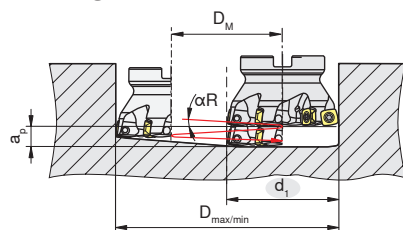


MaxiMill HFC system

Application data HFC 12

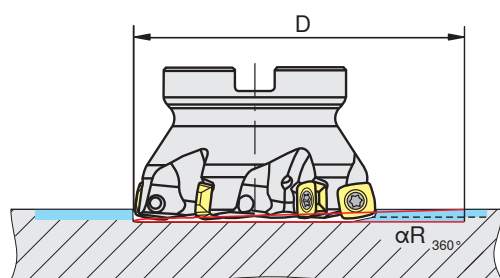
Helical plunge milling



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

D_{min} [mm] = minimum hole diameter

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

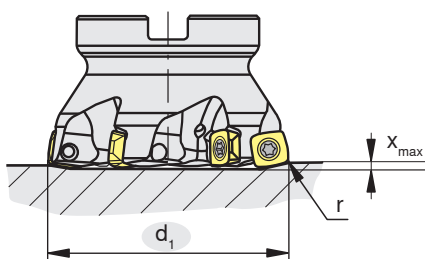


d_1 [mm]	D_{max} [mm]	D_{min} [mm]	$\alpha_{R max}$ [°]
32	62	44	6,1
35	68	50	3,7
40	78	60	2,5
42	82	64	2,3
50	98	80	1,3
52	102	84	1,3
63	124	106	0,9
66	130	112	0,9
80	158	140	1,1
100	198	180	0,6

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

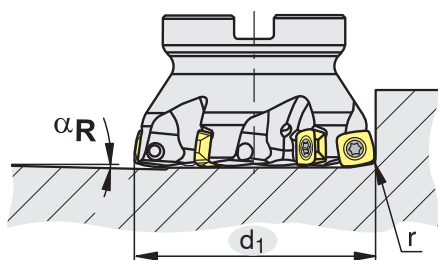
d_1 [mm]	D [mm]	$\alpha_{R max} 360^\circ$ [°]
32	44	6,1
35	50	3,7
40	60	2,5
42	64	2,3
50	80	1,3
52	84	1,3
63	106	0,9
66	112	0,9
80	140	1,1
100	180	0,6

Axial plunging



d_1 [mm]	X_{max} [mm]
32 - 100	1,15

Angled ramping



d_1 [mm]	$\alpha_{R max}$ [°]
32	7,2
35	4,4
40	2,9
42	2,7
50	1,5
52	1,5
63	1,1
66	1,1
80	1,3
100	0,7