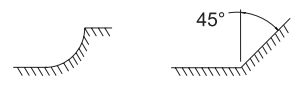


XR45 Series - 5/8" & 3/4" IC



Index

Specials

Inserts

General

Cavity Mold

Gray Iron

PCD / CBN

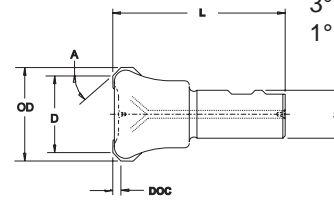
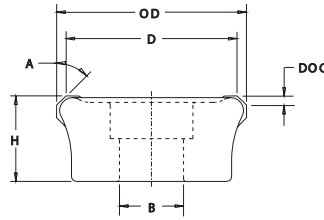
Sloters

Technical Data

Holders



• High Shear XR Style



15° Pos Axial
3° Neg Radial
1° Dish

• End Mills feature thru coolant

XR 45 Series - Dimensional Specifications

Face Mills									
Product Number	D	OD	B	H	A	DOC	Insert	Teeth	Weight
XRF2.00PN45OE5R.75	2.00	2.366	0.75	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	3	2.00
XRF2.50PN45OE5R1.00	2.50	2.866	1.00	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	4	2.75
XRF3.00PN45OE5R1.00	3.00	3.366	1.00	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	5	3.50
XRF4.00PN45OE5R1.50	4.00	4.366	1.50	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	6	5.00
XRF5.00PN45OE5R1.50	5.00	5.366	1.50	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	6	7.75
XRF2.00PN45OE6R.75	2.00	2.440	0.75	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	3	2.00
XRF2.50PN45OE6R1.00	2.50	2.940	1.00	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	4	2.75
XRF3.00PN45OE6R1.00	3.00	3.440	1.00	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	4	3.50
XRF4.00PN45OE6R1.50	4.00	4.440	1.50	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	5	5.00
XRF5.00PN45OE6R1.50	5.00	5.440	1.50	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	6	7.75
XRF6.00PN45OE6R2.00	6.00	6.440	2.00	2.00	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	7	9.00
XRF8.00PN45OE5R2.00	8.00	8.380	2.00	2.00	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	9	21.00

End Mills									
Product Number	D	OD	S	L	A	DOC	Insert	Teeth	Weight
XRE1.25PN45OE5RW.75	1.25	1.616	0.75	4.25	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	2	1.00
XRE1.25PN45OE5RW1.00	1.25	1.616	1.00	4.50	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	2	1.00
XRE1.50PN45OE5RW.75	1.50	1.866	0.75	4.25	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	3	1.25
XRE1.50PN45OE5RW1.00	1.50	1.866	1.00	4.50	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	3	1.25
XRE2.00PN45OE5RW1.00	2.00	2.366	1.00	4.50	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	3	1.50
XRE2.00PN45OE5RW1.25	2.00	2.366	1.25	4.50	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	3	1.50
XRE2.50PN45OE5RW1.25	2.50	2.866	1.25	4.50	45° / R.312	.173 / .312	OECH-534__ / RECH-53__	4	2.00
XRE2.00PN45OE6RW1.25	2.00	2.440	1.25	4.50	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	3	1.50
XRE2.50PN45OE6RW1.25	2.50	2.940	1.25	4.50	45° / R.375	.208 / .375	OECH-634__ / RECH-63__	4	2.00

LEFT HAND cutters also available

Insert I.C. Thickness	Insert Pg. 38	Insert Pg. 38	Insert Pg. 40	Insert Pg. 40	Insert Screw	Insert Screw Wrench
.625 x .188	OECH-534W520	OECH-534-10F	RECH-53W520	RECH-53-10F	3605-0001-0023	1557-TX20
.750 x .188	OECH-634W520	OECH-634-10F	RECH-63W520	RECH-63-10F		

Machining Parameters

Material	SFPM	FPT	Primary	Secondary
PH Type Stainless Steel 17-4, 15-5, 13-8	500-1200	.003-.015	OECH-634-10F GR 606jRm	OECH-634W520 GR LTC-14
Austenitic Stainless Steel 302, 304, 316	400-1350	.003-.015	OECH-634-10F GR 586XRm	OECH-634W520 GR LTC-10
Titanium Alloy 3A1-2.5V, 5A16Sn-2Zr-1mo, 6A14V	120-325	.003-.015	RECH-63-10F GR 586XRm	RECH-63-10F GR LTC-10
Carbon Steel 1018, 1020, 1215	600-1500	.005-.020	OECH-634W520 GR 606jRm	OECH-634W520 GR LTC-14
Alloyed Steel 4130, 4340, 6150	400-1200	.005-.020	OECH-634W520 GR 606jRm	OECH-634W520 GR LTC-14
Tool Steel	350-1000	.005-.020	OECH-634W520 GR 606jRm	OECH-634W520 GR LTC-14
Nickel Based Material K-Monel, Inconel 625, A286	100-650	.003-.015	RECH-63-10F GR 586XRm	RECH-63-10F GR LTC-10
Aluminum 2024, 6061, 7072	900-4000	.003-.015	OECH-634-10F GR LTC-10	RECH-63-10F GR LTC-10

- 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. and up only
- Inserts available in NEW PVD AlTiN coated grades 586XRm and 606jRm