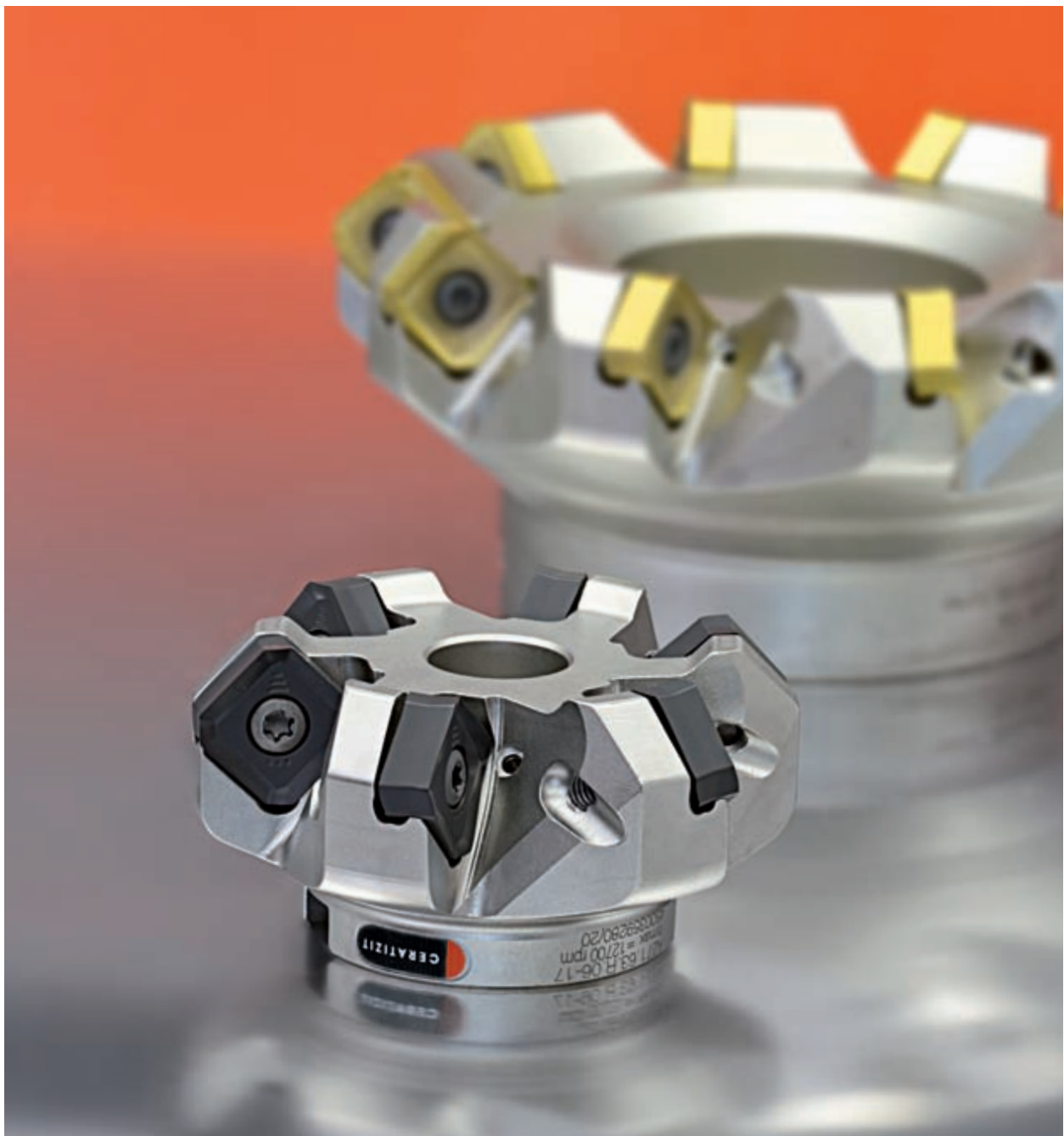


Innovation



MaxiMill 271-17

Smooth machining with substantial depth of cut



EN



Application - customer benefits

Industries

- General mechanical engineering
- Automotive industry
- Wind power industry
- Medium-rough machining

Typical components

- Machine beds
- Steel components
- Machine components
- Motorblocks

Materials

- Steel
- Stainless steel
- Cast iron

Product advantages

Maximum stability of the double-ended insert with positive clearance angle



Depth of cut 8.4 mm with 8 cutting edges



Optimized geometry and open chip pockets



Positive cutting edge aids chip flow



YOUR benefits

Good economy thanks to 8 effective cutting edges. Reduced vibration and low cutting forces ensure maximum cutting performance.

