



End Mill for Titanium Alloy

UVX-TI-SERIES

Volume 2



Features: OSG End Mill for Titanium Alloy



1 Unequal spacing, variable lead
Superior suppression of vibration

2 Available in 4 or 5 flutes

3 Optimal flute shape
Smooth evacuation of chips

4 Web Taper
High efficient milling is achieved
by increasing rigidity

UVX + Safe-Lock™ -The pull out protection

The unique Safe-Lock™ design in cutting tools and tool holders combines a high precision press fit clamping with a positive form locking mechanism. This prevents round cutting tools from being rotated or completely pulled out from its tool holder during heavy machining. The combination of symmetrical pull out protection, highest concentricity and excellent balance of the Safe-Lock™ system, results in a vibration free machining process. This leads to a more efficient metal removal rate, that is superior when compared to conventional Milling chucks or Weldon shanked cutting tools and tool holders.



The Safe-Lock™ design is now available on the UVX end mill series.

- For High Performance Cutting (HPC)
- Highly accurate clamping due to shrink fit technology
- High torque due to form closed clamping
- No loss of accuracy
- No pull out of the tool
- No spinning of the tool
- No damages on work piece or machine
- Groove on tool shank is directed so that tool will be pulled into the chuck (depending on direction of rotation)



SAFE-LOCK®

Cutting Data

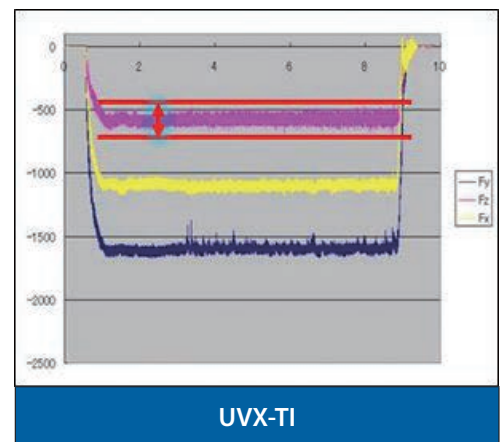
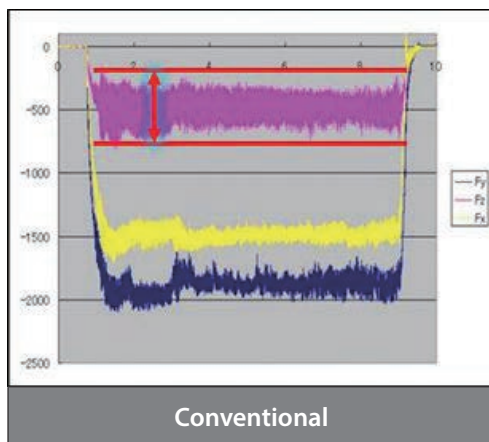
Milling Method and Features

Stable and high efficiency milling of titanium alloy is now possible! UVX series offers solutions for slot milling to easily chatter complicated pocket milling.

	Feature	Slot Milling	Side Milling	
			Depth under 3D	Depth over 3D, under 5D
UVX-TI-5FL	Multi-purpose short type, 5FL	○	⊙	×
UVXL-TI-5FL	High efficient long type, 5FL	△	⊙	⊙

⊙ Best ○ Good × Not recommended △ Fair

Stable high feed milling is achieved by suppressing vibration with high rigidity



Pocket Milling of UVX(L)-TI-5FL

The UVX-TI Series can finish wall surfaces with single cutting and offers a seamless, beautiful cutting surface, thanks to vibration-free cutting

