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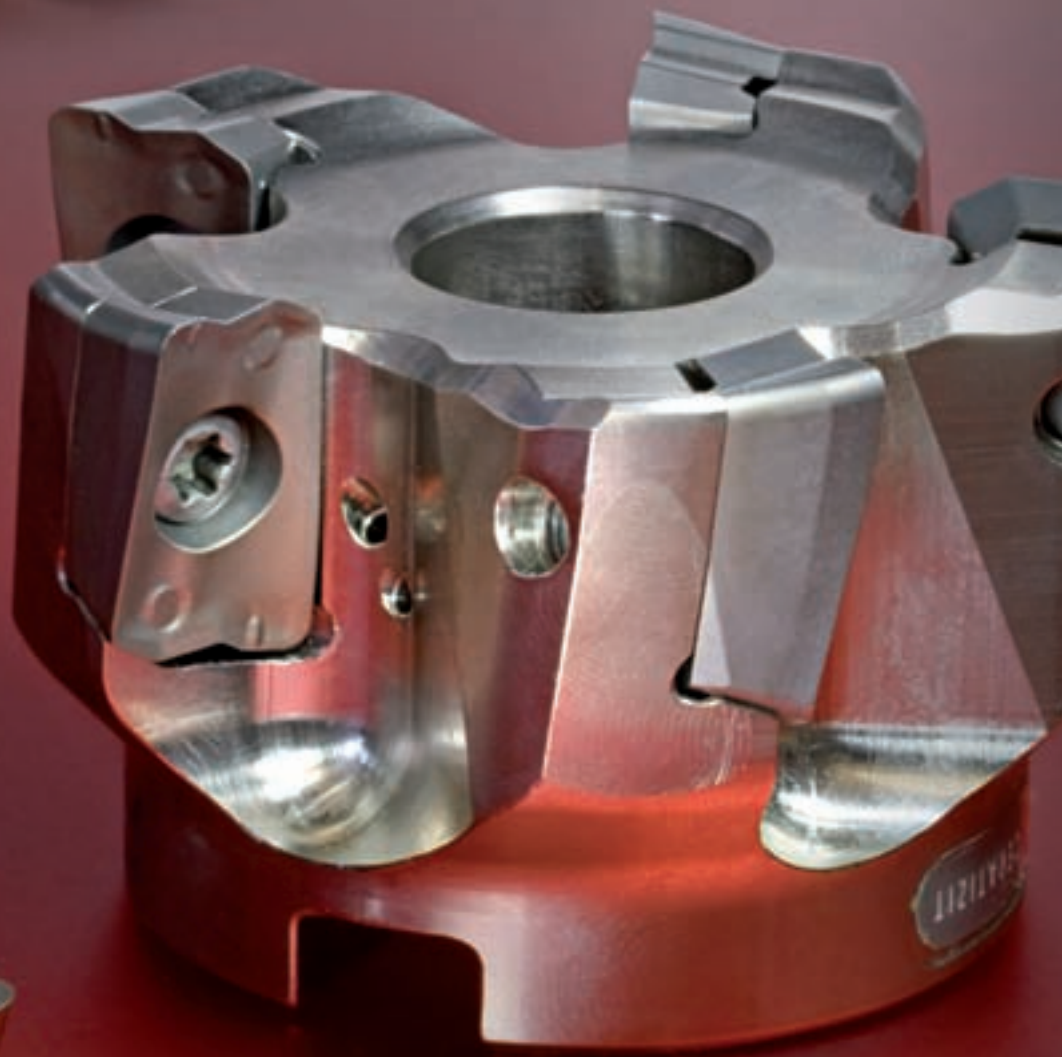
MaxiMill 211-20

The number 1 for exotic materials.



hard material matters

CERATZIT



hard material matters

Industries

- Aerospace
- Power generation, turbine construction
- Oil and gas extraction
- General engineering

Materials

High-tensile stainless steels

- Duplex
- Jetheat
- 17-4PH / 15-4PH/13-8PH

Titanium alloys

- TiAl 6 V4
- Ti-10-2-3
- Ti-5-5-5-3

Super alloys

- Inconel ®
- Hastelloy ®
- Nimonic ®

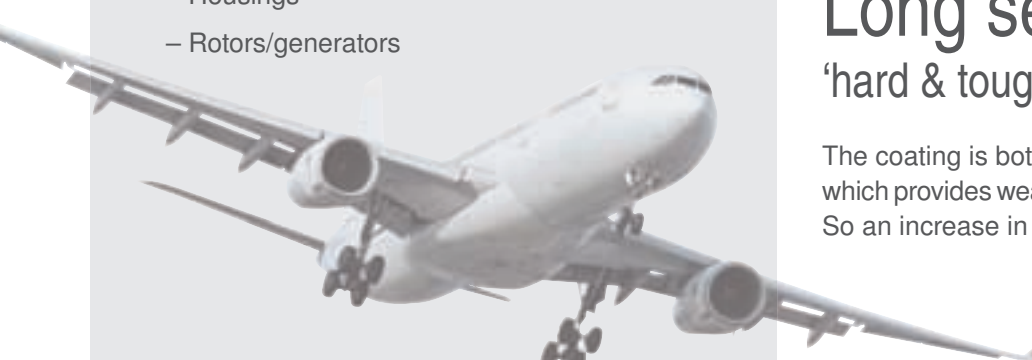
Typical components

Aerospace

- Undercarriage and structural components
- Guides for ailerons
- Engine components

