



Coolant-through carbide drill series for Titanium Alloys and Stainless Steel

# ADO-SUS

Volume 6



# KEY FEATURES: ADO-SUS SERIES

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- 1 Sharp cutting edge
  - 2 New flute geometry
  - 3 Special margin shape
  - 4 New coolant hole shape

5 WXL<sup>®</sup> Coating





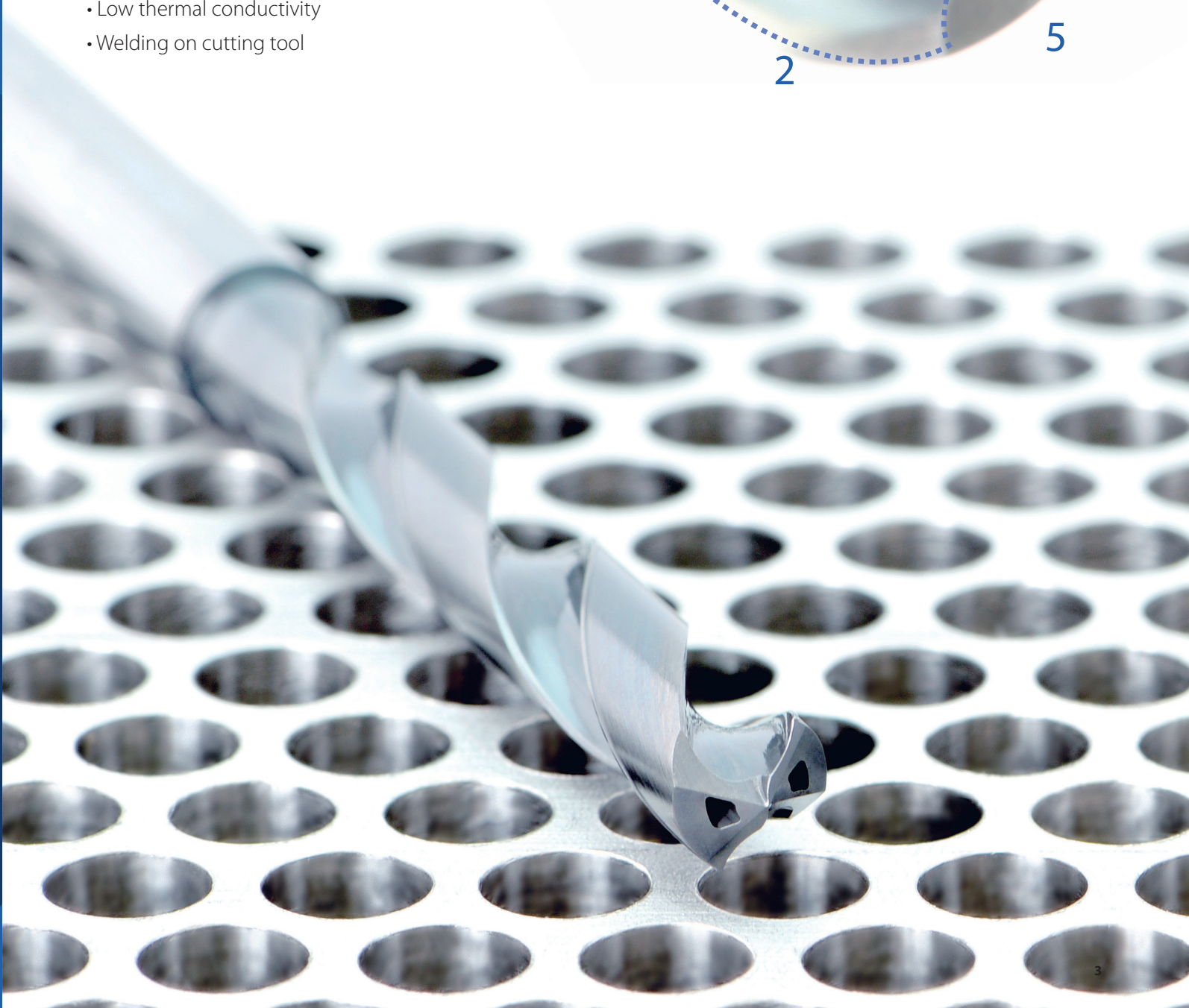
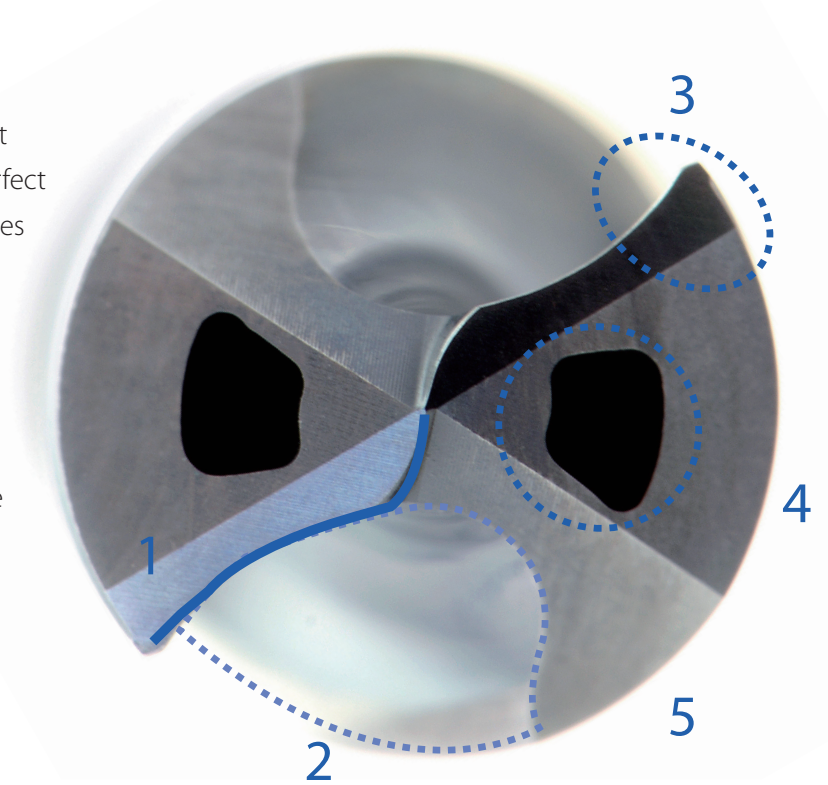
# ADO-SUS DRILL FOR STAINLESS STEELS, TITANIUM ALLOYS & VARIOUS MATERIALS

