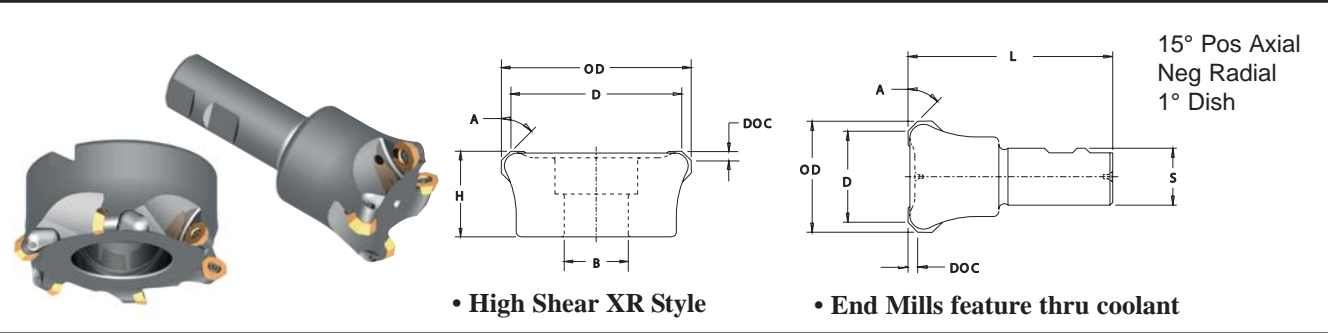
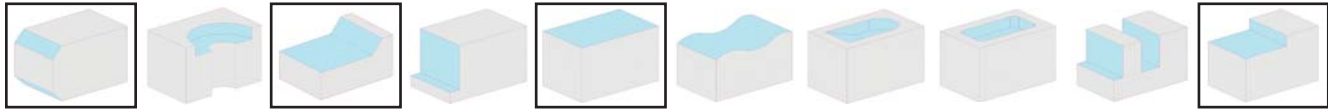


XR4 Series - 1/2" IC



XR4 Series - Dimensional Specifications

Face Mills								
Product Number	D	OD	B	H	A OECH / RECH	Max DOC OECH / RECH	Insert	# of Teeth
XRF2.00PN45OE4R.75	2.000	2.30	0.750	2.000	45° / R .250	.140 / R .250	OECH-432 / RECH-43	4
XRF2.50PN45OE4R.75	2.500	2.80	0.750	2.000	45° / R .250	.140 / R .250	OECH-432 / RECH-43	5
XRF2.50PN45OE4R1.00	2.500	2.80	1.000	2.000	45° / R .250	.140 / R .250	OECH-432 / RECH-43	5
XRF3.00PN45OE4R1.00	3.000	3.30	1.000	2.000	45° / R .250	.140 / R .250	OECH-432 / RECH-43	6
XRF4.00PN45OE4R1.50	4.000	4.29	1.500	2.000	45° / R .250	.140 / R .250	OECH-432 / RECH-43	6
End Mills								
Product Number	D	OD	S	L	A OECH / RECH	Max DOC OECH / RECH	Insert	# of Teeth
XRE1.25PN45OE4RW.75	1.250	1.55	0.750	4.25	45° / R .250	.140 / R .250	OECH-432 / RECH-43	3
XRE1.50PN45OE4RW.75	1.500	1.80	0.750	4.25	45° / R .250	.140 / R .250	OECH-432 / RECH-43	3
XRE2.00PN45OE4RW1.00	2.000	2.30	1.000	4.50	45° / R .250	.140 / R .250	OECH-432 / RECH-43	4
XRE2.00PN45OE4RW1.25	2.000	2.30	1.250	4.50	45° / R .250	.140 / R .250	OECH-432 / RECH-43	4
XRE2.50PN45OE4RW1.25	2.500	2.79	1.250	4.50	45° / R .250	.140 / R .250	OECH-432 / RECH-43	5

LEFT HAND cutters also available

Insert I.C. x Thickness						
.500 x .188	Insert Pg. 38 OECH-432__	Insert Pg. 38 OECH-432-10F	Insert Pg. 40 RECH-43	Insert Pg. 40 RECH-43-10F	Insert Screw 3605-0001-0033	Insert Screw Wrench 1557-TX15

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
PH Type Stainless Steel 17-4, 15-5, 13-8	500 - 1200	.003 - .015	OECH-432W520 GR 606jRm	OECH-432W520 GR LTC-14
Austenitic Stainless Steel 302, 304, 316	400 - 1350	.003 - .015	OECH-432-10F GR 586XRm	OECH-432-10F GR LTC-10
Titanium Alloy 3A1-2.5V, 5A16Sn-2Zr-1mo, 6A14V	120 - 325	.003 - .015	RECH-43-10F GR 586XRm	RECH-43-10F GR LTC-10
Carbon Steel 1018, 1020, 1215	600 - 1500	.005 - .020	OECH-432W520 GR 606jRm	OECH-432W520 GR LTC-14
Alloyed Steel 4130, 4340, 6150	400 - 1200	.005 - .020	OECH-432W520 GR 606jRm	OECH-432W520 GR LTC-14
Tool Steel	350 - 1000	.005 - .020	OECH-432W520 GR 606jRm	OECH-432W520 GR LTC-14
Nickel Based Material K-Monel, Inconel 625, A286	100 - 650	.003 - .015	RECH-43-10F GR 586XRm	RECH-43-10F GR LTC-10
Aluminum 2024, 6061, 7072	900 - 4000	.003 - .015	OECH-432-10F GR 586XRm	OECH-432-10F GR LTX

- Multi-purpose positive/negative geometry optimizes horsepower utilization
- Engineered to perform at accelerated spindle velocities
- Pockets accept either round or octagon inserts to extend application range
- Staggered insert spacing counters harmonic vibration (chatter) on 4.00 dia. & up only
- Inserts available in NEW PVD AlTiN coated grades 586XRm and 606jRm



Index
Specials
Inserts
General
Cavity Mold
Gray Iron
PCD / CBN
Slotters
Technical Data
Holders