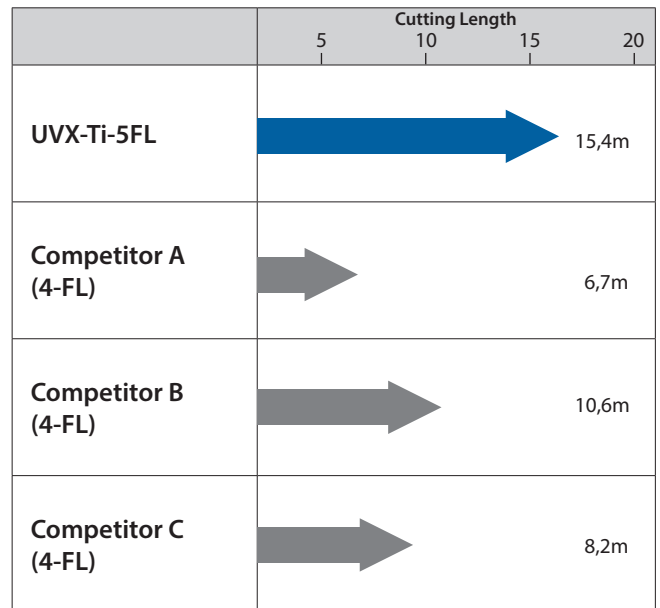
Tool	UVX-TI-5FL	UVXL-TI-5FL
Size	∅ 16 X R3	∅ 12 X R1
Work Material	Ti-6Al-4V	
Cutting Speed	55 m/min (1.100 min ⁻¹)	70 m/min (1.850 min ⁻¹)
Feed Rate	550 mm/min (0,1 mm/t)	650 m/min (0.07 min ⁻¹)
Milling Method	Pocket Milling	
Depth of Cut	ap=16 mm ae=9,6 mm	ap=45 mm ae=0,2 mm
M.R.R.	85 cm ³ /min	6 cm ³ /min
Coolant	Water Soluble	
Overhang Length	50 mm	
Machine	5-axis Machining Center (HSK-A63)	



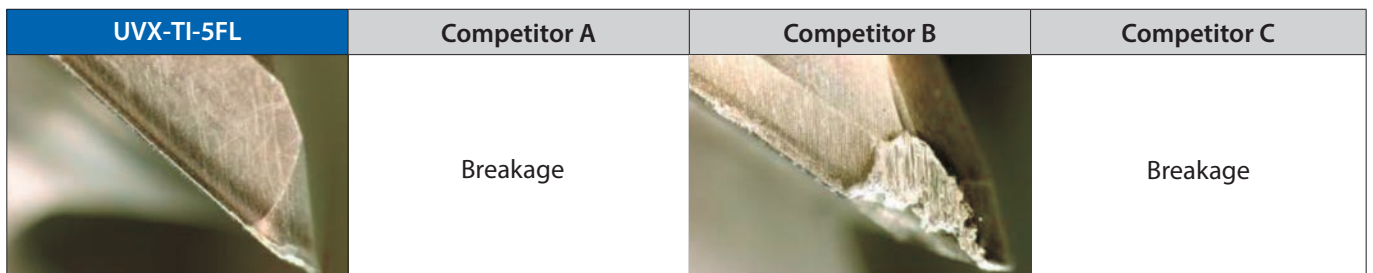
Machining Data

Long Tool Life of UVX-TI-5FL

Tool	UVX-TI-5FL Ø 12 X R 1
Work Material	Ti-6Al-4V (35HRC)
Cutting Speed	100 m/min (2.500 min ⁻¹)
Feed Rate	625 mm/min (0,05 mm/t)
Milling Method	Side Milling
Depth of Cut	ap=6,35 mm (0,5D) ae=3,81 mm (0,3D)
Coolant	Water Soluble
Machine	Vertical Machining Center (BT40)



