



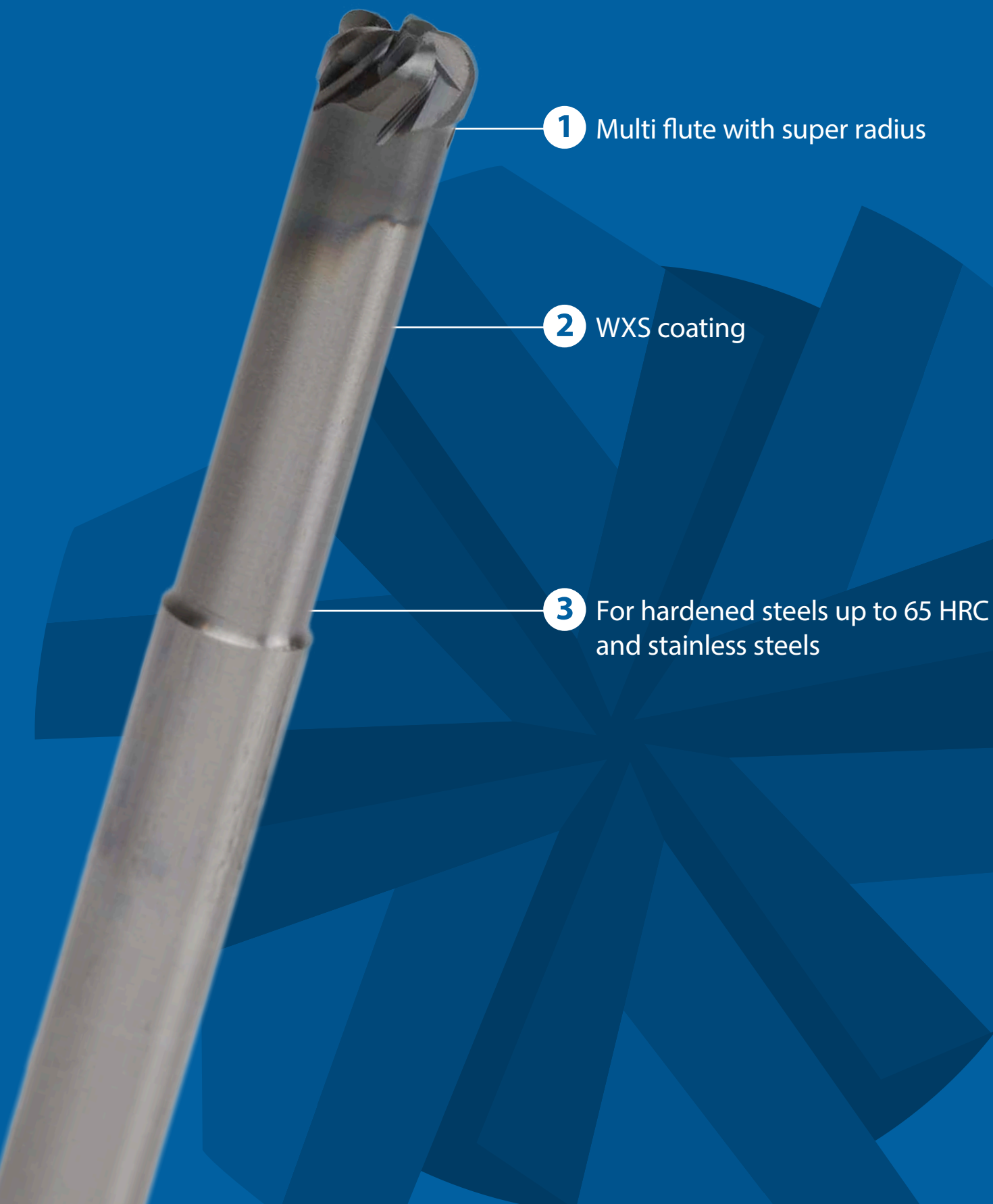
Corner radius end mills for hardened materials up to and over 65 HRC

