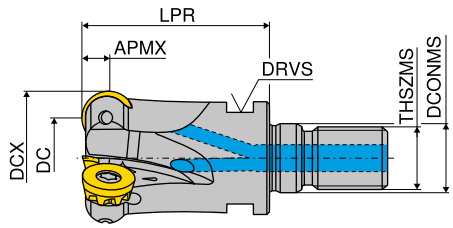
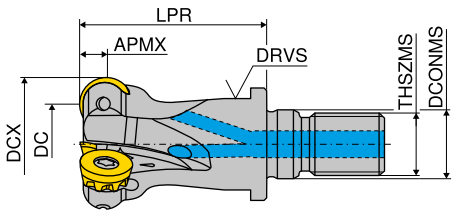
MaxiMill – Screw in cutter G 251 RS



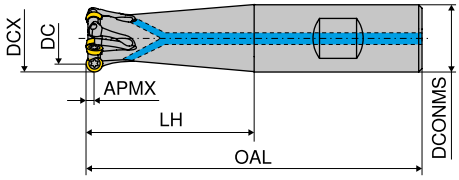
Designation	DC	DCX	ZNF	APMX	DCONMS	LPR	THSZMS	DRVS	RPMX	torque moment	Insert	2B/40 Article no. 50 684 ...	
	mm	mm		mm	mm	mm		mm	1/min.	Nm		EUR	
G251.20.R.05-05-RS	15	20	5	2,5	10,5	33	M10	15	31800	0,7	RDHX 0501..	278,80	220
G251.25.R.06-05-RS	20	25	6	2,5	12,5	35	M12	17	24450	0,7	RDHX 0501..	321,00	225
G251.32.R.07-05-RS	27	32	7	2,5	17,0	35	M16	24	19850	0,7	RDHX 0501..	385,10	232
G251.20.R.03-08-RS	12	20	3	4,0	10,5	33	M10	15	25000	1,2	RDHX 0802..	261,70	120
G251.25.R.04-08-RS	17	25	4	4,0	12,5	35	M12	17	19000	1,2	RDHX 0802..	292,90	125
G251.32.R.05-08-35-RS	24	32	5	4,0	17,0	35	M16	24	19000	1,2	RDHX 0802..	356,10	132
G251.20.R.02-10-RS	10	20	2	5,0	10,5	33	M10	15	30000	2	RP.X 10T3..	211,70	020
G251.25.R.03-10-RS	15	25	3	5,0	12,5	35	M12	17	30000	2	RP.X 10T3..	284,60	025
G251.32.R.04-10-RS	22	32	4	5,0	17,0	35	M16	24	25000	2	RP.X 10T3..	331,20	032
G251.25.R.02-12-35-RS	13	25	2	6,0	12,5	35	M12	17	25000	3,2	RP.X 1204..	205,30	525
G251.32.R.03-12-35-RS	20	32	3	6,0	17,0	35	M16	24	19850	3,2	RP.X 1204..	250,50	532
G251.35.R.03-12-35-RS	23	35	3	6,0	17,0	35	M16	24	15900	3,2	RP.X 1204..	250,50	535
G251.42.R.04-12-42-RS	30	42	4	6,0	17,0	42	M16	24	15000	3,2	RP.X 1204..	297,70	542

