



High Feed Radius End Mill for Titanium Alloy

HFC-TI



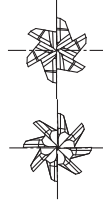
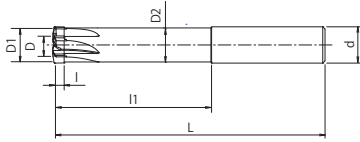
Features: OSG End Mill for Titanium Alloy



1 High efficiency bottom finishing

2 Solid carbide with high wear resistance

3 With 70 mm length neck



EDP	D1	D	L	l	d	l1	D2	ZΔ	Price
8555716	16	7,77	120	5	16	70	15	6	
8555720	20	9,72	120	5	20	70	19	8	
8555725	25	12,15	120	5	25	70	24	8	

Conditions

Titanium Alloy						
Contour Milling						
Vc	50 ~ 100 m/min					
∅	Speed (min ⁻¹)	Feed (mm/min)	Ramping Angle E	R _{rt}	Z	
16	1.490	4.500	2°	0,86	0,46	
20	1.190	3.600		1,01	0,58	
25	850	4.860		1,2	0,74	
Depth of Cut	$a_p \leq 0,035 D_c$ $a_e = 0,39 D_c$					

During machining, please program the milling paths according to the recommended simulated R (rt) respective to the individual end mill diameter.

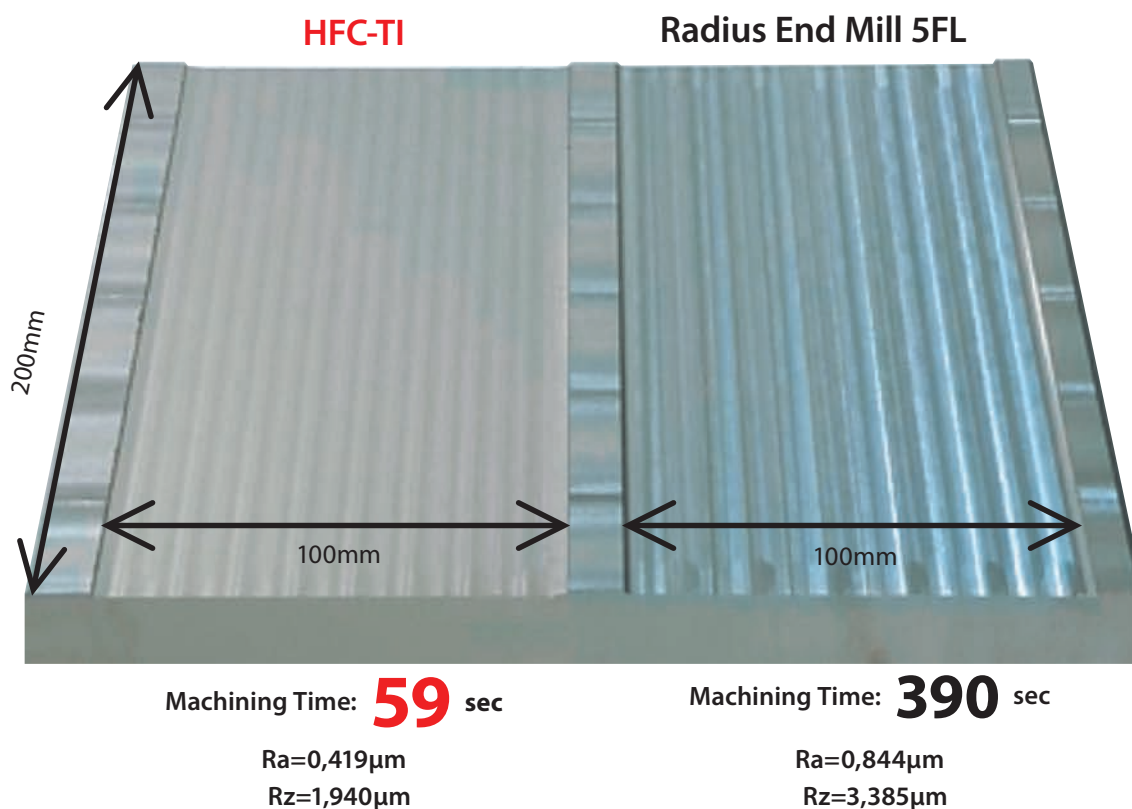
- 1 The above cutting conditions are to be used as general guidelines. Adjustments may be necessary depending on actual milling condition.
- 2 Using water soluble coolant are highly recommended.

Cutting Data

Average Milling Condition

HFC-TI, the high efficiency bottom finishing end mill, achieves superior surface accuracy with reduction of large amount machining time.

