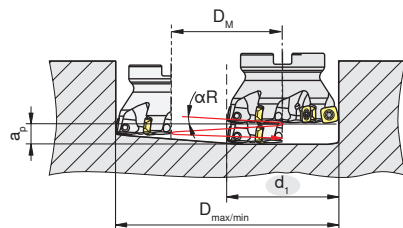


MaxiMill HFC system

Application data HFC 09

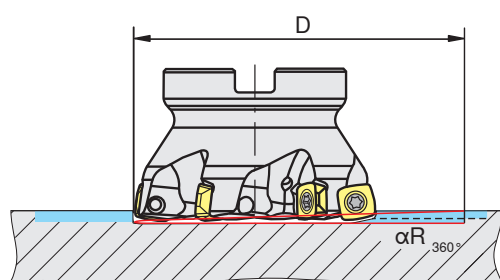
Helical plunge milling



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

D_{min} [mm] = minimum hole diameter

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

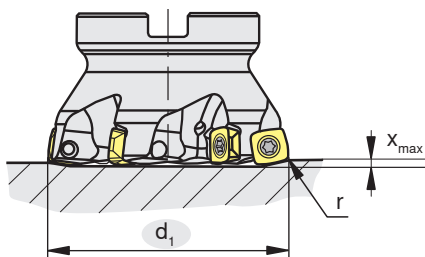


d_1 [mm]	D_{max} [mm]	D_{min} [mm]	$\alpha_{R \max}$ [°]
25	48	35	3,1
32	62	49	1,7
35	68	55	1,4
40	78	65	1,0
42	82	69	0,9
50	98	85	0,8
52	102	89	0,7
63	124	111	0,7
66	130	117	0,6

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

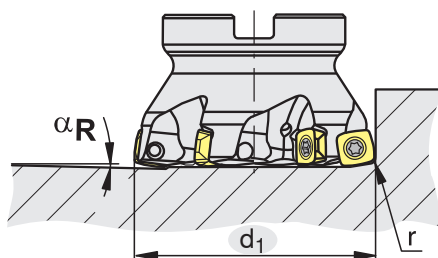
d_1 [mm]	D [mm]	$\alpha_{R \max} 360^\circ$ [°]
25	35	3,1
32	49	1,7
35	55	1,4
40	65	1,0
42	69	0,9
50	85	0,8
52	89	0,7
63	111	0,7
66	117	0,6

Axial plunging



d_1 [mm]	X_{max} [mm]
25 - 66	0,75

Angled ramping



d_1 [mm]	$\alpha_{R \max}$ [°]
25	3,6
32	2,0
35	1,6
40	1,2
42	1,1
50	0,9
52	0,8
63	0,8
66	0,7