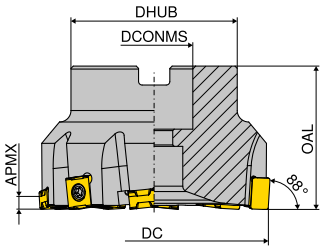
MaxiMill – Shell mill HEC 11

▲ not adjustable

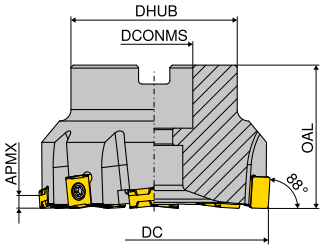


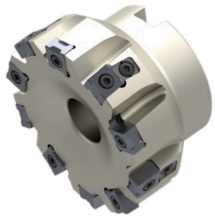
Designation	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	torque moment	Insert	2B/40 Article no. 50 725 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHEC.50.R.06-11	50	6	6	40	48	22	12700	3,2	LNHX 1106	542,80	**050**
AHEC.63.R.08-11	63	8	6	40	48	22	10100	3,2	LNHX 1106	651,60	**063**
AHEC.80.R.10-11	80	10	6	50	58	27	8000	3,2	LNHX 1106	796,60	**080**
AHEC.100.R.12-11	100	12	6	50	78	32	6400	3,2	LNHX 1106	929,60	**100**
AHEC.125.R.12-11	125	12	6	63	88	40	5100	3,2	LNHX 1106	1.062,00	**125**
AHEC.125.R.16-11	125	16	6	63	88	40	5100	3,2	LNHX 1106	1.070,00	**12516**
AHEC.160.R.20-11	160	20	6	63	100	40	4000	3,2	LNHX 1106	1.559,00	**160** [1]

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

MaxiMill – Shell mill HEC 11

▲ Axially adjustable with same tooth pitch



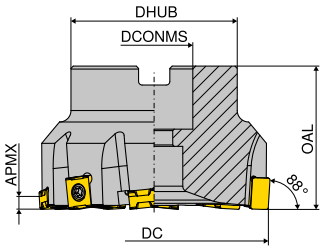


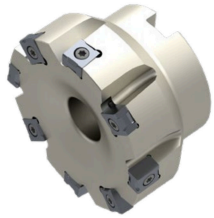
Designation	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	torque moment	Insert	2B/40 Article no. 50 733 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHEC.50.R.06A03-11	50	6	6	40	48	22	12700	3,2	LNHX 1106	822,50	**050**
AHEC.63.R.08A04-11	63	8	6	40	48	22	10100	3,2	LNHX 1106	1.024,00	**063**
AHEC.80.R.10A05-11	80	10	6	50	58	27	8000	3,2	LNHX 1106	1.263,00	**080**
AHEC.100.R.12A06-11	100	12	6	50	78	32	6400	3,2	LNHX 1106	1.490,00	**100**
AHEC.125.R.16A08-11	125	16	6	63	88	40	5100	3,2	LNHX 1106	2.016,00	**125**
AHEC.160.R.20A10-11	160	20	6	63	100	40	4000	3,2	LNHX 1106	2.491,00	**160** [1]

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

MaxiMill – Shell mill HEC 11

▲ with irregular pitch, non adjustable





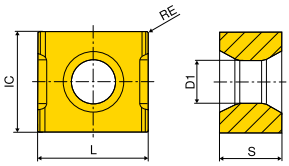
Designation	DC	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	torque moment	Insert	2B/40 Article no. 50 733 ...	
	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
AHEC.50.R.04B-11	50	4	6	40	48	22	12700	3,2	LNHX 1106	423,40	**550**
AHEC.63.R.06B-11	63	6	6	40	48	22	10100	3,2	LNHX 1106	526,20	**563**
AHEC.80.R.08B-11	80	8	6	50	58	27	8000	3,2	LNHX 1106	674,40	**580**
AHEC.100.R.10B-11	100	10	6	50	78	32	6400	3,2	LNHX 1106	866,80	**600**
AHEC.125.R.12B-11	125	12	6	63	88	40	5100	3,2	LNHX 1106	1.060,00	**625**
AHEC.160.R.14B-11	160	14	6	63	100	40	4000	3,2	LNHX 1106	1.316,00	**660** 1)

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

Spare parts DC	Y7 TORX® blade Article no. 80 950 ...		2A/28 Molykote Article no. 70 950 ...		2A/28 Coolant Disc Article no. 70 950 ...		2A/28 Clamping screw Article no. 70 950 ...		2A/28 Wedge Article no. 70 950 ...		Y7 Torque screwdriver Article no. 80 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR	
50 - 63	4,76	**036**	4,38	**303**	25,18	**852**	3,14	**113**	36,80	**199**	131,90	**193**
80	4,76	**036**	4,38	**303**	25,73	**853**	3,14	**113**	36,80	**199**	131,90	**193**
100	4,76	**036**	4,38	**303**	28,32	**854**	3,14	**113**	36,80	**199**	131,90	**193**
125	4,76	**036**	4,38	**303**	37,33	**855**	3,14	**113**	36,80	**199**	131,90	**193**
160	4,76	**036**	4,38	**303**			3,14	**113**	36,80	**199**	131,90	**193**