Surface Roughness (Ra)	≤ 3,2 μm
Depth of Cut (ap)	0,5 mm
Feed Rate	≥ 3.000 mm/min



Machining Data

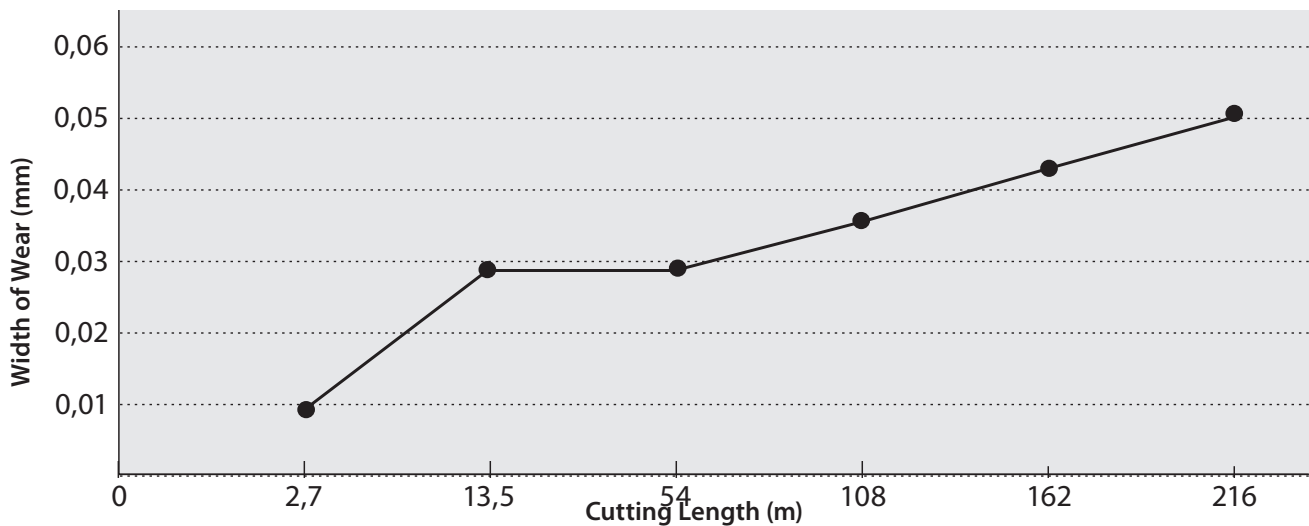
Tool	HFC-TI Ø16 6 Flutes	Radius End mill Ø16 5 Flutes
Cutting Speed	70 m/min	
Feed	4.500 mm/min (0,54 mm/t)	489 mm/min (0,07 mm/t)
Milling Method	Contour Milling	
Depth of Cut	ap=0,5 mm ae=6 mm	ap=0,5 mm ae=8 mm
Coolant	Water Soluble	

Machining Data

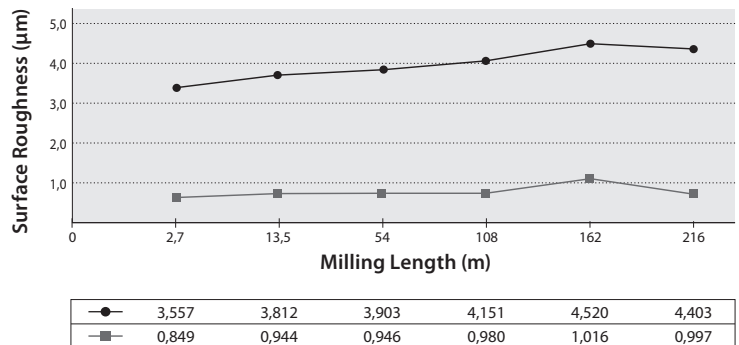
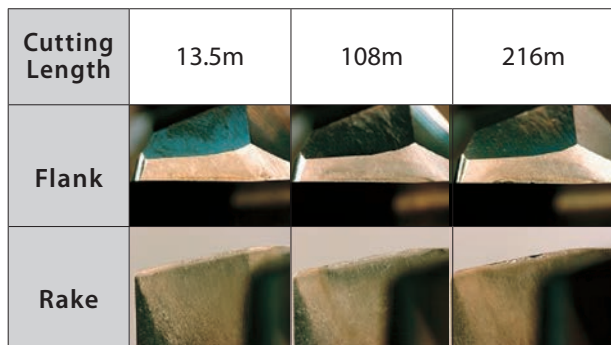
High efficiency milling of HFC-TI