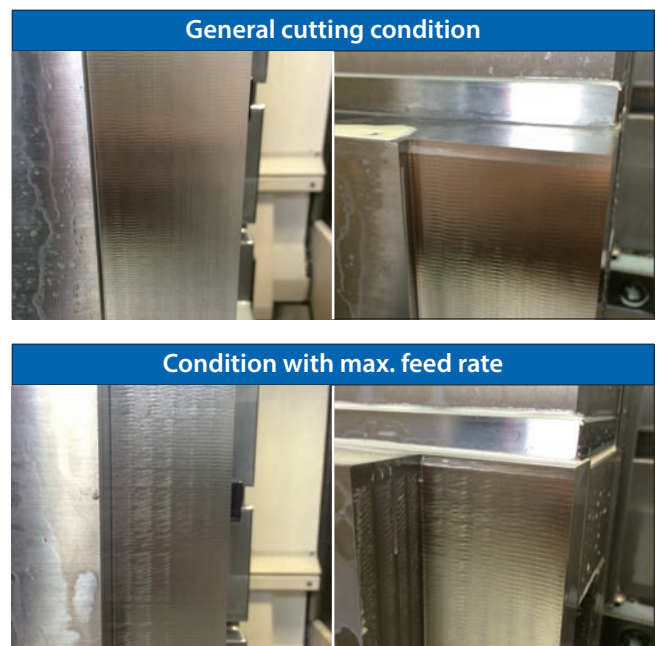
After 10,5m of Milling



The UVX-TI-5FL has outstanding resistance against fracture and can cut materials with excellent stability.

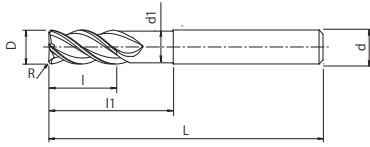
UVXL-TI-5FL Superior efficiency of side milling

	General cutting condition	Condition with max. feed rate
Tool	UVXL-TI-5FL Ø 12 X R 1	
Work Material	Ti-6Al-4V (32HRC)	
Cutting Speed	70 m/min (1.857 min ⁻¹)	70 m/min (1.857 min ⁻¹)
Feed Rate	1.114 mm/min (0,12 mm/t)	3.157 mm/min (0,34 mm/t)
Milling Method	Side Milling	
Depth of Cut	ap=0,48 mm ae=1,2 mm	
M.R.R.	64cm ³ /min	182cm ³ /min
Coolant	Water Soluble	
Machine	Horizontal Machining Center (BT40)	
Holder	Shrink Holder	



Deep side milling of titanium alloy with UVXL-TI-5FL Ø12. Under the cutting cond. of maximized feed rate, astounding result of M.R.R. = 182 cm³/min and fz=0.34 mm/t were achieved.

End Mill

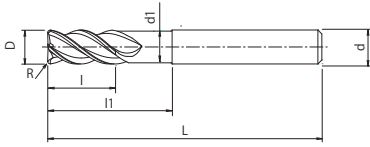


EDP	ZΔ	D	R	L	l	d1	l1	d	Price
8555120	4	12	-	90	24	11,5	36	12	
8555121	4	12	1	90	24	11,5	36	12	
8555122	4	12	1,5	90	24	11,5	36	12	
8555123	4	12	2	90	24	11,5	36	12	
8555124	4	12	2,5	90	24	11,5	36	12	
8555125	4	12	3	90	24	11,5	36	12	
8555126	4	12	4	90	24	11,5	36	12	
8555160	4	16	-	100	32	15,5	48	16	
8555161	4	16	1	100	32	15,5	48	16	
8555162	4	16	1,5	100	32	15,5	48	16	
8555163	4	16	2	100	32	15,5	48	16	
8555164	4	16	2,5	100	32	15,5	48	16	
8555165	4	16	3	100	32	15,5	48	16	
8555166	4	16	4	100	32	15,5	48	16	
8555200	4	20	-	120	40	19,5	60	20	
8555201	4	20	1	120	40	19,5	60	20	
8555202	4	20	1,5	120	40	19,5	60	20	
8555203	4	20	2	120	40	19,5	60	20	
8555204	4	20	2,5	120	40	19,5	60	20	
8555205	4	20	3	120	40	19,5	60	20	
8555206	4	20	4	120	40	19,5	60	20	
8555207	4	20	5	120	40	19,5	60	20	
8555250	4	25	-	140	50	24,5	75	25	
8555251	4	25	1	140	50	24,5	75	25	
8555252	4	25	1,5	140	50	24,5	75	25	
8555253	4	25	2	140	50	24,5	75	25	
8555254	4	25	2,5	140	50	24,5	75	25	
8555255	4	25	3	140	50	24,5	75	25	
8555256	4	25	4	140	50	24,5	75	25	
8555257	4	25	5	140	50	24,5	75	25	
8555258	4	25	6	140	50	24,5	75	25	

