

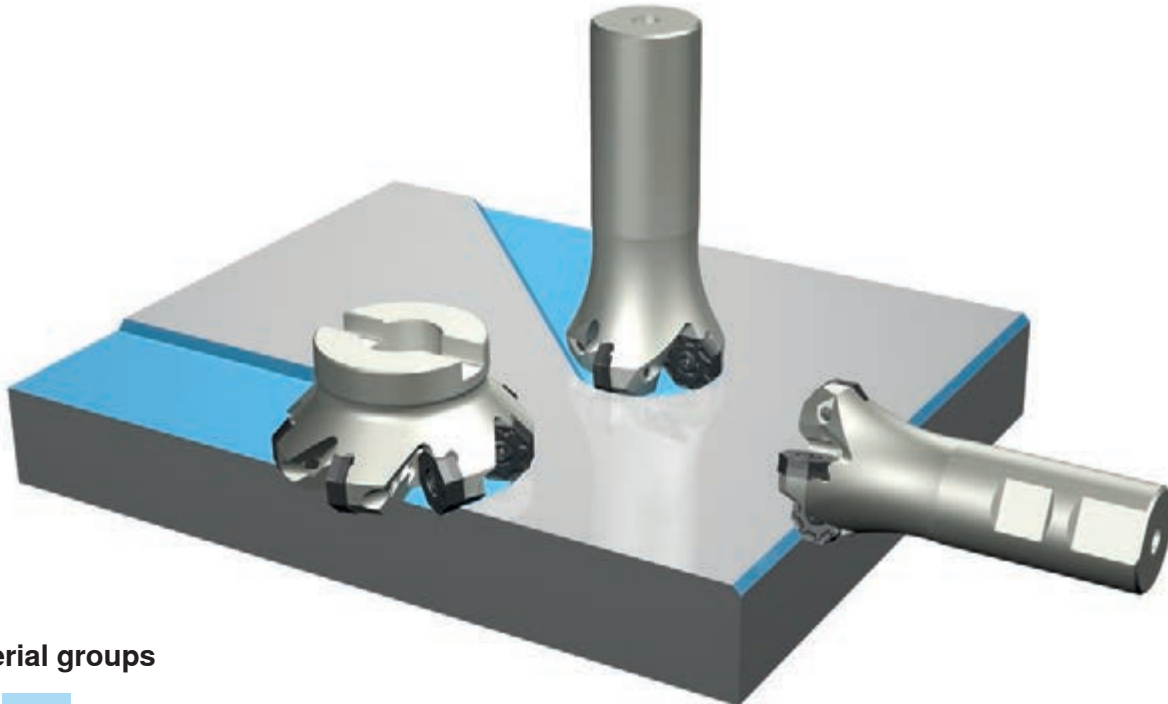
# CERATIZIT HIGHLIGHTS – MORE THAN A BRAND

Cutting Solutions by CERATIZIT is a top-class brand of the CERATIZIT GROUP. Our brand promise is supported by **a strong and creative partner** who has only one goal: to achieve the best for you together!



## Economic face milling for a wide range of materials

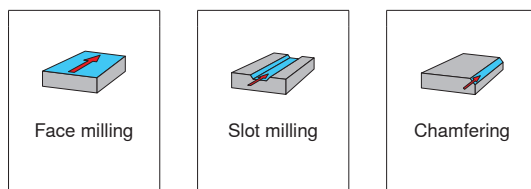
- 16 cutting edges
- Stability and process security combined with low power consumption



### Material groups

P	●
M	○
K	●
N	○
S	○
H	

### Possible applications



### Detailed information

Pitch	Ø range	Inserts
	<p>Ø 32 - 315 mm</p>	<p>OAKU 06..</p>



# MaxiMill 273 system

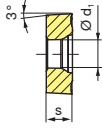
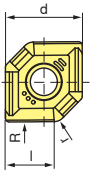
XA..



-M50



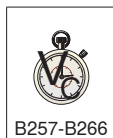
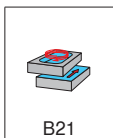
XAHT 060525SL-M50  
XAHT 060525SR-M50







