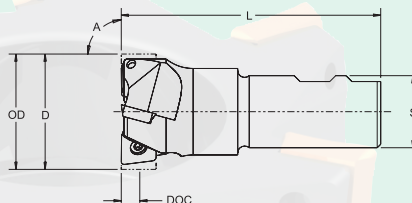
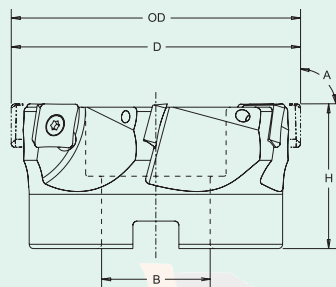
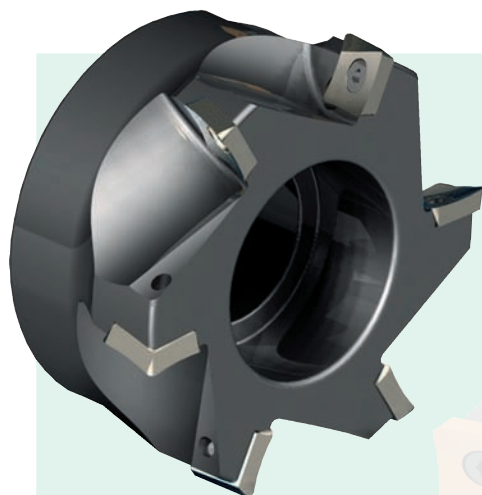
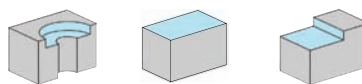


Positive Face Mills - 90° Shoulder



XR90 Series



Pos. Axial

Neg. Radial

90° Lead

XR90 Series End Mills - Dimensional Specifications

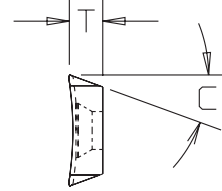
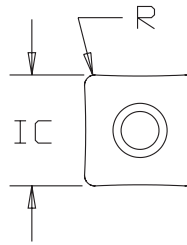
Product Number	D	OD	S	L	A	DOC	Teeth
XRE1.50PN90SE5RW.75	1.500	1.50	0.750	4.25	90°	0.540	2
XRE1.50PN90SE5RW1.00	1.500	1.50	1.000	4.50	90°	0.540	2
XRE2.00PN90SE5RW1.25	2.000	2.00	1.250	4.50	90°	0.540	3

XR90 Series Face Mills - Dimensional Specifications

Product Number	D	OD	B	H	A	DOC	Teeth
XRF2.00PN90SE5R.75	2.000	2.00	0.750	2.000	90°	0.540	3
XRF2.50PN90SE5R1.00	2.500	2.50	1.000	2.000	90°	0.540	4
XRF3.00PN90SE5R1.00	3.000	3.00	1.000	2.000	90°	0.540	5
XRF4.00PN90SE5R1.50	4.000	4.00	1.500	2.000	90°	0.540	6
XRF5.00PN90SE5R1.50	5.000	5.00	1.500	2.000	90°	0.540	7
XRF6.00PN90SE5R2.00	6.000	6.00	2.000	2.000	90°	0.540	7

Accessory Parts

Insert IC x Thickness				
	Insert see page 52	Insert see page 52	Insert Screw	Wrench
.500 x .188	SECH-534-10F	SECH-534_	3605-0001-0023	1557-TX20



New!

Insert Dimensional & Grade Specifications																				
Insert Number	IC	T	R	C	Geometry	586XRm					606jRm					908XRm				
SECH-534	0.625	0.188	0.062	23°	Flat		•	•	•	•	•	•								
SECH-534-10F	0.625	0.188	0.062	23°	+10° Dish		•		•	•		•						•		
SECH-534W520	0.625	0.188	0.062	23°	Flat w/land					•	•	•								

Machining Parameters				
Material	SFPM	FPT	Primary	Secondary
PH Type Stainless Steel 17-4, 15-5, 13-8	500 - 1200	.003 - .015	SECH-534-10F GR 606jRm	SECH-534W520 GR LTC-14
Austenitic Stainless Steel 302, 304, 316	400 - 1350	.003 - .015	SECH-534-10F GR 586XRm	SECH-534W520 GR LTC-10
Titanium Alloy 3A1-2.5V, 5A16Sn-2Zr-1mo, 6A14V	120 - 325	.003 - .015	SECH-534-10F GR 586XRm	SECH-534-10F GR LTC-10
Carbon Steel 1018, 1020, 1215	600 - 1500	.005 - .020	SECH-534W520 GR 606jRm	SECH-534W520 GR LTC-14
Alloyed Steel 4130, 4340, 6150	400 - 1200	.005 - .020	SECH-534W520 GR 606jRm	SECH-534W520 GR LTC-14
Tool Steel	350 - 1000	.005 - .020	SECH-534W520 GR 606jRm	SECH-534W520 GR LTC-14
Aluminum 2024, 6061, 7072	900 - 4000	.003 - .015	SECH-534-10F GR 908XRm	SECH-534-10F GR LTC-10

H = Hard Steel

P = Steel **M** = Stainless **K** = Cast Iron **N** = Non-Ferrous **S** = High Temp Alloy