

Innovation



MaxiMill 274

High flexibility & smooth cutting action



EN



Application - customer benefits

Industries

- General mechanical engineering
- Mould and die production
- Aerospace
- Power generation, turbine construction

Materials

- Steel
- Stainless steel
- Cast iron
- Super alloys
- Titanium alloys
- Non ferrous materials

Typical components

- Turbine blades
- Unstable components



Product advantages

1 milling system for two insert types



Extremely positive position when mounted, enables smooth cutting action



New cutting edge version with enhanced insert position



Positive geometry



YOUR benefits

Flexible machining possibilities with best economy

Application on low power machines and unstable components possible

Perfect surface quality

Particularly suitable for 'exotic' materials



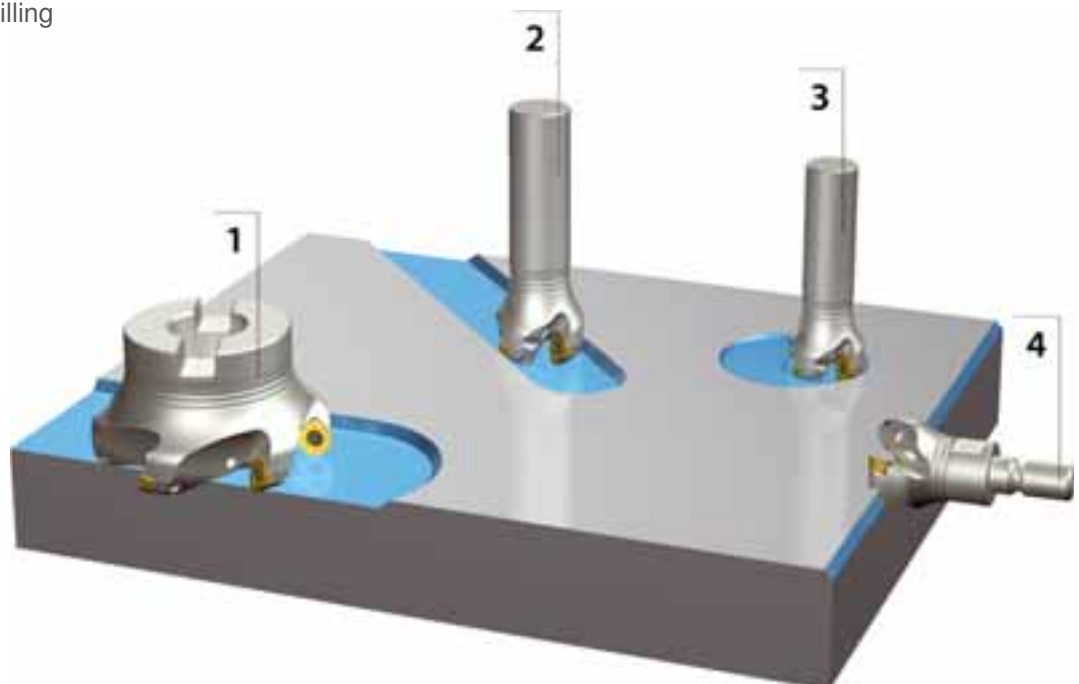
Maximum performance

- 1 tool body – 2 insert types
- SFHT 09: 4 cutting edges for $a_{p\ max} = 3.8\ mm$
- OFHT 06: 8 cutting edges for maximum economy
- Very low power consumption



System MaxiMill 274

- 1 Face milling
- 2 Slot milling
- 3 Helical plunge milling
- 4 Chamfering





The geometries

OFHT – 04 with chip groove -F10

'The sharpest in its class'



Feed rate/tooth	0.05 – 0.3 mm
Application	aluminium + non ferrous metals
Grades	CTW4615
Depth of cut	0.1 – 2.5 mm

OFHT – 04 with chip groove -F50

For 'exotic' materials



Feed rate/tooth	0.1 – 0.3 mm
Application	heat resistant materials, stainless steel, super alloys, titanium, steel, cast iron
Grades	CTP2235,CTC5235,CTP1235,SR226+
Depth of cut	0.05 – 2.5 mm

