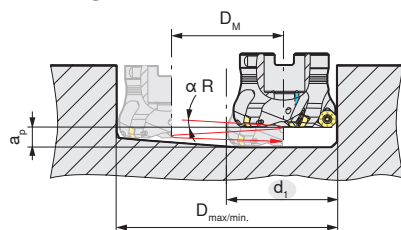


MaxiMill 274 system

Application data OF..04..

Helical plunge milling

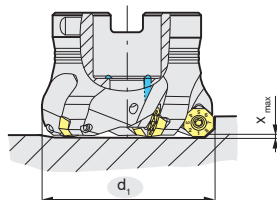


D_{max} [mm] = maximum diameter for flat bottom ground
 D_{min} [mm] = minimum hole diameter
 $D_M = D_{max} - d_1$ or $D_{min} - d_1$

d_1 [mm]	$D_{max / r 0,8}$ [mm]	D_{min} [mm]	$\alpha_{R max}$ [°]
20	45	39	14,2
25	55	49	9,5
32	69	63	6,5
40	85	79	4,7
50	105	99	3,5
63	131	125	2,7
80	165	159	2
100	205	199	1,6
125	255	249	1,2

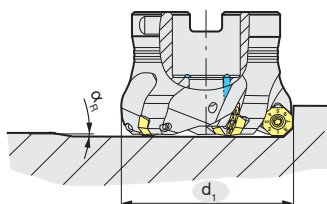
$$a_p \text{ [mm]} = D_M \times \pi \times \tan \alpha_R$$

Axial plunging



d_1 [mm]	X_{max} [mm]
20	2,5
25	2,5
32	2,5
40	2,5
50	2,5
63	2,5
80	2,5
100	2,5
125	2,5

Angled ramping



d_1 [mm]	α_R [°]
20	14,2
25	9,5
32	6,5
40	4,7
50	3,5
63	2,7
80	2,0
100	1,6
125	1,2