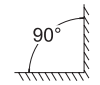
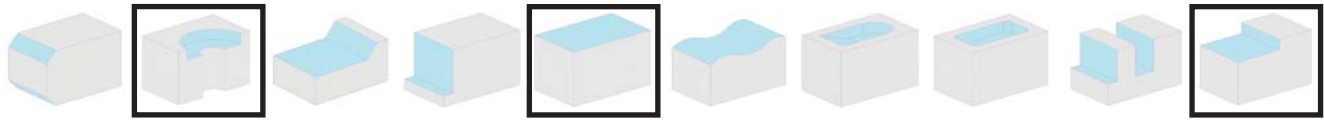


XR90 Series



15° Pos Axial
Neg Radial
90° Shoulder

Face Mill

End Mill

• End mills feature thru coolant

XR 90 Series - Dimensional Specifications

Face Mills									
Product Number	D	OD	B	H	A	DOC	Insert	Teeth	Weight
XRF2.00PN90SE5R.75	2.00	2.00	0.75	2.000	90°	.225	WSECH-534R	3	2.00
XRF2.50PN90SE5R1.00	2.50	2.50	1.00	2.000	90°	.225	WSECH-534R	4	2.75
XRF3.00PN90SE5R1.00	3.00	3.00	1.00	2.000	90°	.225	WSECH-534R	5	3.50
XRF4.00PN90SE5R1.50	4.00	4.00	1.50	2.000	90°	.225	WSECH-534R	6	5.00
XRF5.00PN90SE5R1.50	5.00	5.00	1.50	2.000	90°	.225	WSECH-534R	7	7.75
XRF6.00PN90SE5R2.00	6.00	6.00	2.00	2.000	90°	.225	WSECH-534R	7	9.00

End Mills									
Product Number	D	OD	S	L	A	DOC	Insert	Teeth	Weight
XRE1.50PN90SE5RW.75	1.50	1.50	0.75	4.25	90°	.225	WSECH-534R	2	1.00
XRE1.50PN90SE5RW1.00	1.50	1.50	1.00	4.50	90°	.225	WSECH-534R	2	1.25
XRE2.00PN90SE5RW1.25	2.00	2.00	1.25	4.50	90°	.225	WSECH-534R	3	1.50

LEFT HAND cutters also available

Insert I.C. Thickness			
	Insert Pg. 59	Insert Screw	Insert Screw Wrench
.625 x .188	WSECH-534R	3605-0001-0023	1557-TX20

PCD - Starting Parameters

Material	SFM Range	IPR Range	DOC Range
Aluminum Alloy - Silicon Aluminum	3,000 - 6,000	.006 - .012	.010 >
Brass - Bronze	1,500 - 3,000	.002 - .008	.005 >
Carbon	750 - 2,000	.004 - .008	.100 >
Copper - Copper Alloys	900 - 1,800	.004 - .008	.005 >
Fiberglass - Fiberglass Epoxy	1,500 - 3,000	.004 - .008	.010 >
Graphite - Graphite Composite	1,500 - 2,000	.004 - .008	.010 >
Phenolic Materials	1,500 - 3,000	.004 - .008	.010 >
Plastic	1,500 - 3,000	.008 - .012	.005 >
Tungsten Carbide (over 6% Cobalt)	45 - 150	.004 - .006	.002 - .010

- Multi-purpose positive/negative geometry optimizes horsepower utilization
- Engineered to perform at accelerated spindle velocities
- Non-rhythmic insert spacing counters harmonic vibration (chatter) on 4.00 dia. and up only
- Inserts available in PCD