Conditions

Titanium Alloy (Ti-6Al-4V)						
Vc	Side Milling			Slot Milling		
	60 ~ 80 m/min			30 ~ 50 m/min		
∅	S (min ⁻¹)	F (mm/min)	Depth of Cut		S (min ⁻¹)	F (mm/min)
12	1.900	680	ap	ae	1.350	270
16	1.400	500			990	200
20	1.100	480	≤ 1,8 Dc	0,2 Dc	800	190
25	900	400			640	150

End Mill

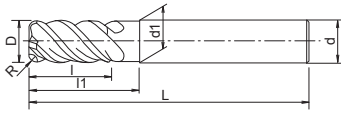


NEW

EDP	ZΔ	D	R	L	I	d1	I1	d	Price
<div style="border: 2px solid gray; border-radius: 50%; padding: 20px; width: 80%; margin: 0 auto;"> <p style="text-align: center;">TOOL COMING SOON • TOOL COMING SOON • TOOL COMING SOON</p> <p style="text-align: center; font-size: 2em; font-weight: bold;">TOOL Coming Soon</p> <p style="text-align: center;">TOOL COMING SOON • TOOL COMING SOON • TOOL COMING SOON</p> </div>									



End Mill

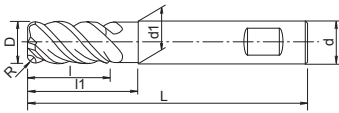


EDP	ZΔ	D	R	L	l	d1	l1	d	Price
8555320	5	12	-	90	24	11,5	36	12	
8555321	5	12	1	90	24	11,5	36	12	
8555322	5	12	1,5	90	24	11,5	36	12	
8555323	5	12	2	90	24	11,5	36	12	
8555324	5	12	2,5	90	24	11,5	36	12	
8555325	5	12	3	90	24	11,5	36	12	
8555326	5	12	4	90	24	11,5	36	12	
8555360	5	16	-	100	32	15,5	48	16	
8555361	5	16	1	100	32	15,5	48	16	
8555362	5	16	1,5	100	32	15,5	48	16	
8555363	5	16	2	100	32	15,5	48	16	
8555364	5	16	2,5	100	32	15,5	48	16	
8555365	5	16	3	100	32	15,5	48	16	
8555366	5	16	4	100	32	15,5	48	16	
8555400	5	20	-	120	40	19,5	60	20	
8555401	5	20	1	120	40	19,5	60	20	
8555402	5	20	1,5	120	40	19,5	60	20	
8555403	5	20	2	120	40	19,5	60	20	
8555404	5	20	2,5	120	40	19,5	60	20	
8555405	5	20	3	120	40	19,5	60	20	
8555406	5	20	4	120	40	19,5	60	20	
8555407	5	20	5	120	40	19,5	60	20	
8555450	5	25	-	140	50	24,5	75	25	
8555451	5	25	1	140	50	24,5	75	25	
8555452	5	25	1,5	140	50	24,5	75	25	
8555453	5	25	2	140	50	24,5	75	25	
8555454	5	25	2,5	140	50	24,5	75	25	
8555455	5	25	3	140	50	24,5	75	25	
8555456	5	25	4	140	50	24,5	75	25	
8555457	5	25	5	140	50	24,5	75	25	
8555458	5	25	6	140	50	24,5	75	25	

Conditions

Titanium Alloy (Ti-6Al-4V)								
Vc	Side Milling			Slot Milling				
	60 ~ 80 m/min			30 ~ 50 m/min				
Ø	S (min ⁻¹)	F (mm/min)	Depth of Cut		S (min ⁻¹)	F (mm/min)		
12	1.900	855	$\frac{a_p}{a_e} \leq 1,8 D_c$ $0,2 D_c$		1.350	340	$\frac{a_p}{a_e} \leq 1 D_c$	
16	1.400	630			990	250		
20	1.100	600			800	240		
25	900	500			640	192		