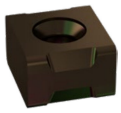
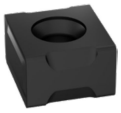
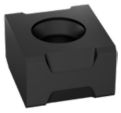
LNHX

Designation	IC	D1	L	S
	mm	mm	mm	mm
LNHX 1106..	10	4,27	11	6,35



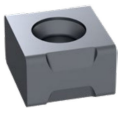
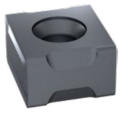
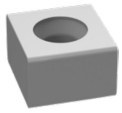
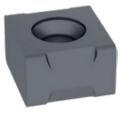
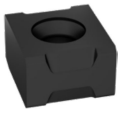
LNHX

LNHX

		CTEP210	CTCK215	-R50 CTCK215	-Q CTCK215
		DCC1210	DCX3215	-R50 DCX3215	-Q DCX3215
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		CERMET			
		LNHX	LNHX	LNHX	LNHX
		1B/79	1B/61	1B/61	1B/61
ISO	RE	Article no. 51 046 ...	Article no. 51 046 ...	Article no. 51 024 ...	Article no. 51 045 ...
	mm	EUR	EUR	EUR	EUR
1106PNEN	0,5		25,91 51600		
1106PNER	0,5		25,91 520	25,91 520	
1106PNER	0,8	30,04 820			
1106ZZER	0,5				25,91 520 1)
Steel		●	○	○	○
Stainless steel					
Cast iron		●	●	●	●
Non ferrous metals					
Heat resistant alloys					
hardened materials					

1) -Q = Wiper insert

LNHX

		CTPK220	-R50 CTPK220	CTN3105	CTL3215	-Q CTL3215
		DPX3220	-R50 DPX3220	CTS3105	CWB3215	
		DRAGONSKIN	DRAGONSKIN			
						
		LNHX	LNHX	CERAMIC LNHX	CBN LNHX	CBN LNHX
		1B/61	1B/61	1G/55	1G/21	1G/21
ISO	RE	Article no. 51 046 ...	Article no. 51 024 ...	Article no. 50 500 ...	Article no. 51 046 ...	Article no. 51 045 ...
	mm	EUR	EUR	EUR	EUR	EUR
110608EN	0,8		25,91 608			
1106PNER	0,5	25,91 620	25,91 620			
1106PNSR	0,5			24,42 904		
1106PNSR					142,70 87200	
1106ZZER						142,70 87000 1)
Steel		○	○			
Stainless steel						
Cast iron		●	●	●	●	●
Non ferrous metals						
Heat resistant alloys						
hardened materials					○	○

1) -Q = Wiper insert

Milling guide

Grade description	→ 209+210	ISO Designation System	→ 194+195
Cutting data appoximate values	→ 148		

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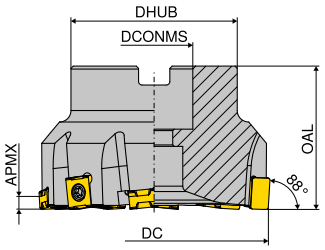
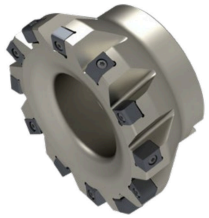
MaxiMill – Shell mill HEC 12

▲ not adjustable





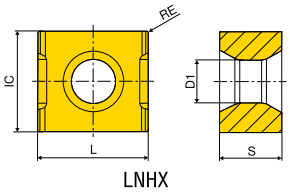
Designation	DC	ZNF	APMX	OAL	DHUB	DCONMS H6	RPMX	torque moment	Insert	NEW 2B/40 Article no. 50 725 ... EUR	
	mm		mm	mm	mm	mm	1/min.	Nm			
AHEC.125.R.12-1210	125	12	8	63	88	40	5000	3,2	LN.. 1210..	1.062,00	32512
AHEC.160.R.16-1210	160	16	8	63	88	40	3900	3,2	LN.. 1210..	1.247,00	36016 1)

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

Spare parts DC	Y7 Key D Article no. 80 950 ... EUR		2A/28 Coolant Disc Article no. 70 950 ... EUR	
125 - 160	7,05	105	37,33	855