MaxiMill – Screw in cutter G 251



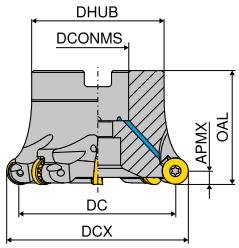
Designation	DC	DCX	ZNF	APMX	THSZMS	LPR	DCONMS	DRVS	torque moment	Insert	2B Article no. 55 112 ...	
	mm	mm		mm		mm	mm	mm	Nm		EUR	
G251.10.R.02-05	5	10	2	2,5	M8	20	8,5	10	0,7	RDHX 0501..	151,00	110
G251.12.R.03-05	7	12	3	2,5	M8	20	8,5	10	0,7	RDHX 0501..	203,40	112
G251.15.R.04-05	10	15	4	2,5	M8	20	8,5	10	0,7	RDHX 0501..	238,00	115
G251.16.R.04-05	11	16	4	2,5	M8	20	8,5	10	0,7	RDHX 0501..	238,00	216
G251.20.R.05-05	15	20	5	2,5	M10	25	10,5	15	0,7	RDHX 0501..	281,00	320
G251.20.R.03-08	12	20	3	4,0	M10	28	10,5	15	1,2	RDHX 0802..	203,40	420
G251.25.R.04-08	17	25	4	4,0	M12	28	12,5	17	1,2	RDHX 0802..	254,80	425
G251.32.R.06-08	24	32	6	4,0	M16	28	17,0	24	1,2	RDHX 0802..	336,60	432
G251.35.R.06-08	27	35	6	4,0	M16	28	17,0	24	1,2	RDHX 0802..	336,60	435
G251.20.R.02-10	10	20	2	5,0	M10	33	10,5	15	2	RP.X 10T3..	216,00	220
G251.32.R.04-10	22	32	4	5,0	M16	35	17,0	24	2	RP.X 10T3..	315,60	232
G251.35.R.05-10	25	35	5	5,0	M16	35	17,0	24	2	RP.X 10T3..	353,40	235
G251.25.R.02-12.IK	13	25	2	6,0	M12	35	12,5	17	3,2	RP.X 1204..	212,90	525
G251.32.R.03-12.IK	20	32	3	6,0	M16	35	17,0	24	3,2	RP.X 1204..	259,00	532
G251.35.R.03-12.IK	23	35	3	6,0	M16	35	17,0	24	3,2	RP.X 1204..	259,00	535
G251.42.R.04-12.IK	30	42	4	6,0	M16	42	17,0	24	3,2	RP.X 1204..	308,30	542

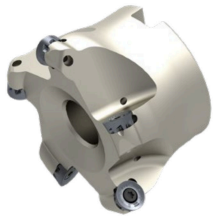
MaxiMill – End milling cutter C 251 RS



Designation	DC	DCX	ZNF	APMX	OAL	LH	DCONMS	RPMX	Insert	A 2B/40 Article no. 50 685 ...		B 2B/40 Article no. 50 685 ...	
	mm	mm		mm	mm	mm	mm	1/min.		EUR		EUR	
C251.10.R-02-05-B-12-20-RS	5	10	2	2,5	67	21,5	12	40000	RDHX 0501..			192,80	010
C251.10.R-02-05-A-25-165-RS	5	10	2	2,5	165	25,0	10	12000	RDHX 0501..	186,20	110		
C251.12.R-03-05-B-16-25-RS	7	12	3	2,5	75	25,0	16	40000	RDHX 0501..			243,20	012
C251.12.R-03-05-A-32-165-RS	7	12	3	2,5	165	32,0	12	16000	RDHX 0501..	234,20	112		
C251.16.R-04-05-B-32-RS	11	16	4	2,5	81	32,0	16	40000	RDHX 0501..			284,60	316
C251.16.R-04-05-A-40-165-RS	11	16	4	2,5	165	40,0	16	18000	RDHX 0501..	278,10	016		
C251.20.R-05-05-B-40-RS	15	20	5	2,5	91	40,0	20	31800	RDHX 0501..			331,20	620
C251.20.R-05-05-A-50-165-RS	15	20	5	2,5	165	50,0	20	18000	RDHX 0501..	324,90	120		
C251.16.R-02-08-B-32-RS	8	16	2	4,0	81	32,0	16	40000	RDHX 0802..			200,60	116
C251.16.R-02-08-A-40-165-RS	8	16	2	4,0	165	40,0	16	18000	RDHX 0802..	192,80	216		
C251.20.R-03-08-B-40-RS	12	20	3	4,0	91	40,0	20	31800	RDHX 0802..			254,90	220
C251.20.R-03-08-A-60-RS	12	20	3	4,0	110	50,0	20	30000	RDHX 0802..	261,70	020		
C251.20.R-03-08-A-50-200-RS	12	20	3	4,0	200	50,0	20	25000	RDHX 0802..	247,10	320		
C251.25.R-04-08-B-50-RS	17	25	4	4,0	107	50,0	25	25500	RDHX 0802..			301,40	625
C251.25.R-04-08-A-60-RS	17	25	4	4,0	116	60,0	25	19000	RDHX 0802..	292,90	125		
C251.25.R-04-08-A-60-225-RS	17	25	4	4,0	225	60,0	25	18000	RDHX 0802..	293,60	225		
C251.20.R-02-10-A-50-RS	10	20	2	5,0	102	50,0	20	25000	RP.X 10T3..	213,50	420		
C251.20.R-02-10-A-50-200-RS	10	20	2	5,0	200	50,0	20	25000	RP.X 10T3..	213,50	520		
C251.25.R.03-10-A-60-RS	15	25	3	5,0	116	60,0	25	25000	RP.X 10T3..	288,50	025		
C251.25.R-03-10-B-60-RS	15	25	3	5,0	116	60,0	25	20000	RP.X 10T3..			288,50	325
C251.25.R-03-10-A-60-225-RS	15	25	3	5,0	225	60,0	25	18000	RP.X 10T3..	288,50	425		
C251.32.R.04-10-A-70-RS	22	32	4	5,0	127	70,0	32	25000	RP.X 10T3..	324,90	032		
C251.25.R-02-12-B-30-RS	13	25	2	6,0	86	30,0	25	25000	RP.X 1204..			263,10	525
C251.32.R-03-12-A-RS	20	32	3	6,0	100	40,0	32	19000	RP.X 1204..	304,30	232		
C251.32.R-03-12-B-40-RS	20	32	3	6,0	100	40,0	32	19000	RP.X 1204..			304,30	132

