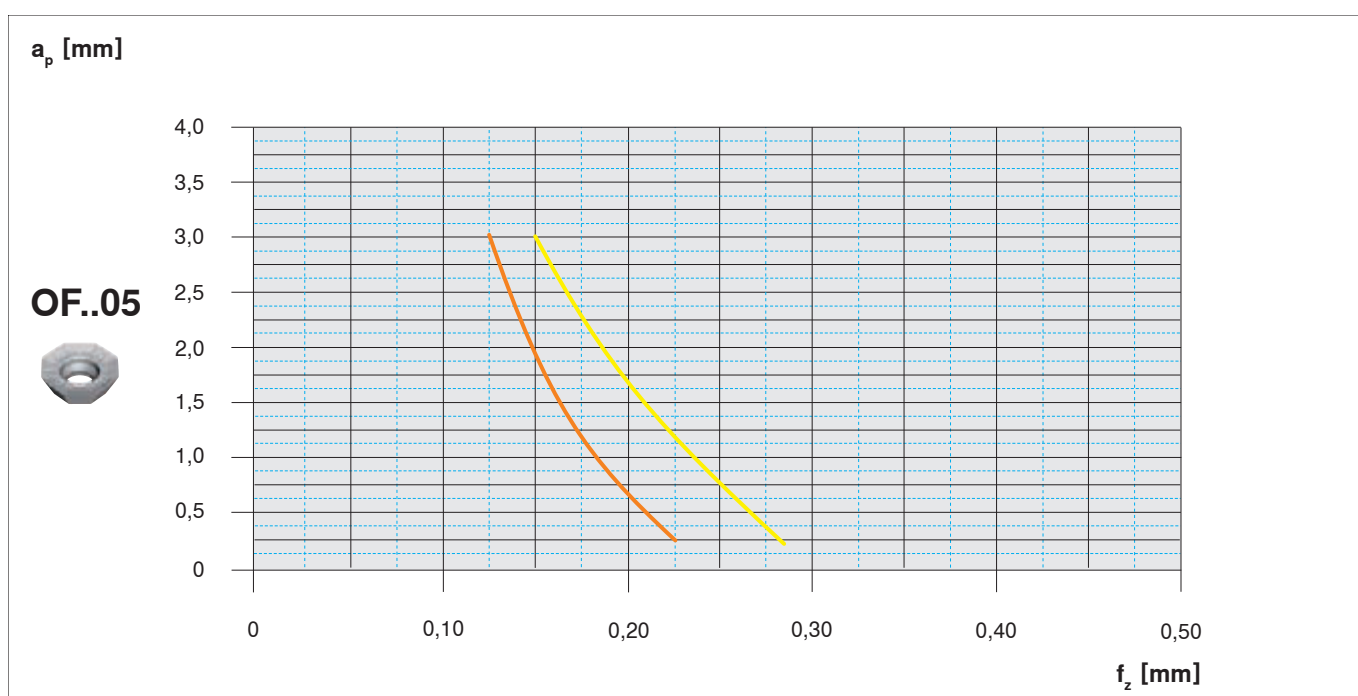
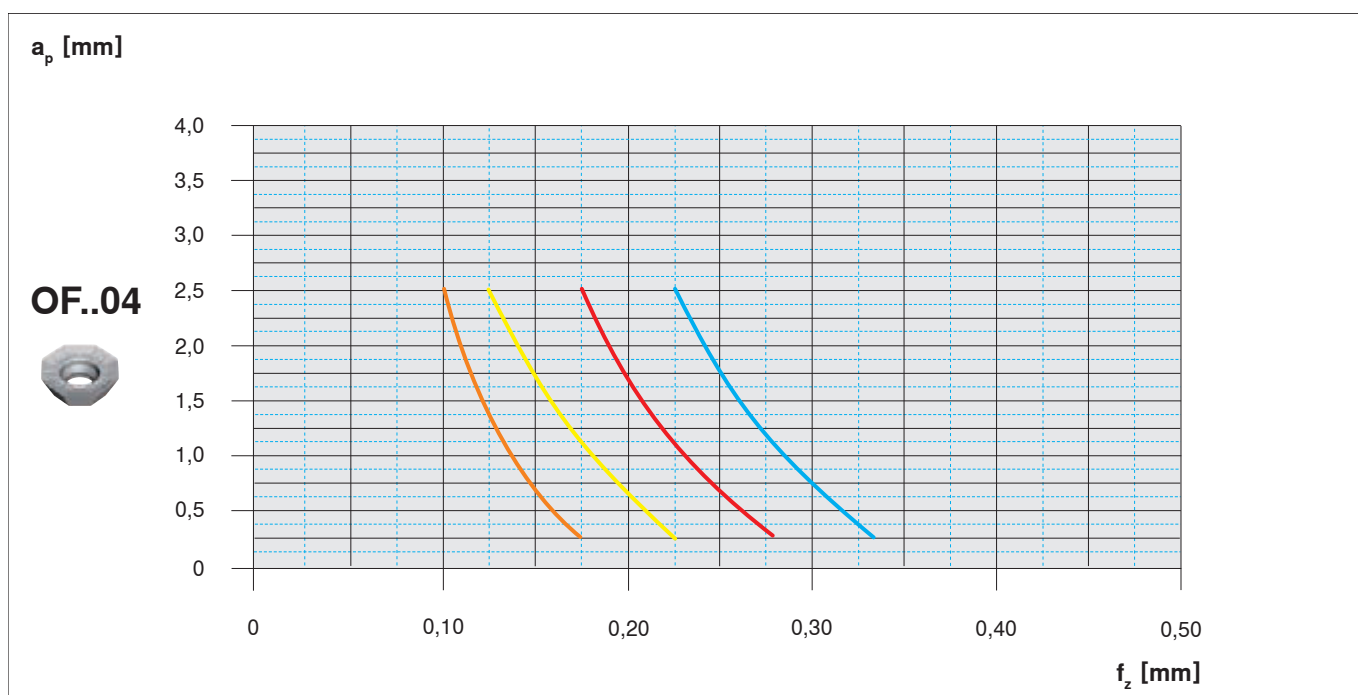


# MaxiMill 274 system

Starting parameters for example materials OF..

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| Materials                                                                         |        |                   |                         | Insert                                 |         | $v_c$ [m/min] | Coolant  |
|-----------------------------------------------------------------------------------|--------|-------------------|-------------------------|----------------------------------------|---------|---------------|----------|
|  | 1.2312 | 40CrMnMoS8-6      | 1.000 N/mm <sup>2</sup> | OFHT 040305SN-M50                      | CTPP235 | 200           | dry      |
|  | 1.4571 | X6CrNiMoTi17-12-2 | 600 N/mm <sup>2</sup>   | OFHT 040305SN-F50<br>OFHT 050410SN-F50 | CTPM240 | 180           | dry      |
|  | 5.1301 | EN-GJL-250        | HB 180                  | OFHT 040305SN-M50                      | CTCK215 | 250           | dry      |
|  | 2.4856 | Inconel 625       | 1.450 N/mm <sup>2</sup> | OFHT 040305SN-F50<br>OFHT 050410SN-F50 | CTC5235 | 35            | emulsion |



Additional grades and geometries can be used for the application and are illustrated in the respective application range of the system.