

# Innovation



## MaxiMill 271-17

Maximum stability 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



### YOUR benefits

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

Depth of cut 8.4 mm with 8 cutting edges



High productivity and economy

Optimized geometry and open chip pockets



Optimum chip evacuation enables good process security

Positive cutting edge aids chip flow



Even distribution of cutting forces avoids vibration

# MAXIMUM POWER

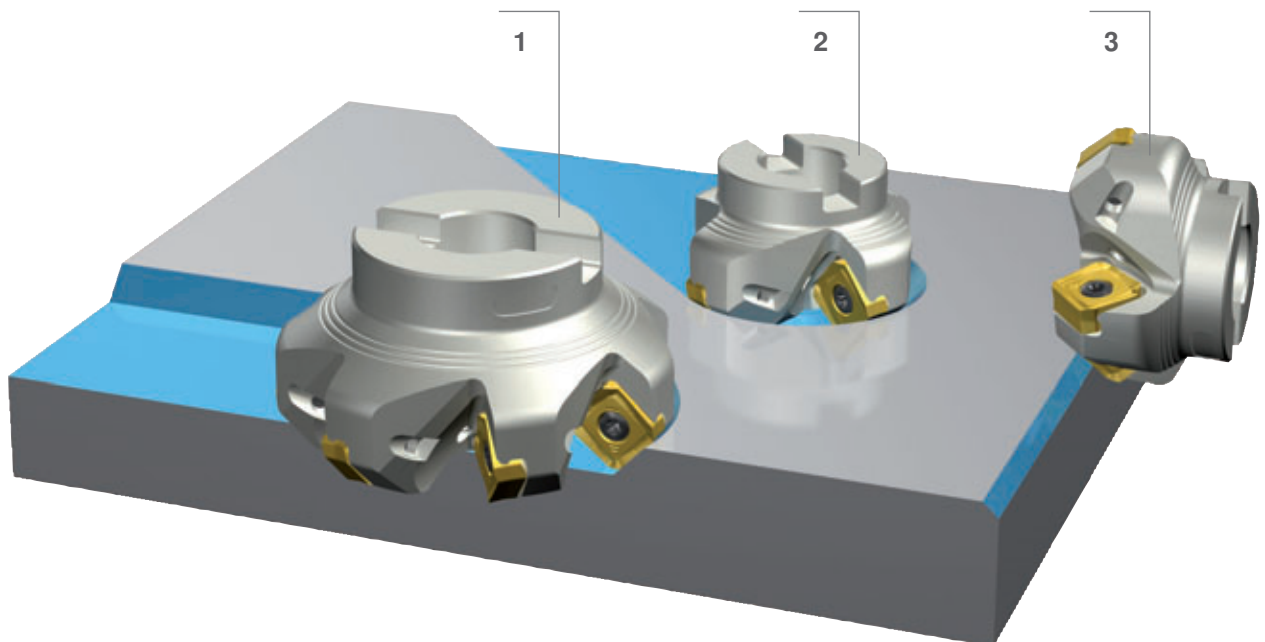
## System 271

- 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)



## Application range – system 271

- 1 Face milling
- 2 Slot milling
- 3 Chamfering

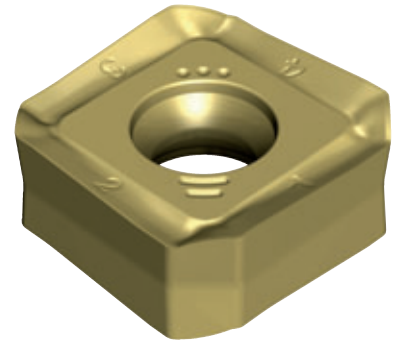




# The geometry

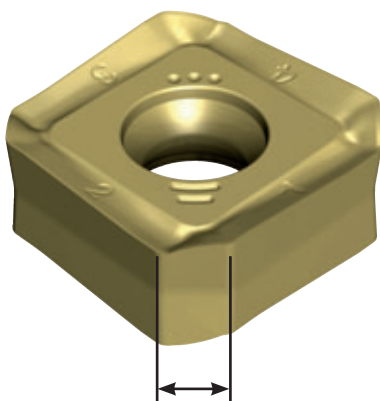
## -M50

- Positive double-sided insert
- 8 effective cutting edges
- Excellent chip formation
- Stable cutting edges
- Angled cutting edge

