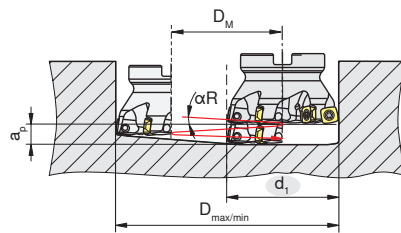


MaxiMill HFC system

Application data HFC 06

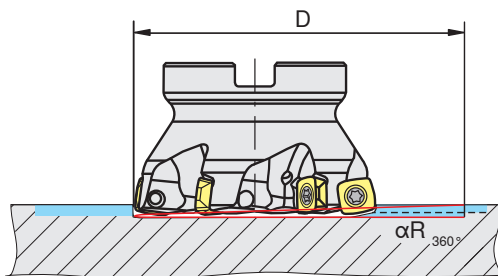
Helical plunge milling



D_{max} [mm] = maximum diameter for flat bottom ground

D_{min} [mm] = minimum hole diameter

$D_M = D_{max} - d_1$ or $D_{min} - d_1$

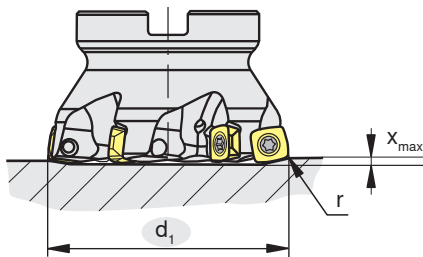


d_1 [mm]	D_{max} [mm]	D_{min} [mm]	$\alpha_{R \max}$ [°]
16	31	22	4,5
20	39	30	2,3
25	49	40	1,3
32	63	54	0,9

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

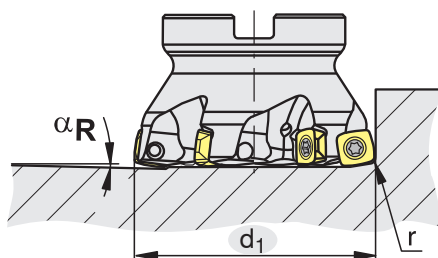
d_1 [mm]	D [mm]	$\alpha_{R \max} 360^\circ$ [°]
16	22	4,5
20	30	2,3
25	40	1,3
32	54	0,9

Axial plunging



d_1 [mm]	X_{max} [mm]
16 - 32	0,5

Angled ramping



d_1 [mm]	$\alpha_{R \max}$ [°]
16	5,9
20	3,2
25	2,0
32	1,3