WXS-(HS)-CRE

Volume 2



KEY FEATURES: WXS-(HS)-CRE



1 Multi flute with super radius

2 WXS coating

3 For hardened steels up to 65 HRC and stainless steels

CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

WXS-CRE / WXS-HS-CRE

Regular milling

Ø	GG		30~38 HRC NAK55 • HPM1 • SKT • SKD		38~45 HRC SUS304 • SKD • HPM50 NAK80		45~55 HRC		55~60 HRC		60~ HRC	
	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)
2 x R0,5	16.000	5.250	12.500	3.800	11.000	3.350	7.950	2.150	4.750	860	4.270	615
3 x R0,75	10.500	6.250	8.500	4.500	7.450	3.900	5.300	2.600	3.200	995	2.850	715
4 x R1	7.950	6.600	6.350	4.800	5.550	4.200	4.000	2.750	2.400	1.050	2.150	755
6 x R1,5	5.300	7.000	4.250	5.100	3.700	4.450	2.650	2.850	1.600	1.150	1.400	825
8 x R2	4.000	7.000	3.200	5.100	2.800	4.450	2.000	2.850	1.200	1.150	1.050	825
10 x R2	3.200	7.000	2.550	5.100	2.250	4.450	1.600	2.850	955	1.150	860	825
12 x R2	2.650	7.000	2.100	5.100	1.850	4.450	1.350	2.850	795	1.150	715	825

High speed side milling

Ø	GG		30~38 HRC NAK55 • HPM1 • SKT • SKD		38~45 HRC SUS304 • SKD • HPM50 NAK80		45~55 HRC		55~60 HRC		60~ HRC	
	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)
2 x R0,5	31.850	10.500	32.000	9.550	24.000	7.150	24000	6.450	16.000	2.850	14.400	2.050
3 x R0,75	21.000	12.500	21.000	12.000	16.000	8.400	16.000	7.850	10.500	3.300	9.450	2.370
4 x R1	16.000	13.000	16.000	12.000	12.000	9.000	12.000	8.200	7.950	3.550	7.150	2.550
6 x R1,5	10.600	14.000	10.600	12.700	7.950	9.550	7.950	8.600	5.300	3.800	5.300	3.800
8 x R2	7.950	14.000	7.950	12.700	5.950	9.550	5.950	8.600	4.000	3.800	4.000	3.800
10 x R2	6.350	14.000	6.350	12.700	4.750	9.550	4.750	8.600	3.200	3.800	3.200	3.800
12 x R2	5.300	14.000	5.300	12.700	4.000	9.550	4.000	8.600	2.650	3.800	2.650	3.800

Max cutting depth		<table border="1"> <tr> <th>ap</th> <th>ae</th> </tr> <tr> <td>0,1xR</td> <td>0,3D</td> </tr> </table>	ap	ae	0,1xR	0,3D	<table border="1"> <tr> <th></th> <th>ap</th> <th>ae</th> </tr> <tr> <td>R<2</td> <td>0,1xR</td> <td>0,3D</td> </tr> <tr> <td>2<R</td> <td>0,2mm</td> <td>0,3D</td> </tr> </table>		ap	ae	R<2	0,1xR	0,3D	2<R	0,2mm	0,3D	<table border="1"> <tr> <th></th> <th>ap</th> <th>ae</th> </tr> <tr> <td>R<2</td> <td>0,05xR</td> <td>0,3D</td> </tr> <tr> <td>2<R</td> <td>0,1mm</td> <td>0,3D</td> </tr> </table>		ap	ae	R<2	0,05xR	0,3D	2<R	0,1mm	0,3D
		ap	ae																							
		0,1xR	0,3D																							
	ap	ae																								
R<2	0,1xR	0,3D																								
2<R	0,2mm	0,3D																								
	ap	ae																								
R<2	0,05xR	0,3D																								
2<R	0,1mm	0,3D																								

1. Use a rigid and precise machine and holder.
2. These milling conditions are based on milling with circular interpolation at corners. For milling without circular interpolation (such as right angle corners), reduce the speed to 50-70% and the cutting depth to 50-80% of the above conditions.
3. We suggest using air blow or MQL (mist).
4. Please adjust the speed, feed and cutting depth according to actual cutting conditions.
5. When WX(S)-CRE enters in Z axis, reduce the feed speed to 30-60% of the above conditions with machining incline angle $\beta < 2^\circ$
6. These milling conditions are for a tool extension length: less than 4 x D. For a longer tool extension, reduce the speed, feed rate, and the cutting depth in accordance with the respective coefficients, to prevent chattering.