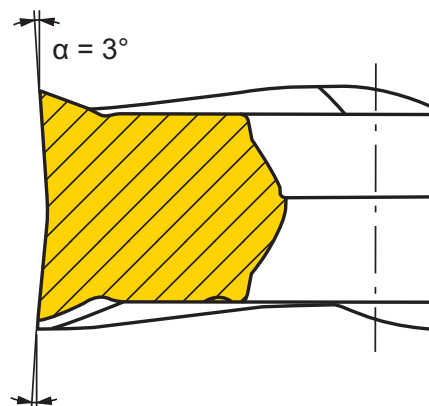


<b>Feed rates/tooth</b>	0.1 – 0.5 mm
<b>Application</b>	steel, stainless steel, cast iron
<b>Grades</b>	CTP1235, SR226+
<b>Depth of cut in mm</b>	0.2 – 8.4 mm

## Product characteristics – insert



Length of Masterfinish facet 3.3 mm



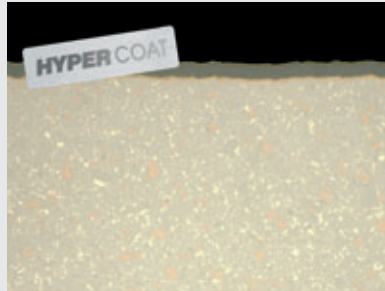
- Clearance angle 3°
- Clearance angle on Masterfinish facet 5°



# Cutting materials

PVD coating

## CTP1235

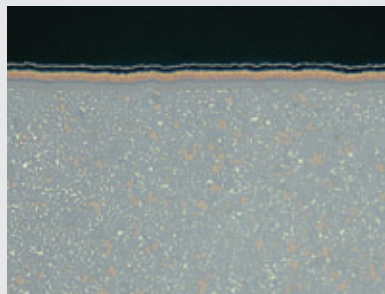


Steels in general

Stainless steels

CVD coating

## SR226+



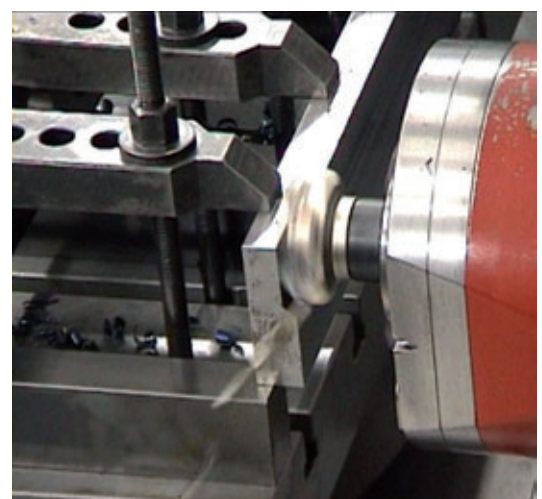
Steels in general

Stainless steels

Cast iron

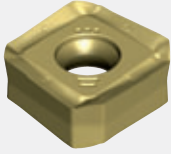
## Practical example:

Machine: Excello 57KW  
 Adapter: SK50 (DIN 69871 A)  
 Material: CK 60 (1.1221) / 800 N/mm<sup>2</sup> / 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



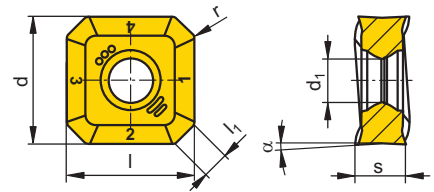
-M50

l [mm]	Type, description	L N R 	CTP1235		d [mm]	s [mm]	l <sub>1</sub> [mm]	r [mm]	d <sub>1</sub> [mm]	α [mm]
			SR226+							
17	SAKU 1706ABSR-M50	N	●	●	17	6,35	3,7	0,8	5,8	3



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

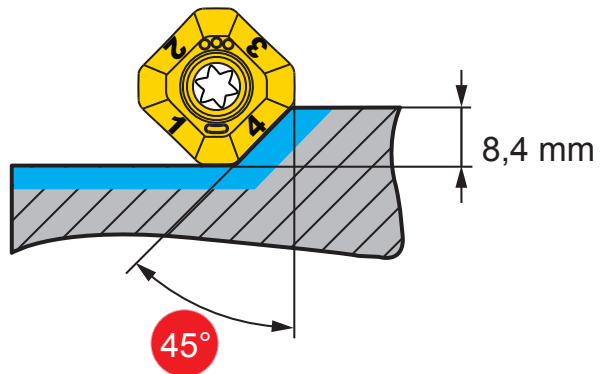
- Main application
- Extended application
- International CERATIZIT range, for present availability see price list