High productivity and economy

Optimum chip evacuation enables good process security

Even distribution of cutting forces avoids vibration

MAXIMUM POWER

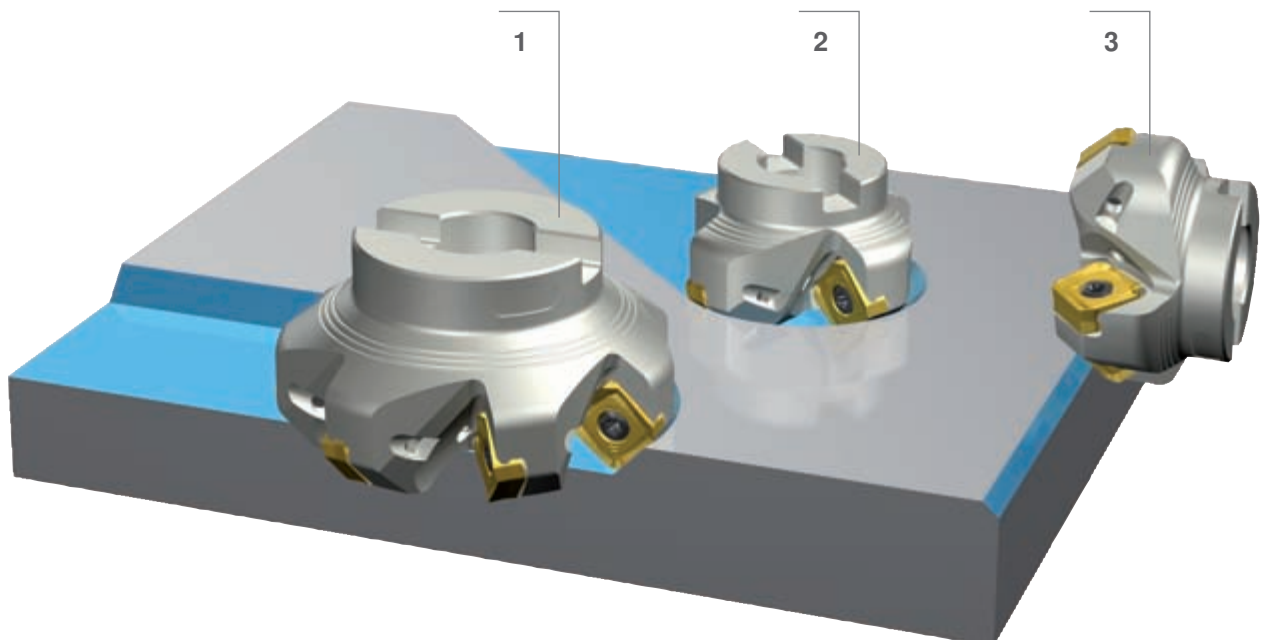
System 271

- Compact, rigid construction
- 8 effective cutting edges
- Maximum depth of cut 8.4 mm
- hard & tough** tool coating
- Coolant hole optimized for MQL (minimum quantity lubrication)
- Positive double-sided insert
- Stable cutting edges



Application range – system 271

- 1 Face milling
- 2 Slot milling
- 3 Chamfering





The geometry

- Excellent chip formation

-F50

Feed rates/tooth	0.1 – 0.35 mm
Application	steel, stainless steel, heat resistant
Depth of cut in mm	0.2 – 8 mm



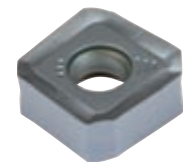
-M50

Feed rates/tooth	0.2 – 0.5 mm
Application	steel, cast iron
Depth of cut in mm	1 – 8 mm