End Mill

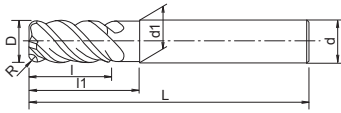


EDP	ZΔ	D	R	L	l	d1	l1	d	Price
W1204247	5	12	0	90	24	11,5	36	12	
W1204248	5	12	1	90	24	11,5	36	12	
W1204249	5	12	2,5	90	24	11,5	36	12	
W1304511	5	12	4	90	24	11,5	36	12	
W1204250	5	16	0	100	32	15,5	48	16	
W1304512	5	16	1	100	32	15,5	48	16	
W1204251A	5	16	2,5	100	32	15,5	48	16	
W1204252A	5	16	4	100	32	15,5	48	16	
W1204253	5	20	0	105	40	19,5	60	20	
W1304513	5	20	1	105	40	19,5	60	20	
W1204254A	5	20	2,5	105	40	19,5	60	20	
W1204255A	5	20	4	105	40	19,5	60	20	
W1204256A	5	20	5	105	40	19,5	60	20	
W1204257	5	20	6	105	40	19,5	60	20	

Conditions

Titanium Alloy (Ti-6Al-4V)						
Vc	Side Milling			Slot Milling		
	60 ~ 80 m/min			30 ~ 50 m/min		
Ø	S (min ⁻¹)	F (mm/min)	Depth of Cut		S (min ⁻¹)	F (mm/min)
12	1.900	855	ap	ae	1.350	340
16	1.400	630			≤ 1,8 Dc	0,2 Dc
20	1.100	600			800	240

End Mill

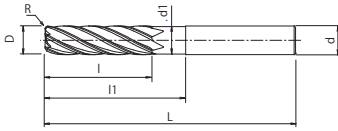


EDP	ZΔ	D	R	L	l	d1	l1	d	Price
48247120	5	12	-	90	24	11,5	36	12	
8555670	5	12	1	90	24	11,5	36	12	
48247123	5	12	1,5	90	24	11,5	36	12	
48247124	5	12	2	90	24	11,5	36	12	
48247125	5	12	2,5	90	24	11,5	36	12	
8555671	5	12	3	90	24	11,5	36	12	
48247127	5	12	4	90	24	11,5	36	12	
48247160	5	16	-	100	32	15,5	48	16	
8555672	5	16	1	100	32	15,5	48	16	
48247163	5	16	1,5	100	32	15,5	48	16	
48247164	5	16	2	100	32	15,5	48	16	
48247165	5	16	2,5	100	32	15,5	48	16	
8555673	5	16	3	100	32	15,5	48	16	
48247167	5	16	4	100	32	15,5	48	16	
48247200	5	20	-	120	40	19,5	60	20	
8555674	5	20	1	120	40	19,5	60	20	
48247203	5	20	1,5	120	40	19,5	60	20	
48247204	5	20	2	120	40	19,5	60	20	
48247205	5	20	2,5	120	40	19,5	60	20	
8555675	5	20	3	120	40	19,5	60	20	
48247207	5	20	4	120	40	19,5	60	20	
8555676	5	20	5	120	40	19,5	60	20	
48247250	5	25	-	140	50	24,5	75	25	
8555677	5	25	1	140	50	24,5	75	25	
48247253	5	25	1,5	140	50	24,5	75	25	
48247254	5	25	2	140	50	24,5	75	25	
48247255	5	25	2,5	140	50	24,5	75	25	
8555678	5	25	3	140	50	24,5	75	25	
48247257	5	25	4	140	50	24,5	75	25	
8555679	5	25	5	140	50	24,5	75	25	
48247259	5	25	6	140	50	24,5	75	25	

Conditions

Titanium Alloy (Ti-6Al-4V)								
Vc	Side Milling			Slot Milling				
	60 ~ 80 m/min			30 ~ 50 m/min				
Ø	S (min ⁻¹)	F (mm/min)	Depth of Cut		S (min ⁻¹)	F (mm/min)		
12	1.900	855	$\frac{ap}{ae} \leq 1,8 Dc$ $0,2 Dc$		1.350	340	$\frac{ap}{ae} \leq 1 Dc$	
16	1.400	630			990	250		
20	1.100	600			800	240		
25	900	500			640	192		

