16-32	DC-(2 x B)	4,3	5,3	initial	min.	max.
							0,10	0,08	0,15
									<0,7 x DC

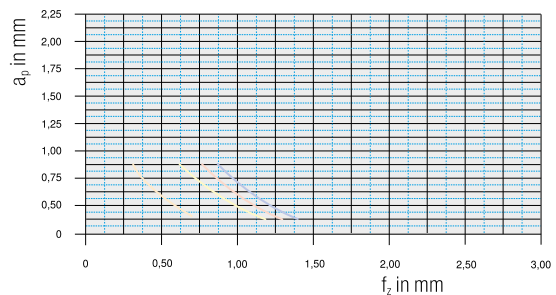


circular			
Helical plunging (helical plunging into solid material)			
DC mm	D _{max} mm	D _{min} mm	$\alpha_{R \max}$ °
16	31	22	4,5°
20	39	30	2,3°
25	49	40	1,3°
32	63	54	0,9°

	axial	Angled
	Plunging	
DC mm	X _{max} mm	α _{R max.} °
16		5,9°
20		3,2°
25	0,5	2°
32		1,3°

Starting Parameter

Example materials				
Steel	1000 N/mm ²	1.15	1.2312	40CrMnMoS 8-6
Stainless steel	600 N/mm ²	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/mm ²	5.8	Inconel 625	Inconel 718



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	XPLX 060305SR-M50	CTPP235 (DPX1235)	200	Dry
Stainless steel	1.4571	XPLX 060305ER-M40	CTPM240 (DPX2240)	180	Dry
Cast iron	5.1301	XPLX 060305ER-M50	CTCK215 (DCX3215)	250	Dry
Heat resistant alloys	2.4856	XPLX 060305SR-F40	CTC5240 (HCF5240)	35	Emulsion

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

System MaxiMill HFC-09

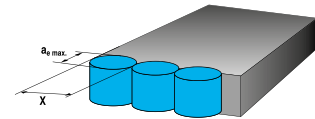
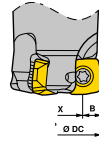
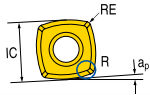
Cutting data recommendations/Technology data

Material	F			M			R		
	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm
Steel				60-280	0,2-2,5	1	60-280	0,2-2,5	1
Stainless steel				60-270	0,2-2,5	1	60-270	0,2-2,5	1
Cast iron				130-360	0,2-2,5	1	130-360	0,2-2,5	1
Non-ferrous metals									
Heat resistant alloys				25-75	0,2-2,5	1	25-75	0,2-2,5	1
hardened materials									

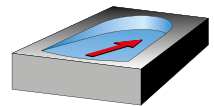
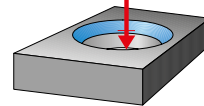
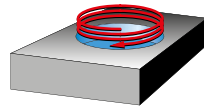
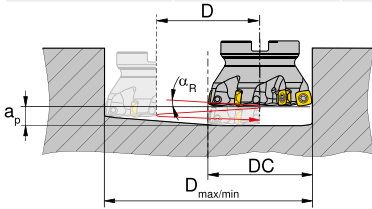
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

Programmed radius R = 2 mm



Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging			
IC in mm	RE in mm	$a_{p \max}$ in mm	DC in mm	X in mm	B in mm	$a_{p \max}$ in mm	f_z in mm		
							initial	min.	max.
9	0,8	1	25-66	DC-(2 x B)	5,9	7,5	0,10	0,08	0,15



circular			
Helical plunging (helical plunging into solid material)			
DC mm	$D_{\max}$ mm	$D_{\min}$ mm	$\alpha_{R \max}$ °
25	48	35	3,1°
32	62	49	1,7°
35	68	55	1,4°
40	78	65	1,0°
42	82	69	0,9°
50	98	85	0,8°
52	102	89	0,7°
63	124	111	0,7°
66	130	117	0,6°

