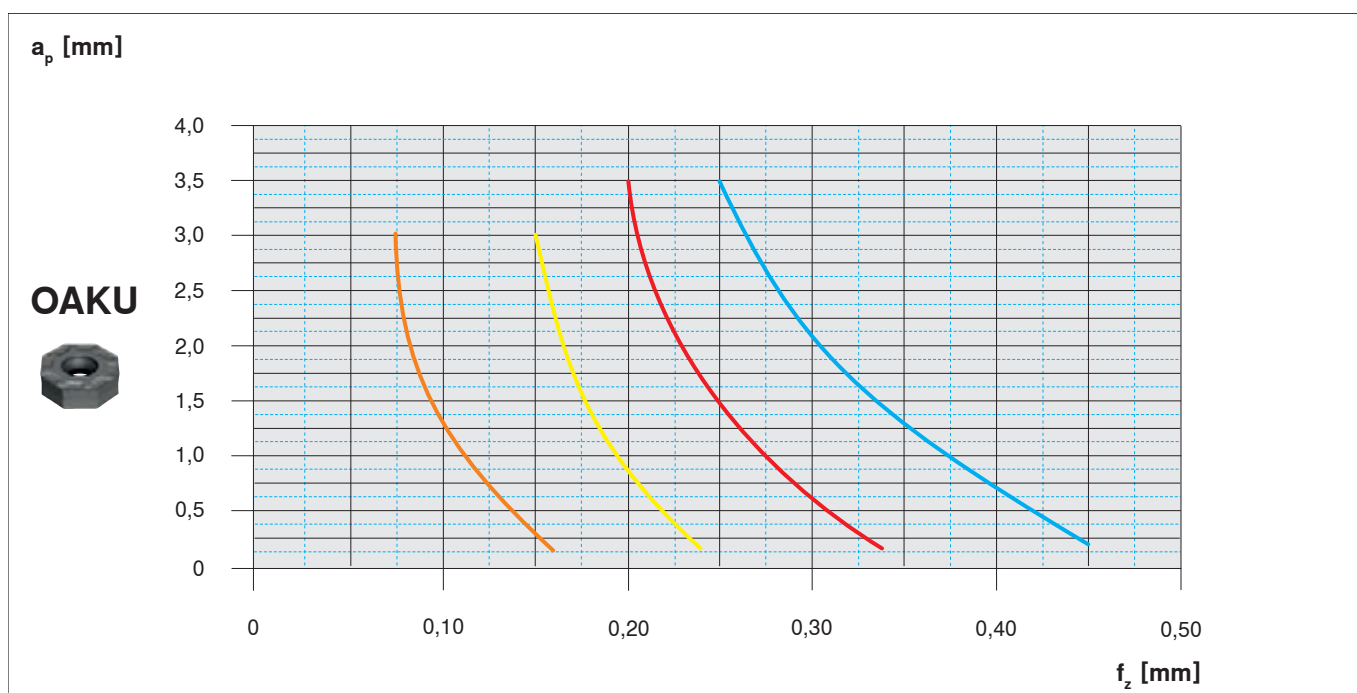


MaxiMill 273 system

Starting parameters for example materials

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Materials				Insert		v_c [m/min]	Coolant
	1.2312	40CrMnMoS8-6	1.000 N/mm ²	OAKU 060508SR-M50	CTPP235	200	dry
	1.4571	X6CrNiMoTi17-12-2	600 N/mm ²	OAKU 060508SR-F50	CTPM240	180	dry
	5.1301	EN-GJL-250	HB 180	OAKU 060508SR-R50	CTCK215	250	dry
	2.4856	Inconel 625	1.450 N/mm ²	OAKU 060508SR-F40	CTC5235	35	emulsion



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