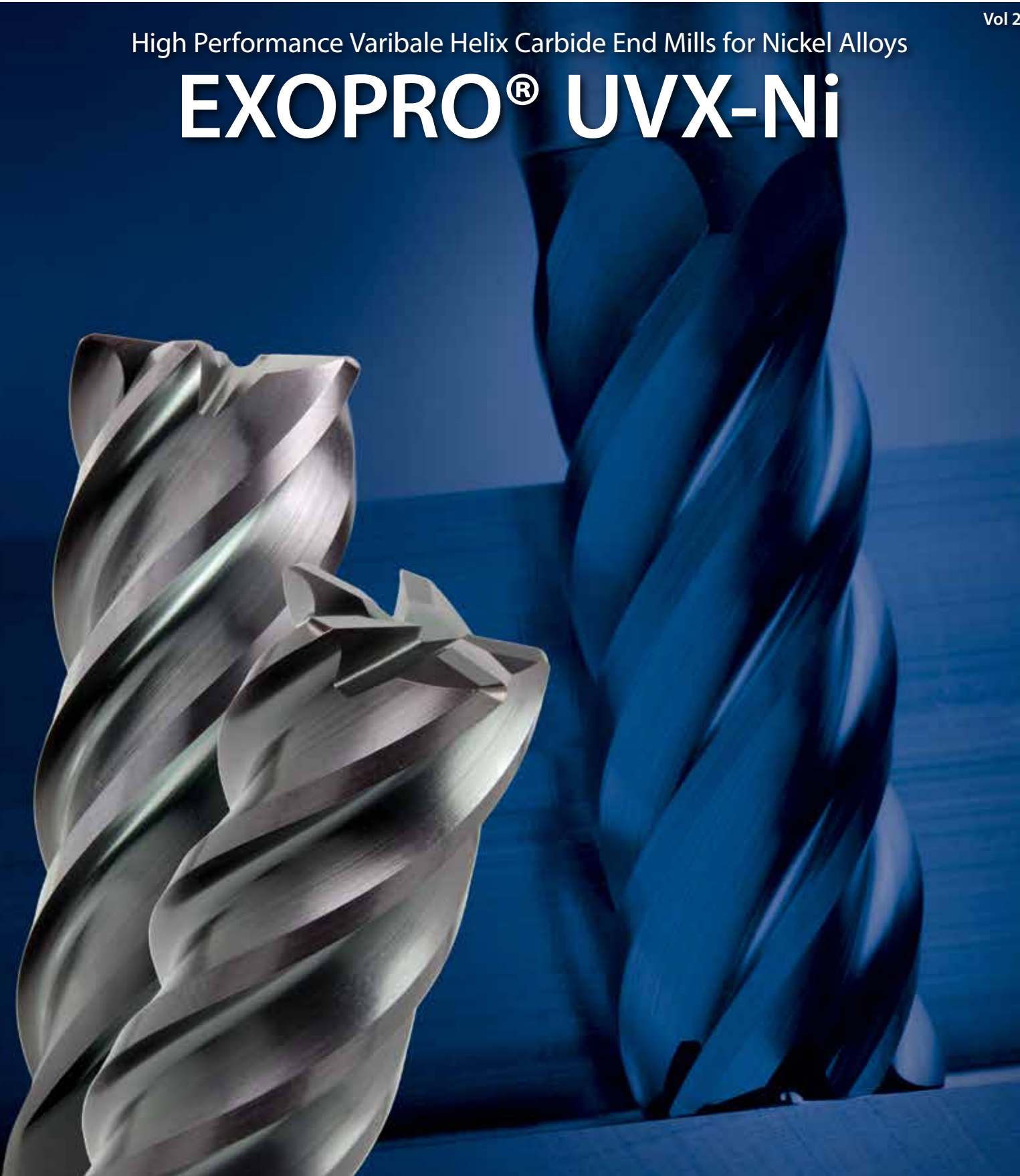




Vol 2

High Performance Variable Helix Carbide End Mills for Nickel Alloys

EXOPRO[®] UVX-Ni



The EXOPRO® UVX-Ni is OSG's ultra premium tooling series, featuring a variable helix and variable index design to reduce vibration, along with a unique flute form to facilitate excellent chip shape and evacuation. Its proprietary cutting edge geometry further reduces cutting heat and forces, allowing it to achieve stable performance in difficult-to-machine materials such as Inconel 718.