MaxiMill – Shell mill A 251 RS



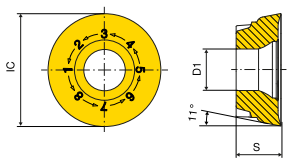


Designation	DC	DCX	ZNF	APMX	OAL	DHUB	DCONMS $_{H6}$	RPMX	torque moment	Insert	2B/40 Article no. 50 686 ...	
	mm	mm		mm	mm	mm	mm	1/min.	Nm		EUR	
A251.40.R.03-10-RS	30	40	3	5	40	38	16	15900	2	RP.X 10T3..	315,60	**240**
A251.40.R.05-10-RS	30	40	5	5	40	38	16	16000	2	RP.X 10T3..	355,70	**140**
A251.42.R.06-10-RS	32	42	6	5	40	38	16	16000	2	RP.X 10T3..	408,80	**142**
A251.50.R.04-10-RS	40	50	4	5	40	43	22	12700	2	RP.X 10T3..	346,60	**350**
A251.50.R.06-10-RS	40	50	6	5	40	43	22	12500	2	RP.X 10T3..	423,00	**150**
A251.52.R.06-10-RS	42	52	6	5	40	43	22	12500	2	RP.X 10T3..	423,00	**152**
A251.40.R.04-12-RS	28	40	4	6	40	38	16	15900	3,2	RP.X 1204..	327,20	**340**
A251.50.R.04-12-RS	38	50	4	6	40	43	22	12700	3,2	RP.X 1204..	337,70	**250**
A251.50.R.05-12-RS	38	50	5	6	40	43	22	12500	3,2	RP.X 1204..	397,10	**050**
A251.52.R.05-12-RS	40	52	5	6	40	43	22	12500	3,2	RP.X 1204..	416,50	**052**
A251.63.R.06-12-RS	51	63	6	6	40	48	22	10000	3,2	RP.X 1204..	490,30	**063**
A251.66.R.07-12-RS	54	66	7	6	40	48	22	9000	3,2	RP.X 1204..	516,90	**166**
A251.80.R.05-12-RS	68	80	5	6	50	58	27	7950	3,2	RP.X 1204..	447,50	**180**
A251.80.R.07-12-RS	68	80	7	6	50	58	27	8000	3,2	RP.X 1204..	553,10	**080**
A251.100.R.06-12-RS	88	100	6	6	50	78	32	6350	3,2	RP.X 1204..	499,40	**100**
A251.100.R.10-12-RS	88	100	10	6	50	78	32	6350	3,2	RP.X 1204..	729,60	**200**
A251.50.R.04-16-RS	34	50	4	8	40	48	22	12700	5	RP.X 1605..	397,10	**450**
A251.52.R.04-16-RS	36	52	4	8	40	48	22	10100	5	RP.X 1605..	397,10	**452**
A251.63.R.05-16-RS	47	63	5	8	40	48	22	10100	5	RP.X 1605..	500,60	**163**
A251.66.R.05-16-RS	50	66	5	8	40	48	22	7950	5	RP.X 1605..	504,30	**466**
A251.80.R.06-16-RS	64	80	6	8	50	58	27	7950	5	RP.X 1605..	608,00	**280**
A251.100.R.07-16-RS	84	100	7	8	50	78	32	6350	5	RP.X 1605..	710,30	**300**
A251.125.R.08-16-RS	109	125	8	8	63	88	40	5050	5	RP.X 1605..	751,80	**225**
A251.80.R.05-20-RS	60	80	5	10	50	58	27	7950	5	RP.X 2006..	514,80	**380**
A251.100.R.06-20-RS	80	100	6	10	50	78	32	6350	5	RP.X 2006..	615,80	**400**
A251.125.R.06-20-RS	105	125	6	10	63	88	40	5050	5	RP.X 2006..	623,50	**125**