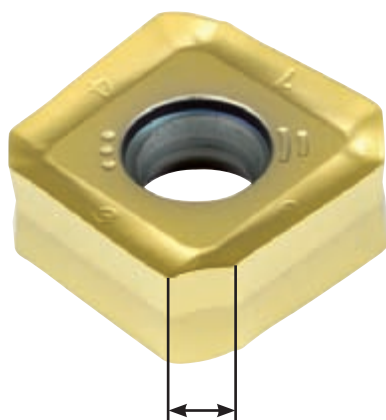


-R50

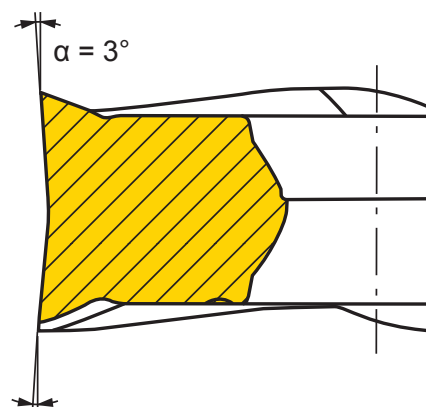
Feed rates/tooth	0.2 – 0.4 mm
Application	cast iron
Depth of cut in mm	1 – 8 mm



Insert Shape



Length of Masterfinish facet 3.3 mm



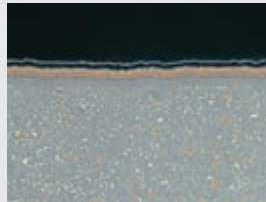
- Clearance angle 3°
- Clearance angle on Masterfinish facet 5°
- Angled cutting edge



Cutting materials

CVD coating

SR226+



steels in general

cast iron

PVD coating

CTP1235



steels in general

CVD coating

CTC5235



heat resistant

stainless steels

CVD coating

CTC3215



cast iron

PVD coating

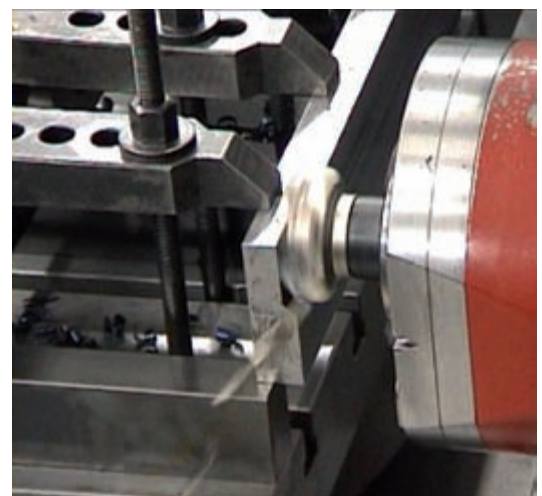
CTP3220



cast iron

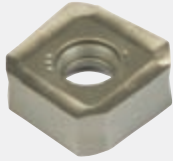
Practical example:

Machine: Excello 57KW
 Adapter: SK50 (DIN 69871 A)
 Material: CK 60 (1.1221) / 800 N/mm² / 96 x 299 x 800
 $v_c = 250$ M/min
 $a_p = 8$ mm
 $a_e = 65$ %
 $f_z = 0.25$ mm/tooth
 Coolant: dry





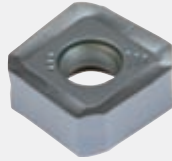
SAKU



-F50



-M50



-R50

l [mm]	Type, description	LNR 						d [mm]	s [mm]	l ₁ [mm]	r [mm]	d ₁ [mm]	α [°]
			SR226+	CTP1235	CTC5235	CTC3215	CTP3220						
17	SAKU 1706ABSR-F50	N	●	●	●								
	SAKU 1706ABSR-M50	N	●	●									
	SAKU 1706ABSR-R50	N				●	●						

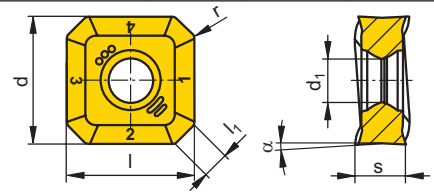


	SR226+	CTP1235	CTC5235	CTC3215	CTP3220
Steel	●	●	○	○	○
Stainless	○	○	○	○	○
Cast iron	●	●	●	●	●
Non ferrous metals	○	○	○	○	○
Heat resistant	○	○	○	○	○
Hard materials	○	○	○	○	○