EXOPRO® UVX-Ni Features

Variable Helix / Variable Index

Vibration absorption enables stable machining

Proprietary Cutting Edge Geometry

Reduction of cutting heat and forces

Corner Protection

Radius with variable negative rake for strong cutting corners

Unique Flute Form

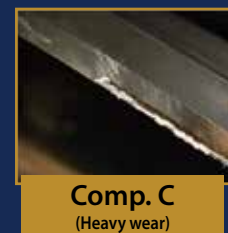
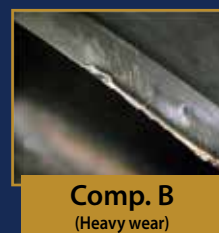
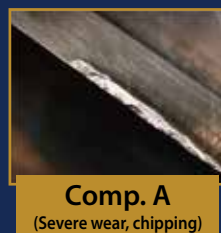
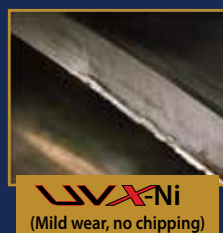
For excellent chip shape and evacuation

Stable performance in Nickel Alloys, like Inconel 718, can be achieved with UVX-Ni's unique cutting geometry and flute design.

Tool Dia	½" x 1-¼" x 3-½" 0.030 CR
Material	Inconel 718 (45HRC)
Speed	764RPM (100 SFM)
Feed	6.02IPM (0.0015 IPT)
Depth of Cut	a _a : 0.250" / a _r : 0.150"
Coolant	Water Soluble (External)

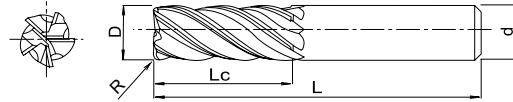


Tool wear after milling 39 inches:



List 2055

Multiple Lengths, 5 Flute, Corner Radius



EDP Number	EDP Number w/Weldon Flat	Mill Diameter	Corner Radius	OAL	Length of Cut	Shank Diameter
		D	R	L	Lc	d
20552501	-	1/4	0.015	2 1/2	5/8	1/4
20552502	-	1/4	0.030	2 1/2	5/8	1/4
20552503	-	1/4	0.060	2 1/2	5/8	1/4
20553121	-	5/16	0.015	2 1/2	3/4	5/16
20553122	-	5/16	0.030	2 1/2	3/4	5/16
20553123	-	5/16	0.060	2 1/2	3/4	5/16
-	20553751	3/8	0.015	2 1/2	7/8	3/8
-	20553752	3/8	0.030	2 1/2	7/8	3/8
-	20553753	3/8	0.060	2 1/2	7/8	3/8
-	20555001	1/2	0.030	2 1/2	5/8	1/2
-	20555002	1/2	0.030	3	1	1/2
-	20555003	1/2	0.060	3	1	1/2
-	20555004	1/2	0.015	3 1/2	1 1/4	1/2
-	20555005	1/2	0.030	3 1/2	1 1/4	1/2
-	20555006	1/2	0.060	3 1/2	1 1/4	1/2
-	20555007	1/2	0.090	3 1/2	1 1/4	1/2
-	20555008	1/2	0.120	3 1/2	1 1/4	1/2
-	20556251	5/8	0.030	3 1/2	1 1/4	5/8
-	20556252	5/8	0.060	3 1/2	1 1/4	5/8
-	20556253	5/8	0.090	3 1/2	1 1/4	5/8
-	20556254	5/8	0.120	3 1/2	1 1/4	5/8
-	20557501	3/4	0.030	4	1 1/2	3/4
-	20557502	3/4	0.060	4	1 1/2	3/4
-	20557503	3/4	0.090	4	1 1/2	3/4
-	20557504	3/4	0.120	4	1 1/2	3/4
-	20551001	1	0.030	4	1 1/2	1
-	20551002	1	0.060	4	1 1/2	1
-	20551003	1	0.090	4	1 1/2	1
-	20551004	1	0.120	4	1 1/2	1

Weldon Flat 3/8" and above.
Packed: 1 pc. Available TiAIN coating only.



Nickel Based Heat Resistant Alloys				
SFM	Side Milling		Slotting	
	125-150		75-100	
Depth of Cut	Aa: ≤ 0.5xD / Ar: ≤ 0.3xD		Aa: ≤ 0.5xD	
Dia.	RPM	Feed (in/min)	RPM	Feed (in/min)
1/4	2100	11.0	1300	7.0
5/16	1600	10.0	1000	6.5
3/8	1400	10.0	900	6.0
1/2	1100	9.5	700	5.5
5/8	800	9.0	500	5.0
3/4	650	8.0	400	4.5
1	500	7.0	300	4.0





shaping your dreams

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