End Mill

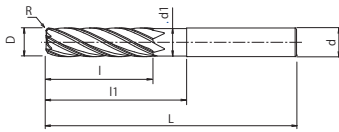


EDP	ZΔ	D	R	L	l	d1	l1	d	Price
8555520	5	12	-	110	48	11,5	60	12	
8555521	5	12	1	110	48	11,5	60	12	
8555522	5	12	1,5	110	48	11,5	60	12	
8555523	5	12	2	110	48	11,5	60	12	
8555524	5	12	2,5	110	48	11,5	60	12	
8555525	5	12	3	110	48	11,5	60	12	
8555526	5	12	4	110	48	11,5	60	12	
8555560	5	16	-	130	64	15,5	80	16	
8555561	5	16	1	130	64	15,5	80	16	
8555562	5	16	1,5	130	64	15,5	80	16	
8555563	5	16	2	130	64	15,5	80	16	
8555564	5	16	2,5	130	64	15,5	80	16	
8555565	5	16	3	130	64	15,5	80	16	
8555566	5	16	4	130	64	15,5	80	16	
8555600	5	20	-	160	80	19,5	100	20	
8555601	5	20	1	160	80	19,5	100	20	
8555602	5	20	1,5	160	80	19,5	100	20	
8555603	5	20	2	160	80	19,5	100	20	
8555604	5	20	2,5	160	80	19,5	100	20	
8555605	5	20	3	160	80	19,5	100	20	
8555606	5	20	4	160	80	19,5	100	20	
8555607	5	20	5	160	80	19,5	100	20	
8555650	5	25	-	190	100	24,5	125	25	
8555651	5	25	1	190	100	24,5	125	25	
8555652	5	25	1,5	190	100	24,5	125	25	
8555653	5	25	2	190	100	24,5	125	25	
8555654	5	25	2,5	190	100	24,5	125	25	
8555655	5	25	3	190	100	24,5	125	25	
8555656	5	25	4	190	100	24,5	125	25	
8555657	5	25	5	190	100	24,5	125	25	
8555658	5	25	6	190	100	24,5	125	25	

Conditions

Titanium Alloy (Ti-6Al-4V)									
Side Milling									
Vc	60 ~ 80 m/min								
Ø	S (min ⁻¹)	F (mm/min)	Depth of Cut						
12	2.100	1.050	<table border="1"> <tr> <td>ap</td> <td>ae</td> </tr> <tr> <td colspan="2">≤ 3,75 Dc 0,1 Dc</td> </tr> <tr> <td colspan="2"> </td> </tr> </table>	ap	ae	≤ 3,75 Dc 0,1 Dc			
ap	ae								
≤ 3,75 Dc 0,1 Dc									
16	1.600	920							
20	1.270	760							
25	1.020	587							

End Mill



EDP	ZΔ	D	R	L	l	d1	l1	d	Price
48248120	5	12	-	110	48	11,5	60	12	
8555680	5	12	1	110	48	11,5	60	12	
48248123	5	12	1,5	110	48	11,5	60	12	
48248124	5	12	2	110	48	11,5	60	12	
48248125	5	12	2,5	110	48	11,5	60	12	
8555681	5	12	3	110	48	11,5	60	12	
48248127	5	12	4	110	48	11,5	60	12	
48248160	5	16	-	130	64	15,5	80	16	
8555682	5	16	1	130	64	15,5	80	16	
48248163	5	16	1,5	130	64	15,5	80	16	
48248164	5	16	2	130	64	15,5	80	16	
48248165	5	16	2,5	130	64	15,5	80	16	
8555683	5	16	3	130	64	15,5	80	16	
48248167	5	16	4	130	64	15,5	80	16	
48248200	5	20	-	160	80	19,5	100	20	
8555684	5	20	1	160	80	19,5	100	20	
48248203	5	20	1,5	160	80	19,5	100	20	
48248204	5	20	2	160	80	19,5	100	20	
48248205	5	20	2,5	160	80	19,5	100	20	
8555685	5	20	3	160	80	19,5	100	20	
48248207	5	20	4	160	80	19,5	100	20	
8555686	5	20	5	160	80	19,5	100	20	
48248250	5	25	-	190	100	24,5	125	25	
8555687	5	25	1	190	100	24,5	125	25	
48248253	5	25	1,5	190	100	24,5	125	25	
48248254	5	25	2	190	100	24,5	125	25	
48248255	5	25	2,5	190	100	24,5	125	25	
8555688	5	25	3	190	100	24,5	125	25	
48248257	5	25	4	190	100	24,5	125	25	
8555689	5	25	5	190	100	24,5	125	25	
48248259	5	25	6	190	100	24,5	125	25	