LNHX / LNEX

Designation	IC	D1	L	S
	mm	mm	mm	mm
LN.X 1210..	10	4,4	12,7	10,00



LNHX

LNHX / LNEX

ISO	RE	CTCK215 LNHX NEW 1B/61 Article no. 51 135 ... EUR		CTPK220 LNEX NEW 1B/61 Article no. 51 133 ... EUR		-R50 CTPK220 LNHX NEW 1B/61 Article no. 51 134 ... EUR	
	mm						
121008EN	0,8					32,38	60800
121008SN	0,8	32,38	50900				
121020EN				29,79	62000		
121020SN	2,0	32,38	52100				

Steel	○	○	○
Stainless steel			
Cast iron	●	●	●
Non ferrous metals			
Heat resistant alloys			
hardened materials			

Milling guide

Grade description	→ 209+210	ISO Designation System	→ 194+195
Cutting data appoximate values	→ 148		

System MaxiMill 270-19

Cutting data appoximate values

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				40–180	0,15–0,6	10	40–180	0,3–0,7	10
Stainless steel				40–120	0,15–0,5	10	40–120	0,3–0,6	10
Cast iron							50–200	0,3–0,9	10
Non-ferrous metals									
Heat resistant alloys				20–70	0,15–0,5	10			
hardened materials									

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

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

System MaxiMill HEC

Cutting data appoximate values

MaxiMill HEC 11

	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									
Cast iron	100–800	0,08–0,3	6	100–360	0,08–0,3	6	100–360	0,1–0,45	6
Non-ferrous metals									
Heat resistant alloys									
hardened materials									

MaxiMill HEC 12

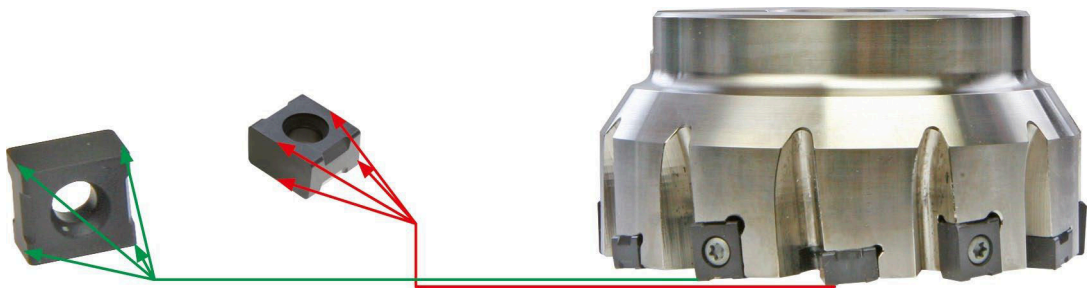
	F			M			R		
Material	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm	v_c m/min	f_z mm	a_p mm
Steel									
Stainless steel									
Cast iron	100–360	0,08–0,3	8	100–360	0,08–0,3	8	100–360	0,1–0,45	8
Non-ferrous metals									
Heat resistant alloys									
hardened materials									

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

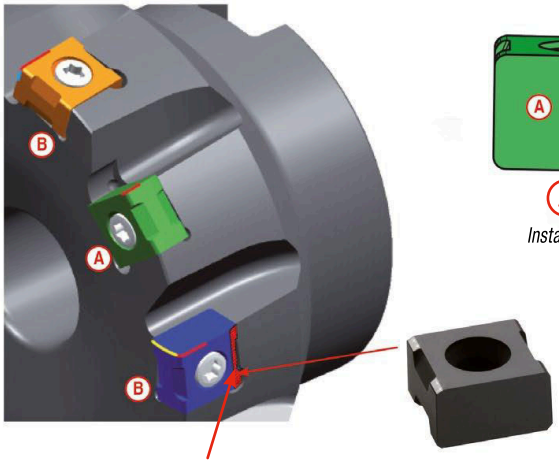
From v_c > 400 m/min, the tool must be balanced!

System MaxiMill HEC 11

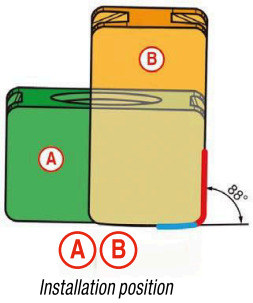
4 cutting edges per installation position



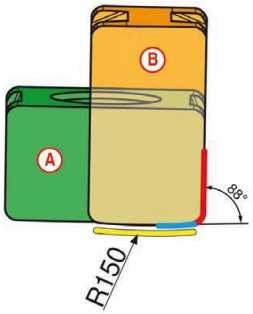
Correct assembly of standard and wiper inserts



Marking for the correct assembly



Installation position



Face machining insert — B
Insert main cutting edge — A B
Wiper Facet — B

Adjust the tools in axial direction

- Install the wedge into the cutter body and lightly clamp the clamping screw so as not to clamp.
- Install the inserts as shown and tighten to 1,0 Nm torque.
- Using pre-setting equipment, mark the highest cutting edge.
- With small adjustments of the setting screw set all cutting edges to the same height by 0,005 mm or better.
- Clamp insert with 3,2 Nm torque.