Power generation

- Housings
- Rotors/generators

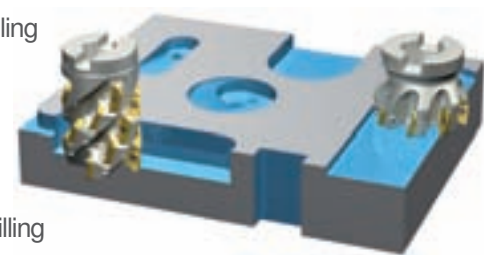


Many milling requirements

One solution: MaxiMill 211-20

Rough milling exotic materials at larger depths of cut is one of the most demanding and difficult of all machining applications. The exceptionally strong MaxiMill 211-20 inserts with their special location feature and light cutting action guarantee maximum process reliability for:

- Angled ramping & ramping
- Axial plunging & helical plunge milling
- Trochoidal groove milling
- Peripheral milling
- Shoulder milling
- Slot milling
- Shoulder and face milling



Force compensation through 'the notch'

The notch provides additional stability when plunging. Reduced machining noise without vibrations is therefore largely guaranteed.



Long service life thanks to 'hard & tough' tool coating

The coating is both extremely hard and tough, which provides wear protection and corrosion resistance. So an increase in the life of the tool is achieved.

The chip groove

-F40

- First choice for shoulder milling, medium and roughing cuts
- Light cutting, optimum chip formation, good component surfaces



The grades

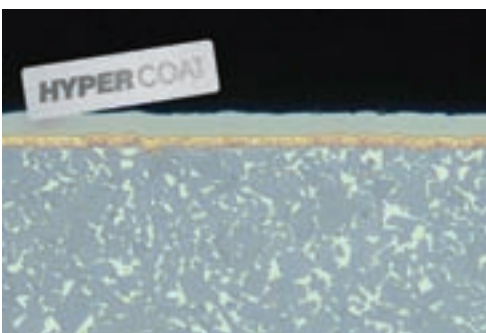
- Extraordinary heat resistance
- High toughness
- Excellent resistance to notching
- CVD high-performance coating with maximum hardness and extremely smooth surface

CTC5235



- High-tensile stainless steels

CTC5240



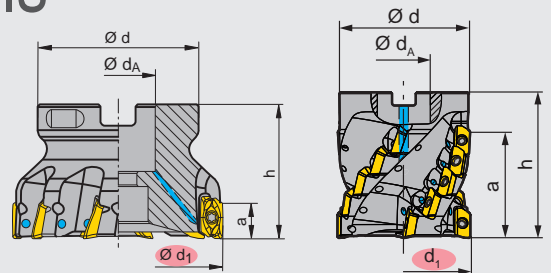
- Titanium alloys
- Super alloys

Application advantages



- Long tool life
20 – 100% improvement guaranteed, with optimum conditions an improvement up to 200% can be achieved
- Reduced machining time
+ 15 – 30% higher cutting speed, combined with maximum feed per tooth
- Maximum process security
 - Gradual wear
 - Predictable consistent tool life
 - Reduced risk of breakage
 - Scrap due to tool breakage virtually eliminated

Tested at the hardest conditions!



Tools



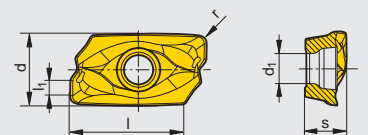
Shell mill cutter

d_1 [mm]	Type, description	h [mm]	a [mm]	d [mm]	d_A [mm]	 z	
63	A211.63.R.05-20	45	18	48	22	5	XDKT...
80	A211.80.R.06-20	50	18	58	27	6	XDKT...
100	A211.100.R07-20	50	18	78	32	7	XDKT...

Porcupine cutter

d_1 [mm]	Type, description	h [mm]	a [mm]	d [mm]	d_A [mm]	 z	 n
63	A211.63.R.04K4-20	92	68	58	27	4	16
80	A211.80.R.05K4-20	92	68	76	32	5	20

Inserts



r [mm]	Type, description	CTC5235	CTC5240	d [mm]	l [mm]	s [mm]	l_1 [mm]	d_1 [mm]
0,80	XDKT 200708ER-F40	•	•	12,5	18,0	6,93	2,8	5,5

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