Size	16 mm
Work Material	Ti-6Al-4V
Cutting Speed	100 m/min (1.990 min ⁻¹)
Feed Rate	6.000 mm/min (0,5 mm/t)
Milling Method	Contour Milling
Depth of Cut	ap= 0,5mm ae= 6mm
Coolant	Water Soluble
Overhang Length	70 mm
Machine	Horizontal Machining Center

Wear Amount



Change in Surface Roughness



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 51
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

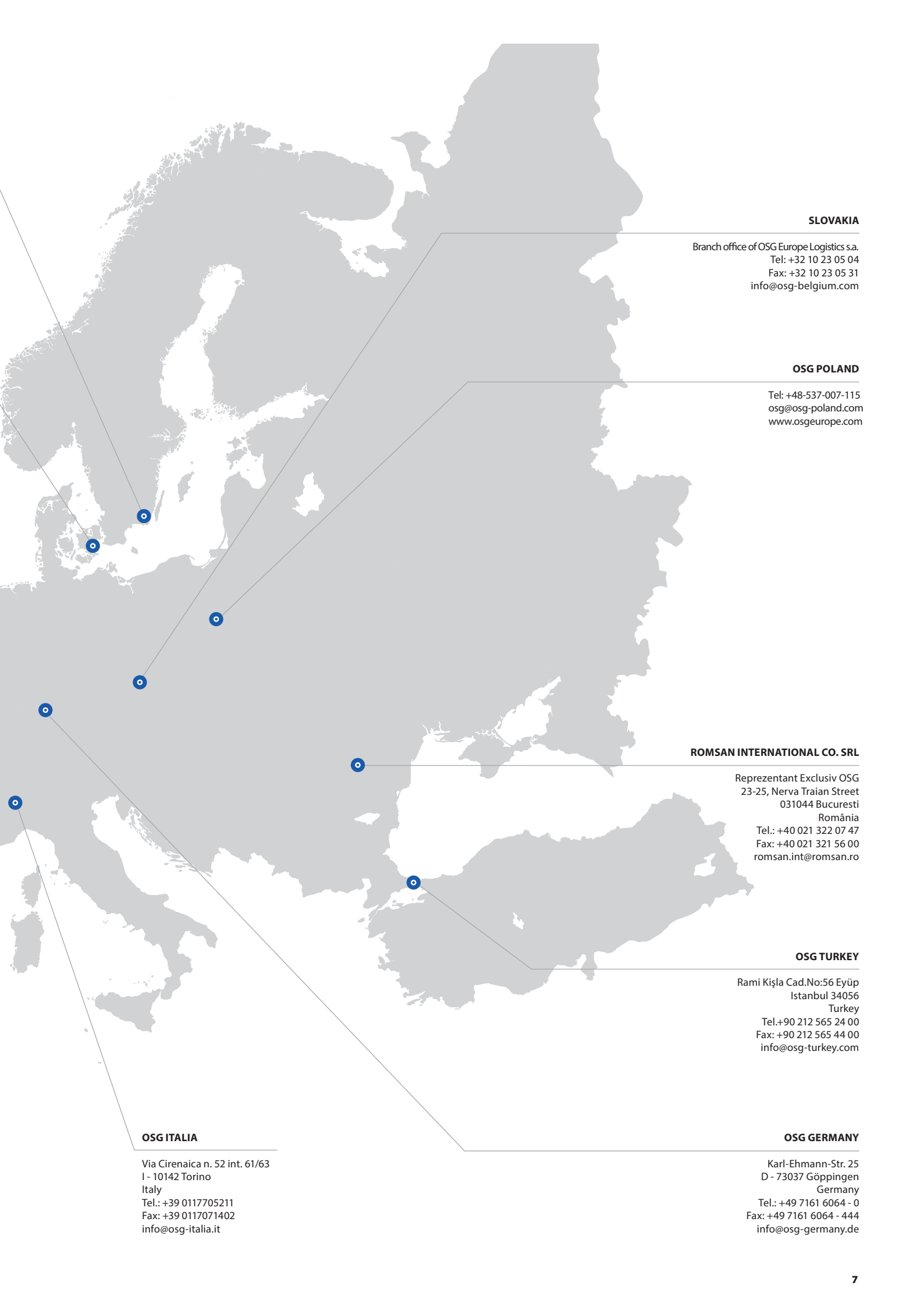
OSG COMAHER

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
BP66191 - 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 Europe Logistics s.a.
Tel: +32 10 23 05 04
Fax: +32 10 23 05 31
info@osg-belgium.com

OSG POLAND

Tel: +48-537-007-115
osg@osg-poland.com
www.osgeurope.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 Kışla 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 Cirenaica 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 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 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 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

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

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 GERMANY

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

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

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 COMAHER

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

OSG ITALIA

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

OSG TURKEY

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

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