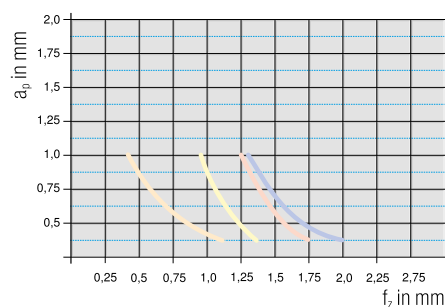
	axial	Angled
	Plunging	
DC mm	X _{max.} mm	α _{R max.} °
25	0,75	3,6°
32		2,0°
35		1,6°
40		1,2°
42		1,1°
50		0,9°
52		0,8°
63		0,8°
66		0,7°

Starting Parameter

Example materials				
Steel	1000 N/mm ²	1.15	1.2312	40CrMnMoS 8-6
Stainless steel	600 N/mm ²	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/mm ²	5.8	Inconel 625	Inconel 718



XDLX 09



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	XDLX09T308SR-M50	CTPP235 (DPX1235)	200	Dry
Stainless steel	1.4571	XDLX09T308SR-M50	CTPM240 (DPX2240)	180	Dry
Cast iron	5.1301	XDLX09T308SR-M50	CTCK215 (DCX3215)	250	Dry
Heat resistant alloys	2.4856	XDLX09T308ER-F40	CTC5240 (HCF5240)	35	Emulsion

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

System MaxiMill HFC-12

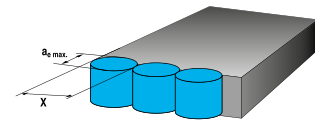
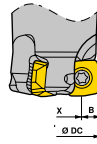
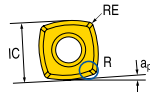
Cutting data recommendations/Technology data

Material	F			M			R		
	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm
Steel				60-280	0,2-3,0	2	60-280	0,2-3,0	2
Stainless steel				60-270	0,2-3,0	2	60-270	0,2-3,0	2
Cast iron				130-360	0,2-3,0	2	130-360	0,2-3,0	2
Non-ferrous metals									
Heat resistant alloys				25-75	0,2-3,0	2	25-75	0,2-3,0	2
hardened materials									

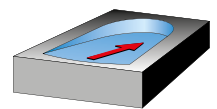
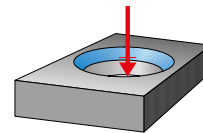
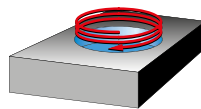
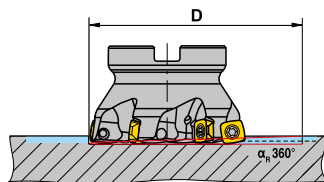
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

Programmed radius R = 3 mm



Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging				
IC in mm	RE in mm	a _{p max.} in mm	DC in mm	X in mm	B in mm	a _{e max.} in mm	f _z in mm		X	
							initial	min.	max.	
12	1,0	2	32–100	DC–(2 x B)	8,3	10	0,15	0,10	0,20	<0,7 x DC



circular			
Helical plunging (helical plunging into solid material)			
DC mm	D _{max.} mm	D _{min.} mm	$\alpha_{R \max.}$ °
32	62	44	6,1°
35	68	50	3,7°
40	78	60	2,5°
42	82	64	2,3°
50	98	80	1,3°
52	102	84	1,3°
63	124	106	0,9°
66	130	112	0,9°
80	158	140	1,1°
100	198	180	0,6°

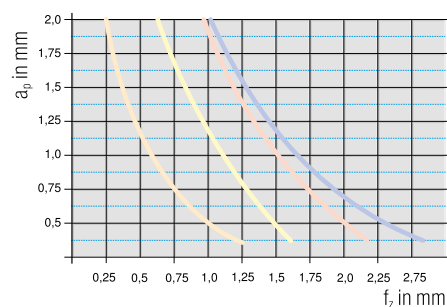
axial		Angled	
Plunging			
X _{max.} mm		α _{R max.} °	
1,15		7,2°	
		4,4°	
		2,9°	
		2,7°	
		1,5°	
		1,1°	
		1,3°	
100		0,7°	