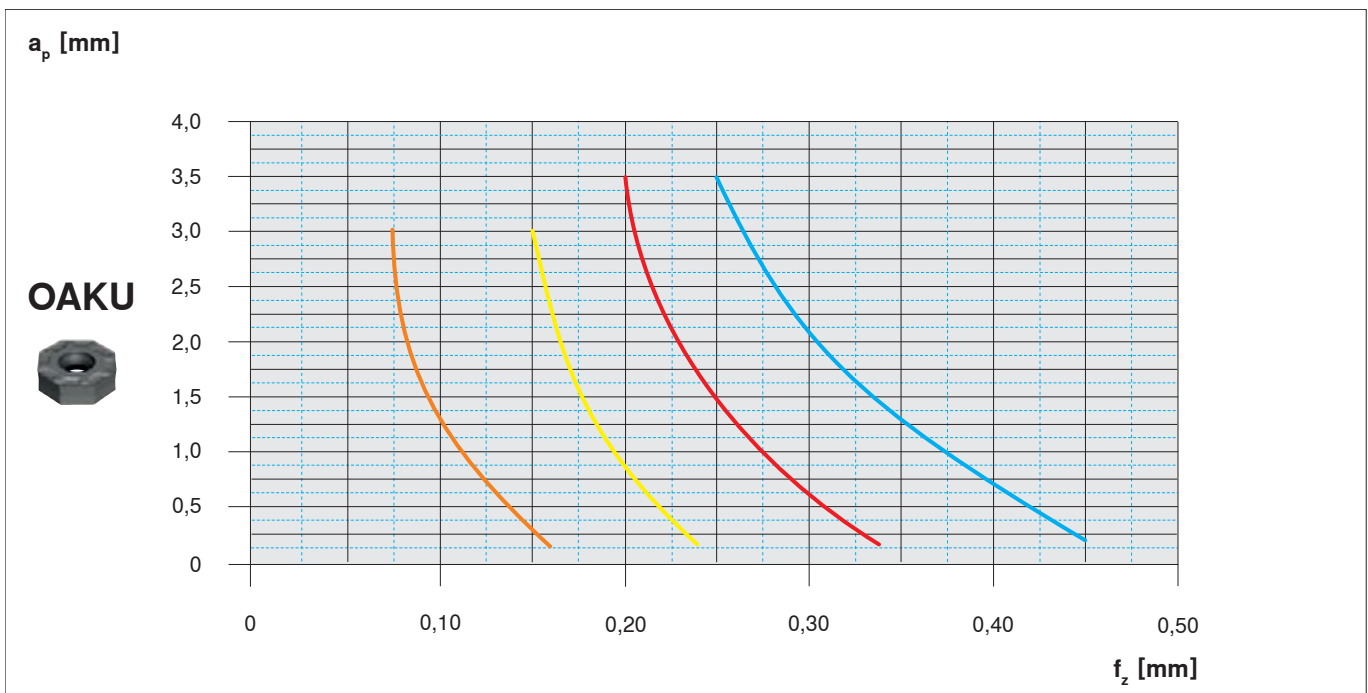
	CTEP210	TCM10	CTCP220	CTPP225	CTCP230	CTPP235	CTPM225	CTCM235	CTPM240	CTN3105	CTL3215	CTCK215	CTPK220	CTD4205	AMZ	H216T	CTW4615	CTC5235	CTC5240	CTP6215	
<b>P</b>	●	●	●	●	●	●	○	○	○						○						
<b>M</b>	●																				
<b>K</b>	○														○						
<b>N</b>																					
<b>S</b>																					
<b>H</b>											○										

d	l	s	r	d <sub>1</sub>	R
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
17.08	8.40	5.56	2.50	6.00	640
17.08	8.40	5.56	2.50	6.00	640

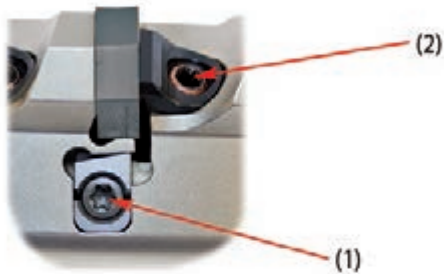
d	l	s	r	d <sub>1</sub>	R



Materials				Insert		$v_c$ [m/min]	Coolant
	1.2312	40CrMnMoS8-6	1.000 N/mm <sup>2</sup>	OAKU 060508SR-M50	CTPP235	200	dry
	1.4571	X6CrNiMoTi17-12-2	600 N/mm <sup>2</sup>	OAKU 060508SR-F50	CTPM240	180	dry
	5.1301	EN-GJL-250	HB 180	OAKU 060508SR-R50	CTCK215	250	dry
	2.4856	Inconel 625	1.450 N/mm <sup>2</sup>	OAKU 060508SR-F40	CTC5235	35	emulsion



### Precision setting procedure



1. Mount the setting wedges in the cutter (as supplied) and tighten the setting screw (1), to lightly hold the wedge without deforming it.
  2. Mount inserts and tighten clamping screws (2) with 1.0 Nm.
  3. Mark 'highest cutting edge' using a presetting device.
  4. Change position of PCD insert by 0.02 mm turning the setting screw (1) clockwise.  
For this purpose use the TORX key (8095018900 / WS-L-T15-136mm).
  5. Set the other cutting edges to this level, maximum deviation of 0.005 mm.
- Maximum adjustment = 0.10 mm.
6. Tighten all clamping screws (2) with 4.0 Nm (273-06).
  7. Check axial run-out of all inserts  
→ target < 0.005 mm.



When changing the insert, first remove the setting screw (1), turning it counter-clockwise. After the mounting procedure is completed, the setting procedure starts again at point 1.