

# 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

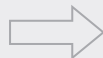
1 milling system for two insert types



## YOUR benefits

Flexible machining possibilities with best economy

Extremely positive position when mounted, enables smooth cutting action



Application on low power machines and unstable components possible

New cutting edge version with enhanced insert position



Perfect surface quality

Positive geometry



Particularly suitable for 'exotic' materials



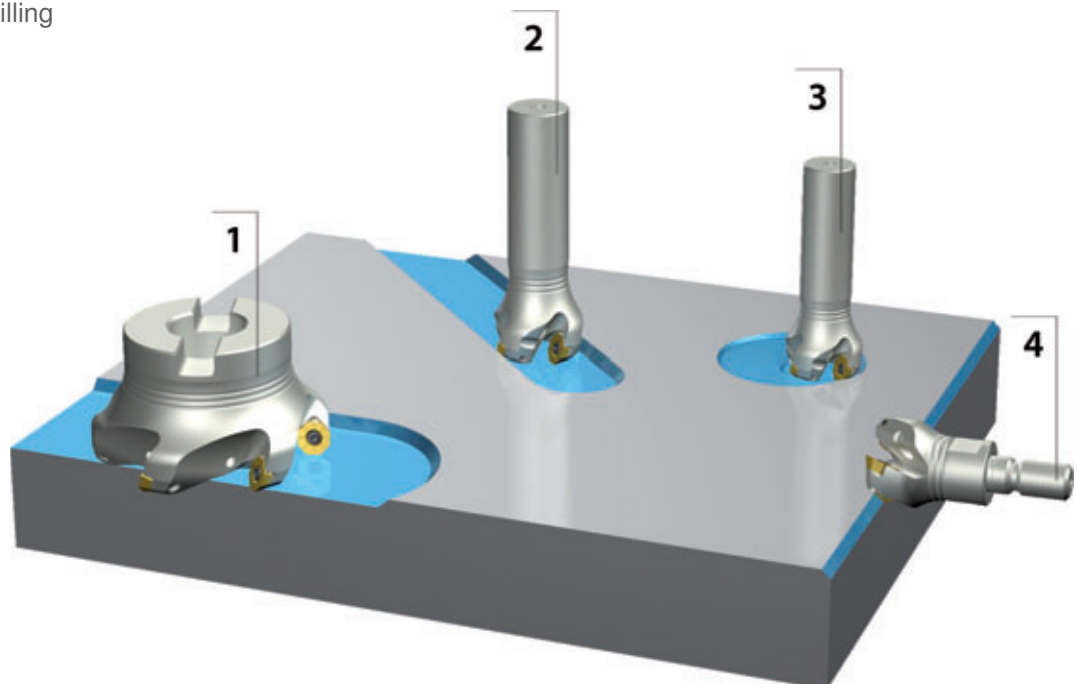
## Maximum performance

- 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

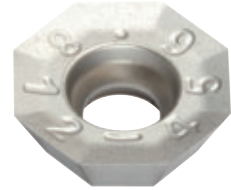




# The geometries

## OFHT – 04 with chip groove -F10

'The sharpest in its class'



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

## OFHT – 04 with chip groove -F50

For 'exotic' materials



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

## OFHT – 04 with chip groove -M50

For steel and cast iron applications



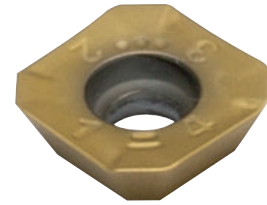
<b>Feed rate/tooth</b>	0.1 – 0.4 mm
<b>Application</b>	steel, cast iron, heat resistant materials, stainless steel
<b>Grades</b>	CTP1235,SR226+,CTC3215, CTP2235
<b>Depth of cut</b>	0.05 – 2.5 mm