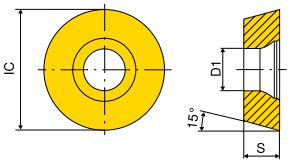
Spare parts	Y7 TORX® blade		Y7  Clamping key – T		Y7  Key D		2A/28  Power Screw		2A/28  Molykote		2A/28  Clamping screw		Y7  Torque screwdriver	
	Article no. 80 950 ...		Article no. 80 397 ...		Article no. 80 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 80 950 ...	
Insert	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
RDHX 0501..	4,76	**031**			8,44	**108**			4,38	**303**	2,57	**149**	118,90	**191**
RDHX 0802..	4,76	**033**			7,80	**110**			4,38	**303**	2,57	**116**	118,90	**191**
RP.X 10T3..	4,76	**035**	3,91	**040**	9,14	**112**	12,48	**151**	4,38	**303**	2,57	**840**	128,60	**192**
RP.X 1204..	4,76	**036**	3,91	**040**	9,28	**113**	12,48	**151**	4,38	**303**	3,14	**304**	128,60	**192**
RP.X 1605..	4,76	**037**	4,24	**050**	9,95	**114**	17,14	**154**	4,38	**303**	2,52	**280**	131,90	**193**
RP.X 2006..	4,76	**037**			9,95	**114**			4,38	**303**	4,09	**302**	131,90	**193**

RDHX / RPHX / RPNX

Designation	IC	D1	S
	mm	mm	mm
RDHX 0501..	5	2,5	1,59
RDHX 0802..	8	2,8	2,38
RP.X 10T3..	10	3,4	3,97
RP.X 1204..	12	4,4	4,76
RP.X 1605..	16	5,5	5,56
RP.X 2006..	20	6,0	6,35



RP.X 10T3.. / RP.X 1204.. / RP.X 1605.. / RPNX 2006..

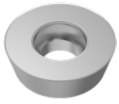


RDHX 0501.. / RDHX 0802..

