

MaxiMill 211 system

Starting parameters for example materials XD..07/11

Materials				Insert		v_c [m/min]	Coolant
	1.2312	40CrMnMoS8-6	1.000 N/mm ²	XDKT 070308SR-M50 XDKT 11T308SR-M50	CTPP235	200	dry
	1.4571	X6CrNiMoTi17-12-2	600 N/mm ²	XDKT 070308SR-F50 XDKT 11T308SR-F50	CTPM240	180	dry
	5.1301	EN-GJL-250	HB 180	XDKT 11T308SR-R50	CTCK215	250	dry
	2.4856	Inconel 625	1.450 N/mm ²	XDKT 070308ER-F40 XDKT 11T308ER-F50	CTC5235	35	emulsion



If $a_e < 50\%$ use correction list

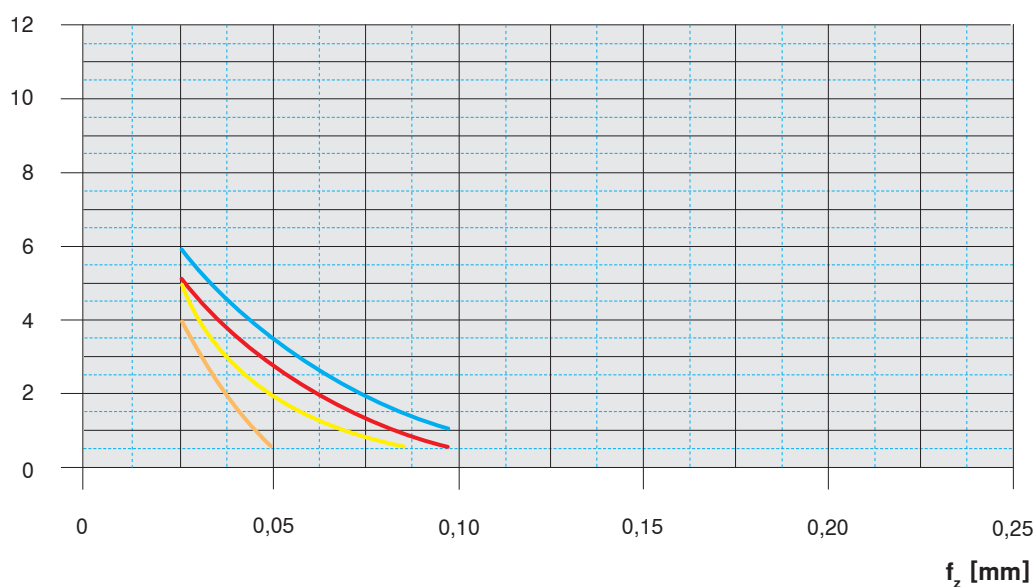


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a_p [mm]



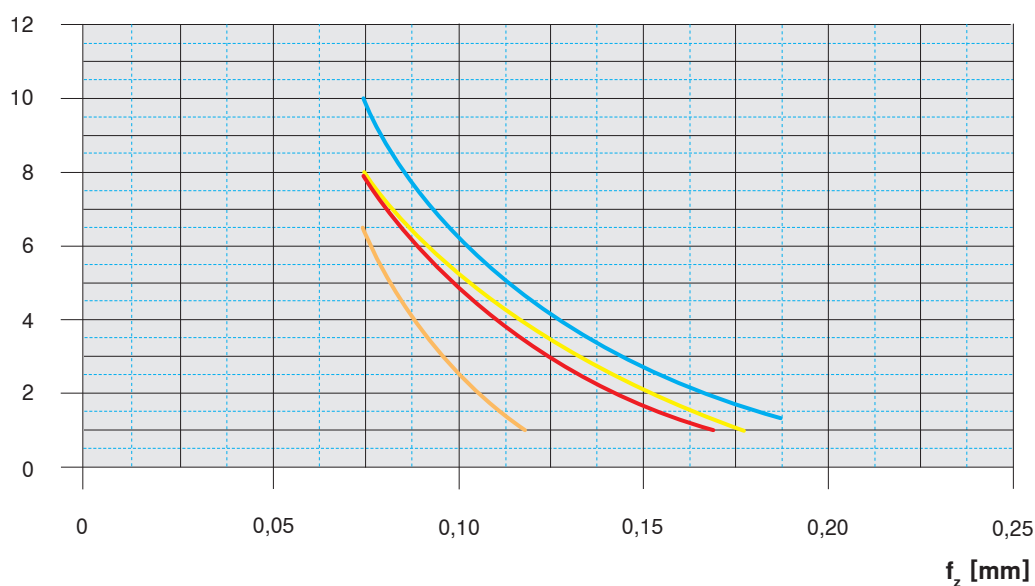
07



a_p [mm]



11



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