Conditions

Titanium Alloy (Ti-6Al-4V)								
Side Milling								
60 ~ 80 m/min								
Vc	S		F	Depth of Cut				
∅	(min ⁻¹)	(mm/min)	(mm/min)					
12	2.100		1.050	<table border="1"> <tr> <td>ap</td> <td>ae</td> </tr> <tr> <td>≤ 3,75 Dc</td> <td>0,1 Dc</td> </tr> </table>	ap	ae	≤ 3,75 Dc	0,1 Dc
ap	ae							
≤ 3,75 Dc	0,1 Dc							
16	1.600		920					
20	1.270		760					
25	1.020		587					

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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

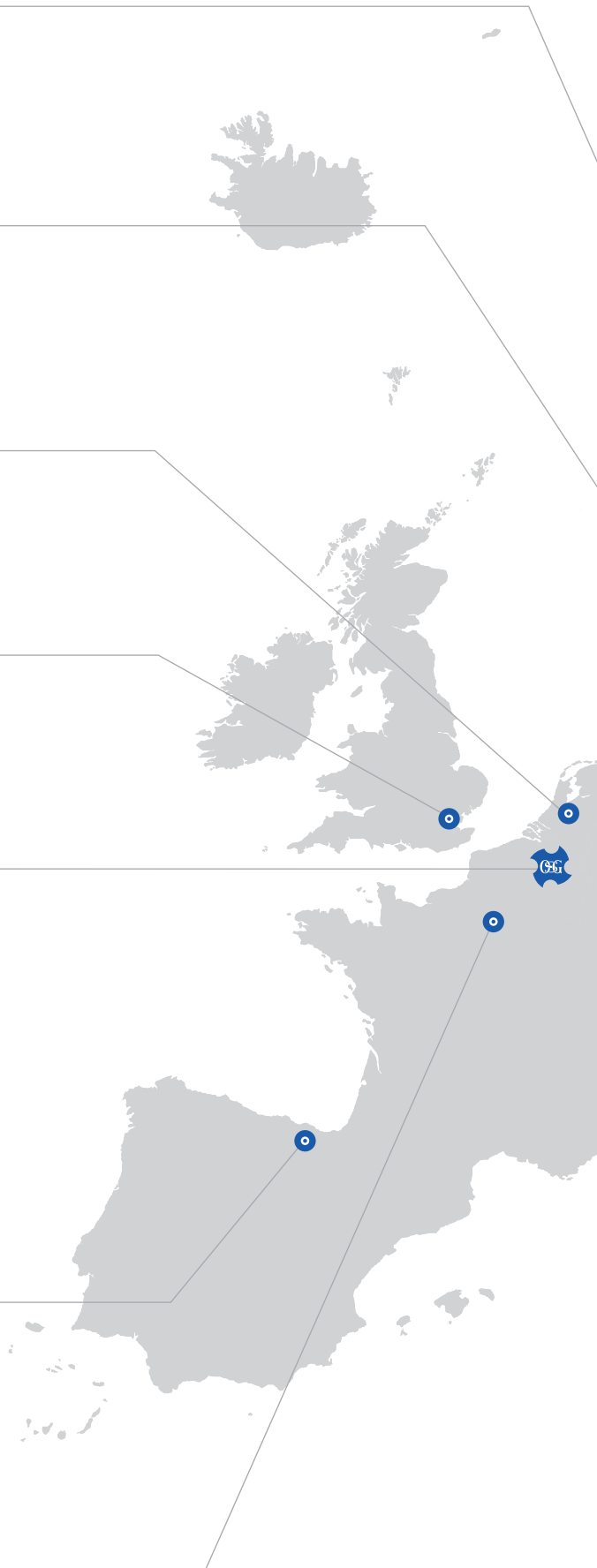
Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel.: +32 10 23 05 11
Fax: +32 10 23 05 31
info@osg-belgium.com

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 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

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