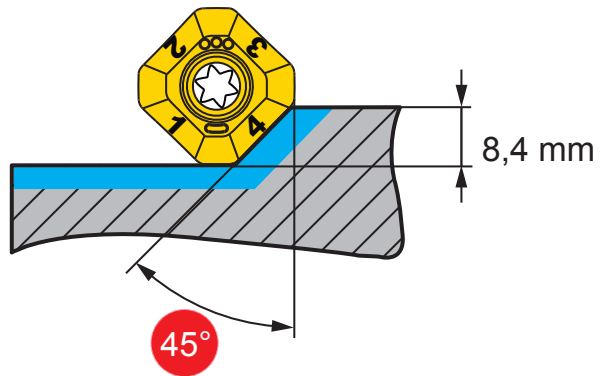
- Main application
- Extended application
- International CERATIZIT range, for present availability see price list

Ordering example: 10 pieces SAKU 1706ABSR-F50 CTP1235

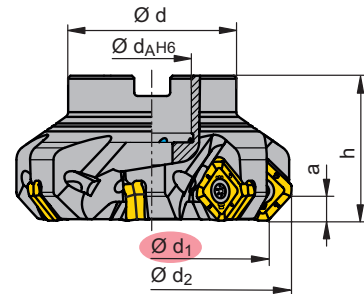
Additional grades and geometries will be available in the future.





Depth of cut up to 8.4 mm







A271-17

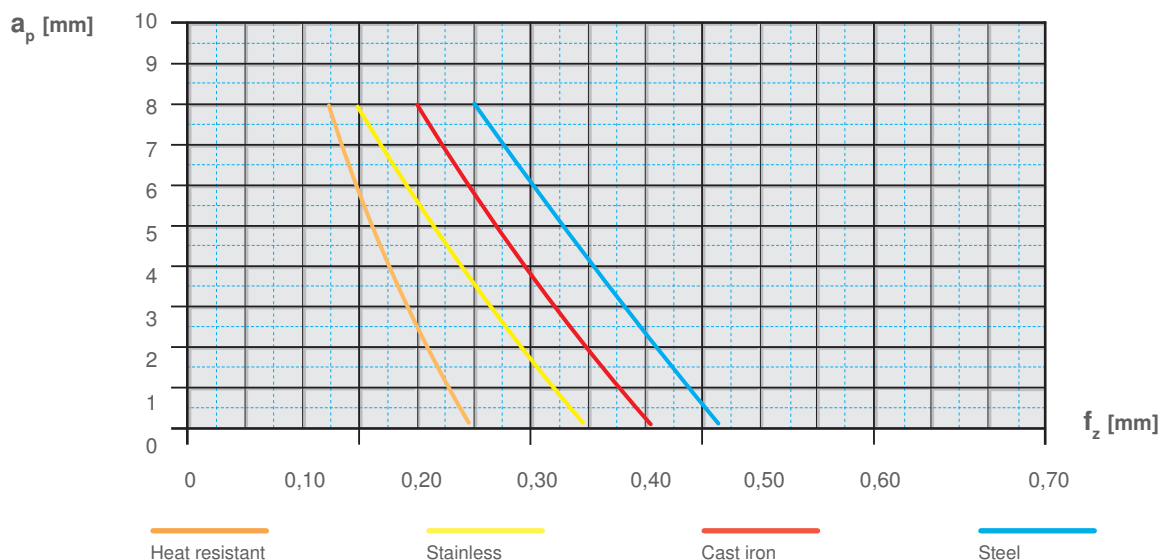


d ₁ [mm]	Type, description	d _a [mm]	d [mm]	d ₂ [mm]	h [mm]	a [mm]		
50	A271.50.R.04-17	22	43	66,1	40	8,4	4	SAKU 1706..
63	A271.63.R.06-17	22	48	79,1	40		6	SAKU 1706..
80	A271.80.R.07-17	27	58	96,1	50		7	SAKU 1706..
100	A271.100.R.08-17	32	79	116,1	50		8	SAKU 1706..
125	A271.125.R.10-17	40	88	141,1	63		10	SAKU 1706..
160	A271.160.R.12-17	40	104	176,1	63		12	SAKU 1706..
200	A271.200.R.13-17	60	134	216,1	63		13	SAKU 1706..
250	A271.250.R.15-17	60	134	266,1	63		15	SAKU 1706..