OFHT – 04 with chip groove -M50

For steel and cast iron applications



Feed rate/tooth	0.1 – 0.4 mm
Application	steel, cast iron, heat resistant materials, stainless steel
Grades	CTP1235,SR226+,CTC3215, CTP2235
Depth of cut	0.05 – 2.5 mm



The geometries

SFH/KT – 09 with chip groove -M50

Depth of cut 3.8 mm possible with minimum cutting forces



Feed rate/tooth	0.1 – 0.4 mm
Application	steel, stainless steel, cast iron
Grades	CTP1235, SR226+
Depth of cut	0.05 – 3.8 mm

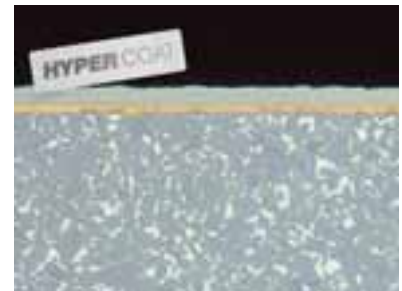
Cutting materials

See entire program
for system 274
in catalogue No. 500.



CTC5240

for super alloys



CTC3215

for cast iron



CTP1235

for steel



CTW4615

for non ferrous metals



CTC5235

for heat resistant



CTP2235

for stainless steel



SR226+

for steel & cast iron





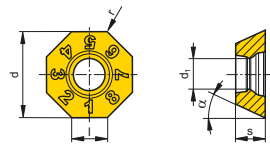
Program



l [mm]	Type, description	LNR 							d [mm]	d ₁ [mm]	s [mm]	r [mm]	α [°]
			CTW4615	CTC3215	SR226+	CTP1235	CTC5235	CTP2235					
4	OFHT 040305FN-F10	N	●						9,52	3,35	3,18	0,5	25°
	OFHT 040305SN-F50			●	●	●	●					0,2	
	OFHT 040305SN-M50		●	●	●		●						
	OFHW 040302EN						●						

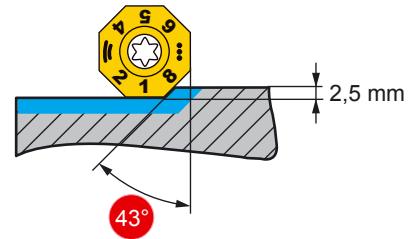


	CTW4615	CTC3215	SR226+	CTP1235	CTC5235	CTP2235	CTC5240
Steel	●	●	●	●	●	●	●
Stainless	○	○	○	○	○	○	○
Cast iron	●	●	●	○	●	●	●
Non ferrous metals	●	○	○	○	○	○	○
Heat resistant	○	○	○	○	○	○	○
Hard materials							



- Main application
- Extended application
- International CERATIZIT range, for present availability see price list


Ordering example: 10 pieces OFHT 040305FN-F10 CTW4615



SFH/KT

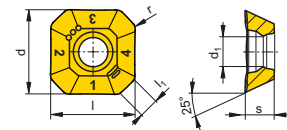


-M50

l [mm]	Type, description	LNR 					d [mm]	d ₁ [mm]	s [mm]	l ₁ [mm]	r [mm]
			SR226+	CTP1235	CTC5235	CTP2235					
9	SFKT 0903AFSR-F50	N	●				9,80	3,35	3,50	2,25	1,0
	SFKT 0903AFSR-M50		●	●							
	SFHT 0903AFSR-F50		●	●	●	●					

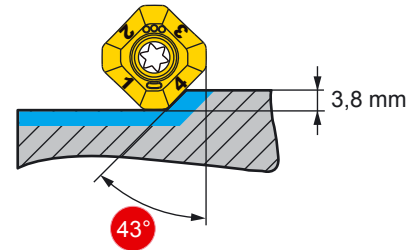


Steel	●	●	●	●	●
Stainless	○	○	○	○	○
Cast iron	●	●	●	●	●
Non ferrous metals	○	○	○	○	○
Heat resistant	○	○	○	○	○
Hard materials					



- Main application
- Extended application
- International CERATIZIT range, for present availability see price list

Ordering example: 10 pieces SFKT 0903AFSR-F50 CTC5235



CERATIZIT worldwide



- CERATIZIT worldwide production sites and support centres
- CERATIZIT worldwide distribution partner network



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