RDHX

	-SN CTCP230	-SN CTPP235	-F50 CTPM240	-F50 CTPM245
	-SN DCX1230	-SN DPX1235	-F50 DPX2240	-F50 DPX2245
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	RDHX	RDHX	RDHX	RDHX
	1B/61	1B/61	NEW 1B/61	1H/17
ISO	Article no. 51 048 ...	Article no. 51 048 ...	Article no. 51 083 ...	Article no. 51 083 ...
	EUR	EUR	EUR	EUR
0501MOSN	12,11 020	12,11 120		11,12 465
0802M4SN				14,64 471
0802MOSN	12,36 025	12,36 125	12,36 420	14,64 470
Steel	●	●	○	●
Stainless steel	○	○	●	●
Cast iron				
Non ferrous metals				
Heat resistant alloys				
hardened materials				

RDHX

	-EN CTCK215	-FN H216T	-M31 CTC5240	-F50 CTCS245
	-EN DCX3215	-FN CWK26	-M31 HCF5240	
	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
				
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	1B/61	1B/61	1H/D4	NEW 1H/D4
ISO	Article no. 51 048 ...	Article no. 50 481 ...	Article no. 50 481 ...	Article no. 51 083 ...
	EUR	EUR	EUR	EUR
0501MOFN		9,61 600		
0802M4EN			14,64 50100	
0802MOEN	12,36 520		14,64 500	14,64 570
0802MOFN		9,91 602		
Steel	○			
Stainless steel				
Cast iron	●	○		
Non ferrous metals		●		
Heat resistant alloys			●	●
hardened materials				

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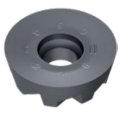
RPHX / RPNX

	-SN TCM10	-F50 CTCP230	-M50 CTCP230	-SN CTCP230	-SN CTCP230
	-SN CWC10	-F50 DCX1230	-M50 DCX1230	-SN DCX1230	-SN DCX1230
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
	CERMET RPHX	RPNX	RPNX	RPHX	RPNX
	1B/79	1B/18	1B/61	1B/61	1B/61
ISO	Article no. 50 483 ...	Article no. 51 055 ...	Article no. 51 054 ...	Article no. 51 052 ...	Article no. 51 057 ...
	EUR	EUR	EUR	EUR	EUR
10T3MOEN		12,83 020			
10T3MOSN	12,83 900		9,77 020	12,83 020	
1204MOEN		11,22 025			
1204MOSN	14,06 902		11,22 025	14,06 025	11,22 025
1605MOSN			15,26 030	19,13 030	15,26 030
2006MOSN					19,85 035
Steel	●	●	●	●	●
Stainless steel	●	○	○	○	○
Cast iron	○				
Non ferrous metals					
Heat resistant alloys					
hardened materials					

RPHX / RPNX

	-F50 CTPP235	-F50 CTPP235	-M30 CTPP235	-M30 CTPP235
	-F50 DPX1235	-F50 DPX1235	-M30 DPX1235	-M30 DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	RPHX	RPNX	RPHX	RPNX
	1B/61	1B/61	1B/61	1B/61
ISO	Article no. 51 051 ...	Article no. 51 055 ...	Article no. 51 049 ...	Article no. 51 053 ...
	EUR	EUR	EUR	EUR
10T3MOEN			12,83 120	
10T3MOSN	12,83 12000	9,77 120		
1204MOEN		11,22 125		
1204MOSN	14,06 125			
1605MOSN		15,26 130		
2006MOEN				19,85 120
Steel	●	●	●	●
Stainless steel	○	○	○	○
Cast iron				
Non ferrous metals				
Heat resistant alloys				
hardened materials				

RPNX / RPHX

	-M50 CTPP235	-M50 CTPP235	-SN CTPP235	-SN CTPP235
	-M50 DPX1235	-M50 DPX1235	-SN DPX1235	-SN DPX1235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	RPNX	RPHX	RPHX	RPNX
	1B/61	NEW 1B/61	1B/61	1B/18
ISO	Article no. 51 054 ...	Article no. 51 050 ...	Article no. 51 052 ...	Article no. 51 057 ...
	EUR	EUR	EUR	EUR
10T3MOSN	9,77 12000	12,83 12000	12,83 120	
1204MOSN	11,22 125		14,06 125	11,22 125
1605MOSN	15,26 130		19,13 130	15,26 130
2006MOSN				19,85 135
Steel	●	●	●	●
Stainless steel	○	○	○	○
Cast iron				
Non ferrous metals				
Heat resistant alloys				
hardened materials				