# The geometries

## SFH/KT – 09 with chip groove -M50

Depth of cut 3.8 mm possible with minimum cutting forces



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

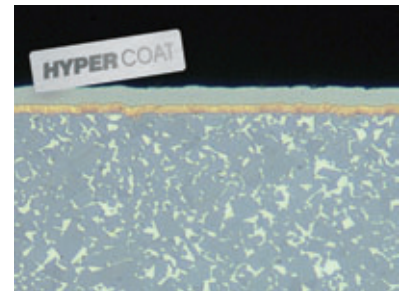
# Cutting materials

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



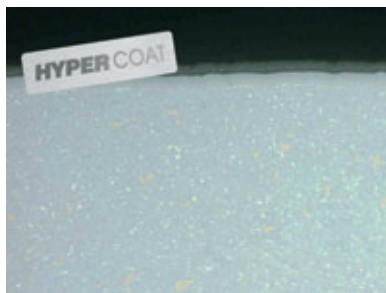
### CTC5240

for super alloys



### CTC3215

for cast iron



### CTP1235

for steel



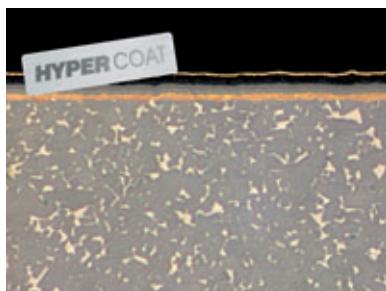
### CTW4615

for non ferrous metals



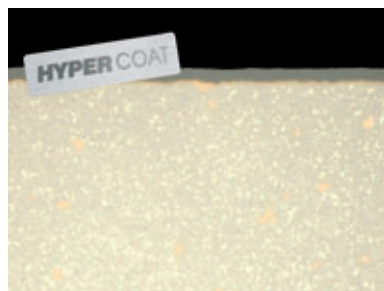
### CTC5235

for heat resistant



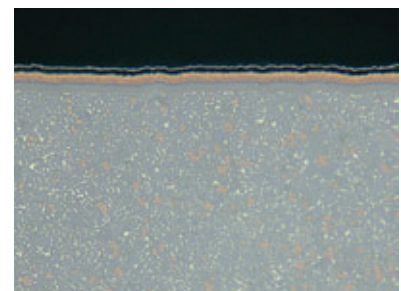
### CTP2235

for stainless steel



### SR226+

for steel & cast iron



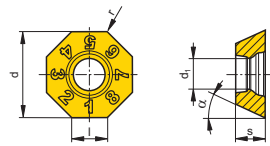




l [mm]	Type, description	LNR 							d [mm]	d <sub>1</sub> [mm]	s [mm]	r [mm]	α [°]
			CTW4615	CTC3215	SR226+	CTP1235	CTC5235	CTP2235					
4	OFHT 040305FN-F10	N	●						9,52	3,35	3,18	0,5	25°
	OFHT 040305SN-F50			●	●	●	●						
	OFHT 040305SN-M50		●	●	●		●						
	OFHW 040302EN						●	●					

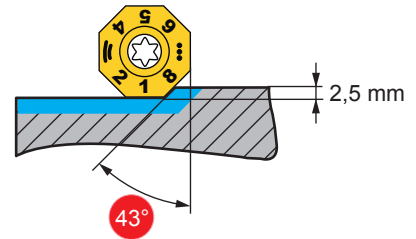


Steel	●	●	●	●	●	●
Stainless	●	○	○	●	●	●
Cast iron	●	●	●	○	●	●
Non ferrous metals	●	●	●	●	●	●
Heat resistant	●	●	●	●	●	●
Hard materials						

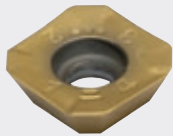


- Main application
- Extended application
- International CERATIZIT range, for present availability see price list


Ordering example: 10 pieces OFHT 040305FN-F10 CTW4615



# SFH/KT

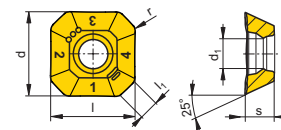


-M50

l [mm]	Type, description	LNR 					d [mm]	d <sub>1</sub> [mm]	s [mm]	l <sub>1</sub> [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		●	●	●	●					

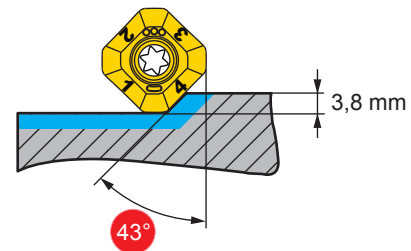


Steel	●	●	●	●	●
Stainless	●	●	●	●	●
Cast iron	●	●	●	●	●
Non ferrous metals	●	●	●	●	●
Heat resistant	●	●	●	●	●
Hard materials					

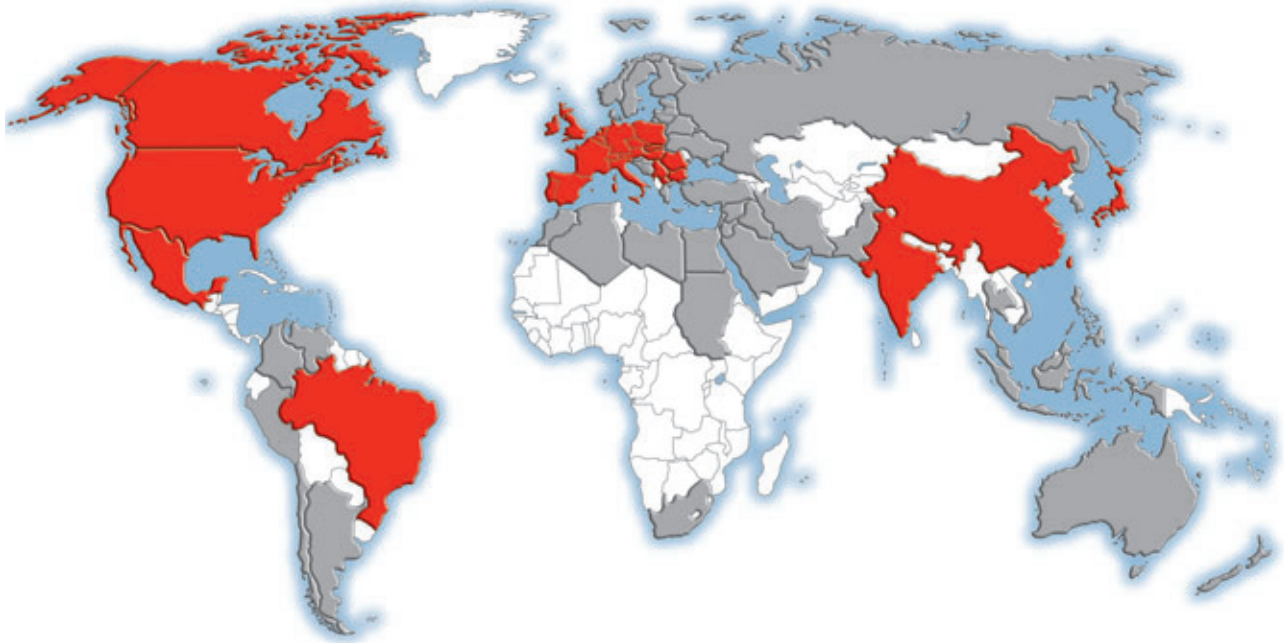


- Main application
- Extended application
- International CERATIZIT range, for present availability see price list

Ordering example: 10 pieces SFKT 0903AFSR-F50 CTC5235



## CERATIZIT worldwide



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



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

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