Starting Parameter

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



XOLX 12



Material		Inserts		v_c in m/min	Coolant
Steel	1.2312	XOLX120410SR-M50	CTPP235 (DPX1235)	200	Dry
Stainless steel	1.4571	XOLX120410ER-M50	CTPM240 (DPX2240)	180	Dry
Cast iron	5.1301	XOLX120410ER-M50	CTCK215 (DCX3215)	250	Dry
Heat resistant alloys	2.4856	XOLX120410ER-F40	CTC5240 (HCF5240)	35	Emulsion

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

System MaxiMill HFC-19

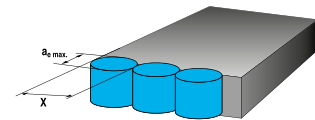
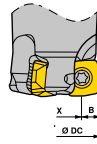
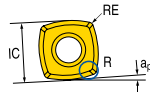
Cutting data recommendations/Technology data

Material	F			M			R		
	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm	v_c in m/min	f_z in mm	a_p in mm
Steel				60-280	0,2-3,0	3,3	60-280	0,2-3,0	3,3
Stainless steel				60-270	0,2-3,0	3,3	60-270	0,2-3,0	3,3
Cast iron				130-360	0,2-3,0	3,3	130-360	0,2-3,0	3,3
Non-ferrous metals									
Heat resistant alloys				25-75	0,2-3,0	3,3	25-75	0,2-3,0	3,3
hardened materials									

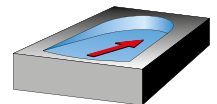
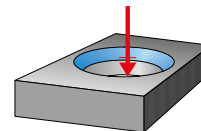
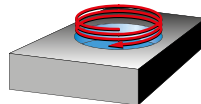
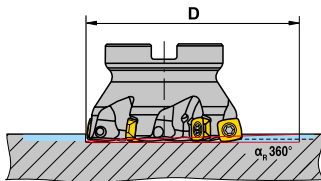
Detailed information on cutting speed for each grade can be found on → page 138+139

Machining strategy

Programmed radius R = 5 mm



Cutting depth and remaining material			Cutting width for flat surfaces			Cutting depth when plunging			
IC in mm	RE in mm	a _{p max.} in mm	DC in mm	X in mm	B in mm	a _{e max.} in mm	f _z in mm		X
							initial	min.	max.
19,14	1,5	3,3	63-160	DC-(2 x B)	13,1	12	0,2	0,10	0,25 <0,65 x DC



circular			
Helical plunging (helical plunging into solid material)			
DC mm	D _{max} mm	D _{min} mm	α _{R max.} °
63	97	123	2,5
80	131	157	1,4
100	171	197	1,0
125	221	247	0,7
160	291	317	0,5

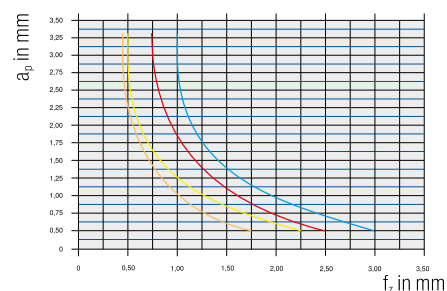
DC mm	axial	Angled	
	Plunging		
	X _{max.} mm	α _{R max.} °	a _{p max} mm
	63		2,9
80		1,8	
100	1,7	1,3	3,3
125		1,0	
160		0,7	

Starting Parameter

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



XOLX 19



Material	Inserts	v_c in m/min	Coolant
Steel	XOLX190615SR-M50 CTPP235 (DPX1235)	200	Dry
Stainless steel	XOLX190615SR-M50 CTPM240 (DPX2240)	180	Dry
Cast iron	XOLX190615SR-M50 CTCK215 (DCX3215)	250	Dry
Heat resistant alloys	XOLX190615ER-F40 CTC5240 (HCF5240)	35	Emulsion

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