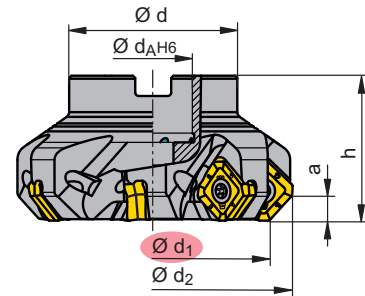
Ordering example: 10 pieces SAKU 170608SR-M50 CTP1235



Additional grades and geometries will be available in the future.

Depth of cut up to 8.4 mm






# A271-17

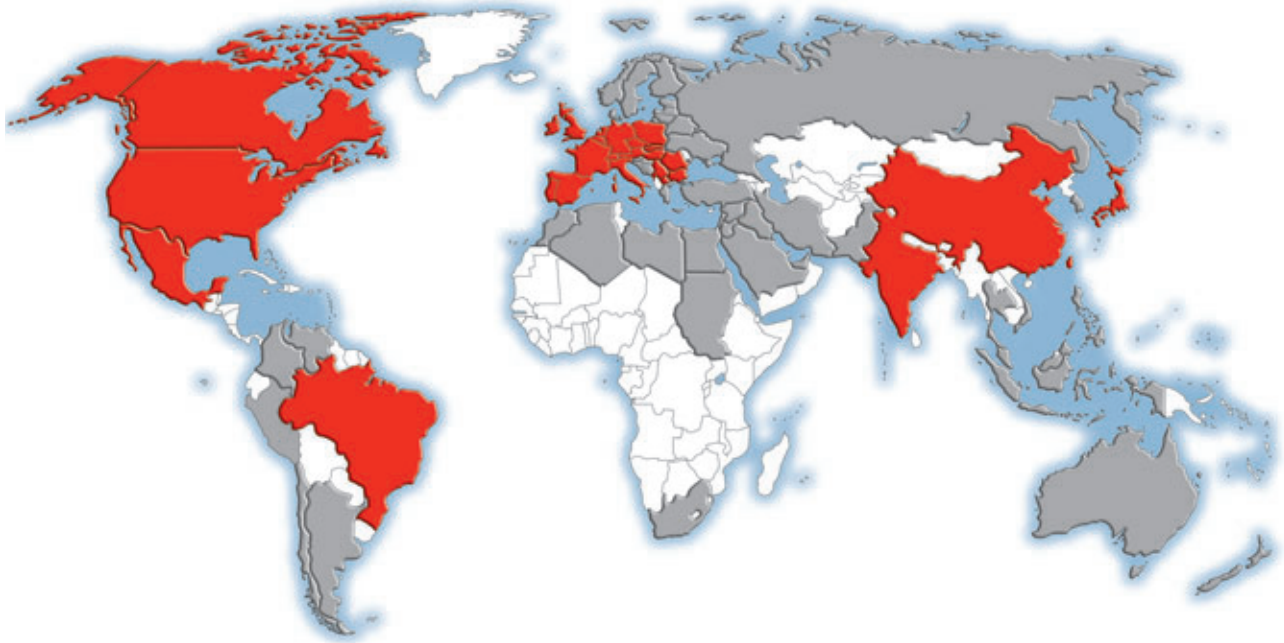


$d_1$ [mm]	Type, description	$d_a$ [mm]	$d$ [mm]	$d_2$ [mm]	$h$ [mm]	$a$ [mm]		
50	A271.50.R.04-17	22	43	66,1	40	8,4	4	SAKU 1706..
63	A271.63.R.06-17	22	48	79,1	40		6	SAKU 1706..
80	A271.80.R.07-17	27	58	96,1	50		7	SAKU 1706..
100	A271.100.R.08-17	32	79	116,1	50		8	SAKU 1706..
125	A271.125.R.10-17	40	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

	$d_1$ [mm]				
SAKU 1706..	50-160	10000155 (M5,0x14,0)	7724104(T20)	DMSD 5,0Nm/SORT T20	

## CERATIZIT worldwide



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



[www.ceratizit.com](http://www.ceratizit.com)

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