

MaxiMill 491 system

Starting parameters for example materials

B20



Materials				Insert		v_c [m/min]	Coolant
	1.2312	40CrMnMoS8-6	1.000 N/mm ²	SNHU 120408SR-M50	CTPP235	200	dry
	1.4571	X6CrNiMoTi17-12-2	600 N/mm ²	SNHU 120408SR-F50	CTPM240	140	dry
	5.1301	EN-GJL-250	HB 180	SNHU 120408SR-R50	CTCK215	250	dry
	3.4365	Alu	450 N/mm ²	SNHU 120408SR-F10	CTCK215	1500	Minimum quantity lubrication



If $a_e < 50\%$ use correction list