RPHX

	-F50 CTPM225	-M30 CTPM225	-SN CTPM225	-F50 CTCM235	-M30 CTCM235
	-F50 DPX2225	-M30 DPX2225	-SN DPX2225	-F50 DCX2235	-M30 DCX2235
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
	RPHX	RPHX	RPHX	RPHX	RPHX
	1B/61	1B/61	1B/61	1B/61	1B/61
ISO	Article no. 51 051 ...	Article no. 51 049 ...	Article no. 51 052 ...	Article no. 51 051 ...	Article no. 51 049 ...
	EUR	EUR	EUR	EUR	EUR
1204MOEN		14,06 225		14,06 325	
1204MOSN	14,06 225		14,06 225		14,06 325
Steel	○	○	○	○	○
Stainless steel	●	●	●	●	●
Cast iron					
Non ferrous metals					
Heat resistant alloys					
hardened materials					

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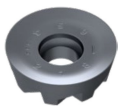
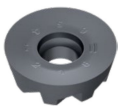
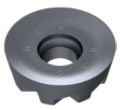
RPHX / RPNX

	-F50 CTPM240		-F50 CTPM240		-M30 CTPM240		-M30 CTPM240		-M50 CTPM240	
	-F50 DPX2240		-F50 DPX2240		-M30 DPX2240		-M30 DPX2240		-M50 DPX2240	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
										
	RPHX		RPNX		RPHX		RPNX		RPHX	
	1B/61		1B/61		1B/61		1B/61		1B/61	
ISO	Article no. 51 051 ...		Article no. 51 055 ...		Article no. 51 049 ...		Article no. 51 053 ...		Article no. 51 050 ...	
	EUR		EUR		EUR		EUR		EUR	
10T3MOEN					12,83	420			12,83	420
10T3MOSN	12,83	420								
1204MOEN					14,06	425			14,06	425
1204MOSN	14,06	425								
1605MOEN					19,13	430				
1605MOSN	19,13	430								
2006MOEN							19,85	420		
2006MOSN			19,85	435						
Steel	○		○		○		○		○	
Stainless steel	●		●		●		●		●	
Cast iron										
Non ferrous metals										
Heat resistant alloys										
hardened materials										

RPHX / RPNX

	CTPM245		-F50 CTPM245		-F50 CTPM245		-M32 CTPM245		-M50 CTPM245	
	DPX2245		-F50 DPX2245		-F50 DPX2245		-M32 DPX2245		-M50 DPX2245	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
										
	RPHX		RPHX		RPNX		RPHX		RPHX	
	1H/17		1H/17		1H/17		1H/17		1H/17	
ISO	Article no. 51 052 ...		Article no. 51 051 ...		Article no. 51 055 ...		Article no. 51 108 ...		Article no. 51 050 ...	
	EUR		EUR		EUR		EUR		EUR	
10T3M4SN			16,19	470 [1]	13,46	470 [1]			16,19	470 [1]
10T3M8SN			16,19	471	13,46	471			16,19	471
1204M4EN	17,84	475 [1]					17,84	475 [1]		
1204M4SN			17,84	475 [1]	15,84	475 [1]			17,84	475 [1]
1204M6SN			17,84	476					17,84	476
1204M8SN			17,84	477	15,84	476			17,84	477
1605M8SN			24,34	480						
2006M4SN			30,83	485 [1]						
2006M8SN					24,34	485				
Steel	●		●		●		●		●	
Stainless steel	●		●		●		●		●	
Cast iron										
Non ferrous metals										
Heat resistant alloys										
hardened materials										

1) Insert with 4 indexes

RPNX / RPHX

	-R30 CTCK215	-SN CTCK215	-SN CTCK215	-SN CTPK220	-27P H216T
	-R30 DCX3215	-SN DCX3215	-SN DCX3215	-SN DPX3220	-ALP CWK26
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
					
