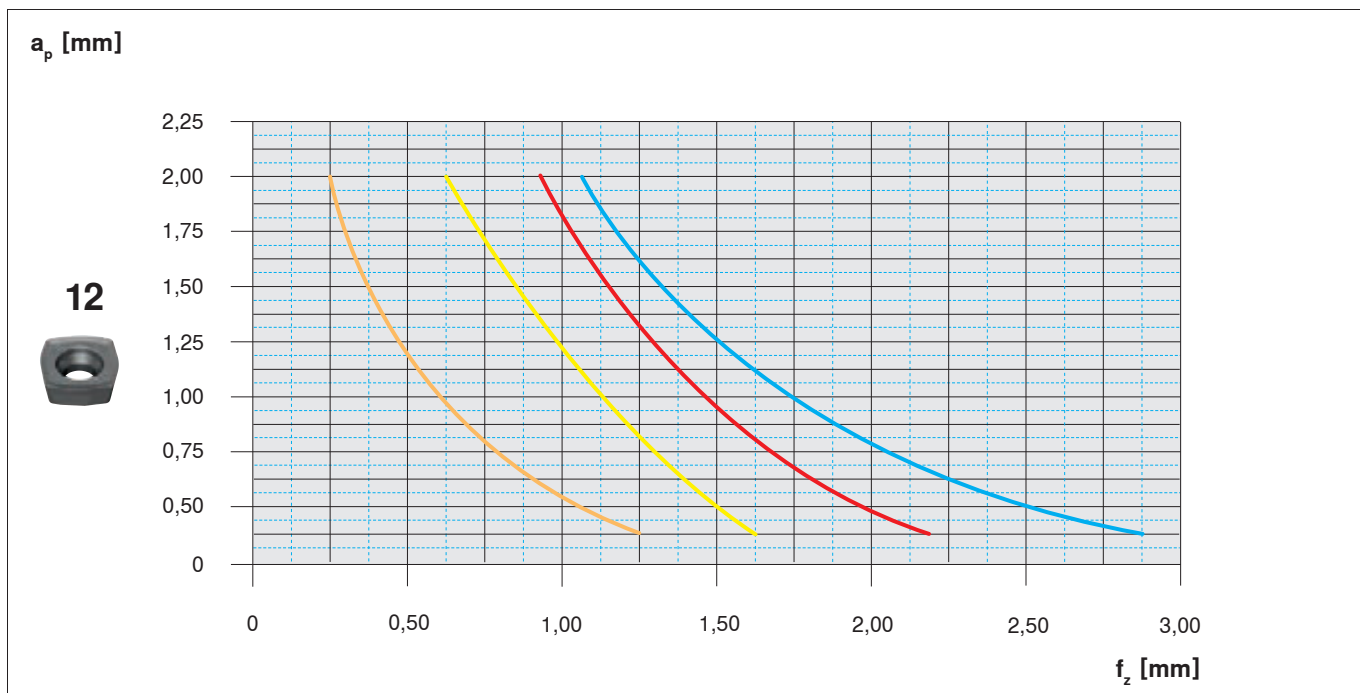


MaxiMill HFC system

Starting parameters for example materials HFC 12

Materials				Insert		v_c [m/min]	Coolant
	1.2312	40CrMnMoS8-6	1.000 N/mm ²	XOLX 120410SR-M50	CTPP235	180	dry
	1.4571	X6CrNiMoTi17-12-2	600 N/mm ²	XOLX 120410ER-M50	CTPM240	160	dry
	5.1301	EN-GJL-250	HB 180	XOLX 120410ER-M50	CTCK215	250	dry
	2.4856	Inconel 625	1.450 N/mm ²	XOLX 120410ER-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.