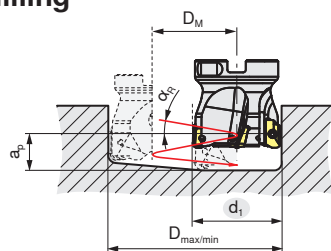


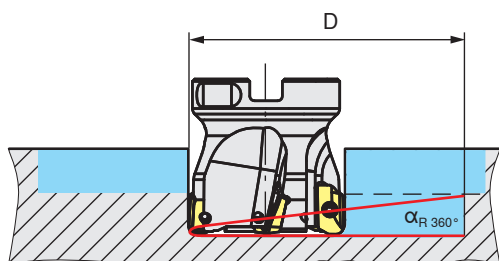
MaxiMill 211 system

Application data 211..07..

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 $D_{min} - d_1$

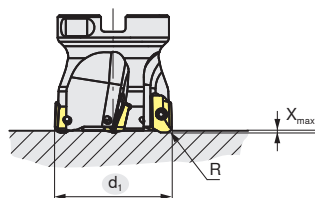


d_1 [mm]	$D_{max} / r.4$ [mm]	D_{min} [mm]	$\alpha_{R \max 360^\circ}$ [°]
10	19	13	5,5
12	23	17	6,0
16	31	25	3,0
20	39	33	2,0
25	49	43	1,5
32	63	57	1,2
40	79	73	0,8
50	99	93	0,7

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

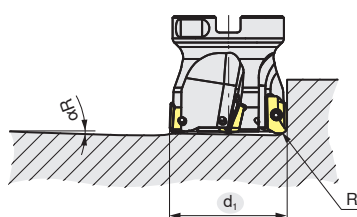
d_1 [mm]	D [mm]	$\alpha_{R \max 360^\circ}$ [°]
10	13	5,5
12	17	6,0
16	25	3,0
20	33	2,0
25	43	1,5
32	57	1,2
40	73	0,8
50	93	0,7

Axial plunging



d_1 [mm]	X_{max} [mm]
10	0,8
12	0,8
16	0,8
20	0,8
25	0,8
32	0,8
40	0,8
50	0,8

Angled ramping



d_1 [mm]	α_R [°]
10	11,0
12	7,9
16	4,3
20	3,0
25	2,5
32	1,6
40	1,2
50	1,0