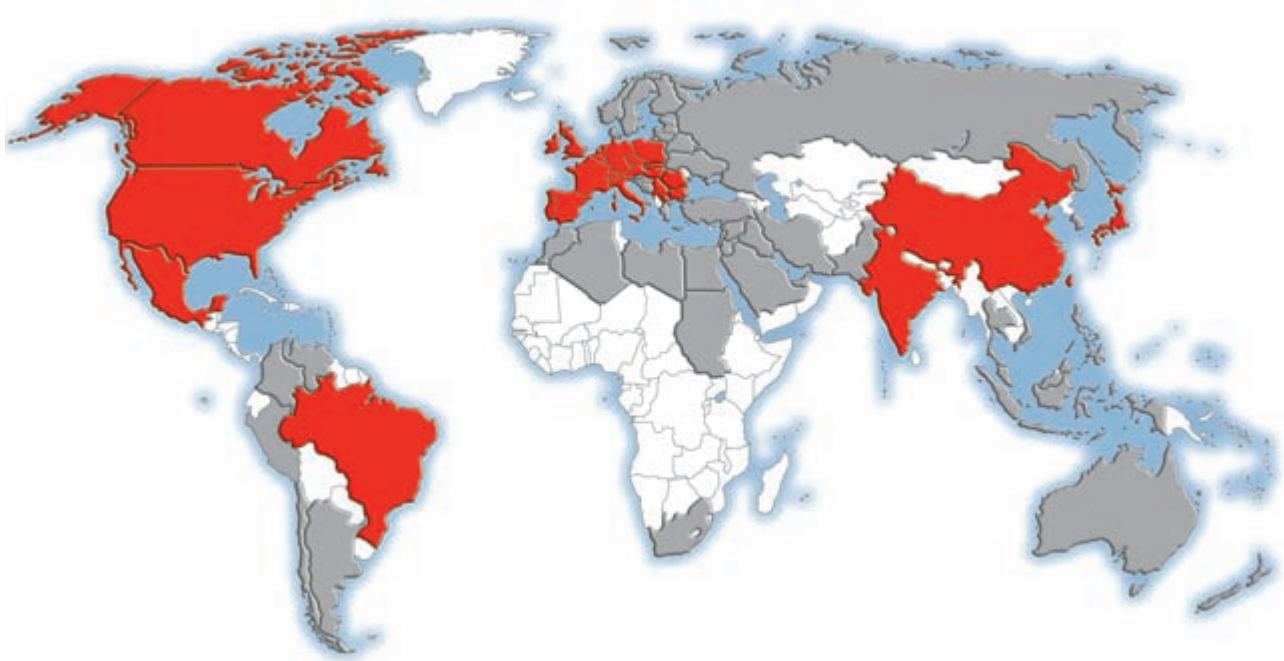
Ordering example: cutter body, insert clamping screws
 Ordering example: 1 pieces A271.50.R.04-17

	d ₁ [mm]				
SAKU 1706..	50-160	10000155 (M5,0x14,0)	7724104(T20)	DMSD 5,0Nm/SORT T20	

Starting parameters:



CERATIZIT worldwide



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



www.ceratizit.com

Parent company in Luxembourg

CERATIZIT Luxembourg Sàrl
Route de Holzem 101
L-8232 Mamer
Tel.: +352 312 085-1
Fax: +352 311 911
E-mail: info@ceratizit.com
www.ceratizit.com

Contact for further information:

CERATIZIT Austria Gesellschaft m.b.H.
A-6600 Reutte/Tyrol
Tel.: +43 (5672) 200-0
Fax: +43 (5672) 200-502
E-mail: info.austria@ceratizit.com
www.ceratizit.com