	RPNX	RPHX	RPNX	RPNX	RPHX
	1B/18	1B/61	1B/18	1B/61	1A/90
ISO	**Article no. 51 056 ...**	**Article no. 51 052 ...**	**Article no. 51 057 ...**	**Article no. 51 057 ...**	**Article no. 50 483 ...**
	EUR	EUR	EUR	EUR	EUR
10T3MOEN	9,77 **520**				
10T3MOFN					14,65 **600**
10T3MOSN		12,83 **520**		9,77 **620**	
1204MOEN	11,22 **525**				
1204MOFN					16,24 **602**
1204MOSN		14,06 **525**	11,22 **525**	11,22 **625**	
1605MOFN					22,16 **604**
1605MOSN		19,13 **530**	15,26 **530**	15,26 **630**	
2006MOSN			19,85 **535**	19,85 **635**	
Steel	○	○	○	○	
Stainless steel					
Cast iron	●	●	●	●	○
Non ferrous metals					●
Heat resistant alloys					
hardened materials					

RPHX / RPNX

	-M31 CTC5240	-F50 CTCS245	-F50 CTCS245	-R60 CTP6215
	-M31 HCF5240			-R60 CCN6215
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
				
	RPHX	RPHX	RPNX	RPNX
	1H/D4	NEW 1H/D4	NEW 1H/D4	1B/61
ISO	**Article no. 50 493 ...**	**Article no. 51 051 ...**	**Article no. 51 055 ...**	**Article no. 50 508 ...**
	EUR	EUR	EUR	EUR
10T3M4EN	16,19 **550** [1]			
10T3M4SN		16,19 **570** [1]		
10T3M8EN	16,19 **551**			
10T3M8SN		16,19 **571**		
1204M4EN	17,84 **552** [1]			
1204M4SN		17,84 **575**		
1204M6EN	17,84 **56200**	17,84 **57800**		
1204M8EN	17,84 **582**			12,11 **300**
1204M8SN		17,84 **577**		
1605M8EN	24,34 **555**	24,34 **58100**		
2006M8SN			24,34 **585**	
Steel				
Stainless steel				
Cast iron				●
Non ferrous metals				
Heat resistant alloys	●	●	●	
hardened materials				●

1) Insert with 4 indexes

Milling guide

Machining strategy	→ 176	ISO Designation System	→ 194+195
Grade description	→ 209+210	Cutting data appoximate values	→ 175

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System MaxiMill 251

Cutting data recommendations/Technology data

for standard inserts

	F				
		05		08	
Material	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm
Steel	50–350	0,08–0,35	2,5	0,08–0,35	4
Stainless steel	130–280	0,08–0,35	2,5	0,08–0,35	4
Cast iron	100–360			0,1–0,4	4
Non-ferrous metals	160–1500	0,05–0,4	2,5	0,05–0,4	4
Heat resistant alloys	25–75			0,08–0,35	4
hardened materials					

	M						
		10		12		16	
Material	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm	f_z mm	a_p mm
Steel	50–350	0,08–0,4	5	0,08–0,4	6	0,08–0,4	8
Stainless steel	60–280	0,08–0,35	5	0,08–0,35	6	0,08–0,35	8
Cast iron	100–360	0,1–0,4	5	0,1–0,4	6	0,1–0,4	8
Non-ferrous metals	160–1500	0,05–0,4	5	0,05–0,4	6	0,05–0,4	8
Heat resistant alloys	25–75	0,08–0,38	5	0,08–0,38	6	0,08–0,38	8
hardened materials	40–60			0,05–0,35	6		

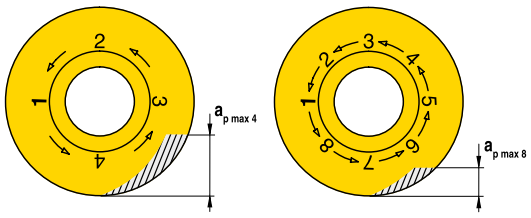
	R						
		20					
Material	v_c m/min	f_z mm	a_p mm	f_z mm	a_p mm	f_z mm	a_p mm
Steel	50–350	0,1–0,4	10				
Stainless steel	60–280	0,08–0,35	10				
Cast iron	100–360	0,1–0,4	10				
Non-ferrous metals	160–1500	0,05–0,4	10				
Heat resistant alloys	25–75	0,08–0,38	10				
hardened materials							