SWEDEN

Branch office of OSG SCANDINAVIA
Abrahams Gränd 8
295 35 Bromölla
Sweden
Tel: +46 40 41 22 55
Fax: +46 40 41 32 55
osg@osg-scandinavia.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde
Denmark
Tel.: +45 46 75 65 55
Fax: +45 46 75 67 00
osg@osg-scandinavia.com

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Postbus 50 - 3480 DB Harmelen
The Netherlands
Tel.: +31 348 44 2764
Fax: +31 348 44 2144
info@osg-nl.com

OSG UK

Shelton house, 5 Bentalls
Pipps Hill Ind Est, Basildon Essex SS14 3BY
United Kingdom
Tel.: +44 845 305 1066
Fax: +44 845 305 1067
sales@osg-uk.com

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel.: +32 10 23 05 07
Fax: +32 10 23 05 11
info@osgeurope.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel.: +32 10 23 05 11
Fax: +32 10 23 05 31
info@osg-belgium.com

OSG COMAHER

Bekolarra 4
E - 01010 Vitoria-Gasteiz
Spain
Tel.: +34 945 242 400
Fax: +34 945 228 883
osg-comaher@osg-comaher.com

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte
France
Tel.: +33 1 49 90 10 10
Fax: +33 1 49 90 10 15
sales@osg-france.com





SLOVAKIA

Branch office of OSG Belgium s.a.
Tel: +32 10 23 05 04
Fax: +32 10 23 05 31
info@osg-belgium.com

OSG POLAND

59 Złota St
00-120 Warsaw
Poland

OSG RUSSIA

Butlerova street, 17B, office 5069
117342 Moscow
Russia
Tel: +7 (495) 150 41 54
info@osg-russia.com

ROMSAN INTERNATIONAL CO. SRL

Reprezentant Exclusiv OSG
23-25, Nerva Traian Street
031044 Bucuresti
România
Tel: +40 021 322 07 47
Fax: +40 021 321 56 00
romsan.int@romsan.ro

OSG TURKEY

Rami Kişla Cad.No:56 Eyüp
Istanbul 34056
Turkey
Tel:+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

OSG ITALIA

Via Cirenaiica n. 52 int. 61/63
I - 10142 Torino
Italy
Tel.: +39 0117705211
Fax: +39 0117071402
info@osg-italia.it

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen
Germany
Tel.: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de



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OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 07
Fax: +32 10 23 05 51
info@osgeurope.com

OSG POLAND Sp. z o.o.

ul. Spółdzielcza 57
05-074 Halinów - Poland
Tel: +22 760 82 71
Fax: +22 760 82 71
osg@osg-poland.com

OSG TURKEY

Rami Kişla Cad.No:56 Eyüp
Istanbul 34056 - Turkey
Tel:+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 11
Fax: +32 10 23 05 31
info@osg-belgium.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen - Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de

ROMSAN INTERNATIONAL CO. SRL

Reprezentant Exclusiv OSG
23-25, Nerva Traian Street
031044 Bucuresti - România
Tel: +40 021 322 07 47
Fax: +40 021 321 56 00
romsan.int@romsan.ro

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte - France
Tel: +33 1 49 90 10 10
Fax: +33 1 49 90 10 15
sales@osg-france.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde - Denmark
Tel: +45 46 75 65 55
Fax: +45 46 75 67 00
osg@osg-scandinavia.com

AUSTRIA

Branch office of OSG GERMANY
Messestraße 11
A-6850 Dornbirn
Tel: +49 7161 6064-0
Fax: + 49 7161 6064-444
info@osg-germany.de

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Tel: +31 348 44 2764
Fax: +31 348 44 2144
info@osg-nl.com

SWEDEN

Branch office of OSG SCANDINAVIA
Abrahams Gränd 8
295 35 Bromölla - Sweden
Tel: +46 40 41 22 55
Fax: +46 40 41 32 55
osg@osg-scandinavia.com

OSG ITALIA

Via Cirenaiica n. 52 int. 61/63
I - 10142 Torino - Italy
Tel: +39 0117705211
Fax: +39 0117071402
info@osg-italia.it

OSG UK

Shelton house, 5 Bentalls
Pipps Hill Ind Est, Basildon Essex SS14 3BY
Tel: +44 845 305 1066
Fax: +44 845 305 1067
sales@osg-uk.com

OSG COMAHER

Bekolarra 4
E - 01010 Vitoria-Gasteiz - Spain
Tel: +34 945 242 400
Fax: +34 945 228 883
osg-comaher@osg-comaher.com

WEXO PRÄZISIONSWERKZEUGE GmbH

Siemensstraße 13
D-61352 Bad Homburg
Tel: (06172) 10 62 06
Fax: (06172) 10 62 13
verkauf@wexo.com

SLOVAKIA

Branch office of OSG Europe Logistics s.a.
Tel (SK) +421 2 4329 1295
Tel (BE) +32 10 23 05 07
Fax (BE) +32 10 23 05 51
sales-osgsvk@osgeurope.com

RUSSIA

Butlerova street, 17B, office 5069
117342 Moscow - Russia
Tel: +7 (495) 150 41 54
info@osg-russia.com

OSG EUROPE LOGISTICS S.A.

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