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

Recommended cutting depth

	4-position		8-face
Ø mm	$a_{p\,max.}$ mm	$a_{p\,max}$ theoretical mm	$a_{p\,max.}$ mm
5	1,0	2,0	0,7
8	1,5	3,5	1,1
10	2,5	4,5	1,4
12	3,0	5,5	1,7
16	4,0	7,5	2,3
20	4,0	9,5	2,9

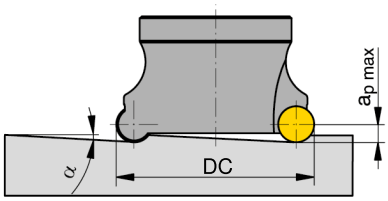
Average depth for the 4/8 index use of the insert



System MaxiMill 251

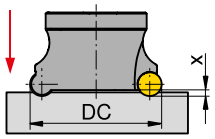
Technical data

Linear ramping



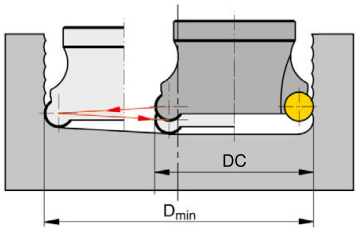
	05	08	10	12	16	20
Ø DC mm	α °	α °	α °	α °	α °	α °
10	3,4					
12	16,0					
16	8,0	5,0				
20	5,5	20,0	1,3			
25	4,0	13,0	2,0	6,0		
32	3,0	8,0	3,0	4,0		
40			3,3	2,8		
42			3,1			
50			2,4	2,6	4,0	
52			2,2	2,3		
63				1,9	2,8	
66				1,6		
80				1,3	2,0	3,2
100				1,0	1,5	2,3
125						1,7

Plunging

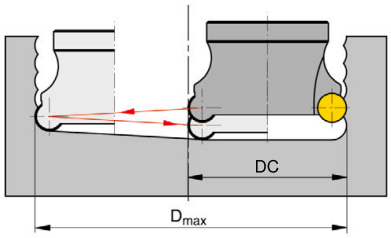


	05	08	10	12	16	20
Ø DC mm	X max. mm	X max. mm	X max. mm	X max. mm	X max. mm	X max. mm
10	0,5					
12	1,3					
16	1,3	0,5				
20	1,3	2,7	0,2			
25	1,3	2,7	0,4	1,0		
32	1,3	2,7	0,8	1,1		
40			1,5	1,2		
42			1,5	1,5		
50			1,5	1,5	2,0	
52			1,5	1,5	2,0	
63				1,5	2,0	
66				1,5	2,0	
80				1,5	2,0	3,0
100				1,5	2,0	3,0
125						3,0

Circular milling into solid



$D_{min.}$ = smallest drilling diameter depending on the tool diameter



$D_{max.}$ = Maximum hole diameter Depending on the tool diameter

maximum possible hole diameter = 2 x DC – 1 mm

	05			08			10			12			16			20		
Ø DC mm	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °	D_{min} mm	D_{max} mm	α_R °
10	12	15	2,5															
12	16	19	2,1															
16	24	27	1,5	21	24	2,4												
20	32	35	1,2	27	32	1,9	26	30	1,3									
25	42	45	1,0	37	42	1,5	37	40	1,8	31	38	2,2						
32	56	59	0,7	51	56	1,2	50	54	1,5	46	52	1,7						
40							64	70	1,1	62	68	1,4						
42							68	74	1,1									
50							84	90	0,9	81	88	1,1	75	84	1,5			
52							88	94	0,9	86	92	1,0						
63										107	114	0,9	101	110	1,1			
66										113	120	0,8						
80										142	148	0,7	135	144	0,9	128	140	1,1
100										181	188	0,5	175	184	0,7	168	180	0,9
125																218	230	0,7