OSG's next generation of carbide drills is an almighty one. Focused on the reduction of thrust and aimed at machining Stainless Steel, ADO-SUS-3D/5D is the perfect drill to use for your machine. The flute design produces optimal chip shape, thereby realizing smooth chip evacuation.

The margin form is designed to realize low resistance and low cutting temperature.

Common machining problems associated with these materials :

- Work hardening tendency
- Elongation of chips
- Low thermal conductivity
- Welding on cutting tool

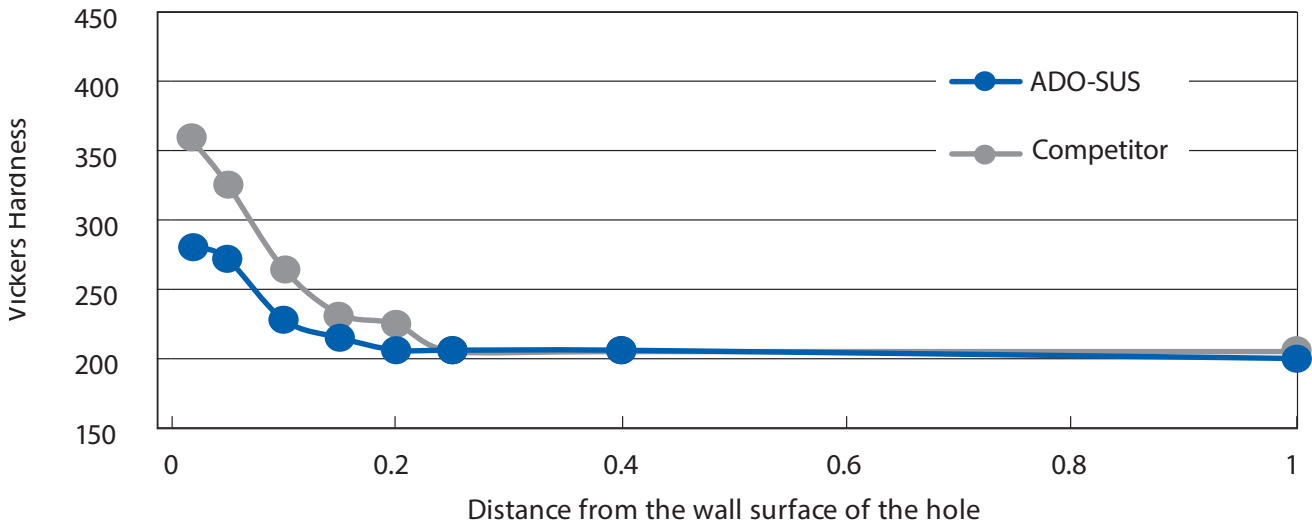


# KEY FEATURES & BENEFITS

## 1 Solution for work hardening - Sharp cutting edge

Reduces work hardening, which leads to longer tool life during tapping and reaming

|               |                |           |                                   |         |                               |
|---------------|----------------|-----------|-----------------------------------|---------|-------------------------------|
| Tool          | ADO-SUS-5D φ10 | Speed     | 70m/min (2,229min <sup>-1</sup> ) | Coolant | 1.5MPa Water Soluble Internal |
| Work Material | SUS3040C       | Feed Rate | 446mm/min(0.2mm/rev)              | Machine | Horizontal Machining Center   |



## 2 Solution for elongation of chips - New flute geometry

Enables the creation of compact cutting chips

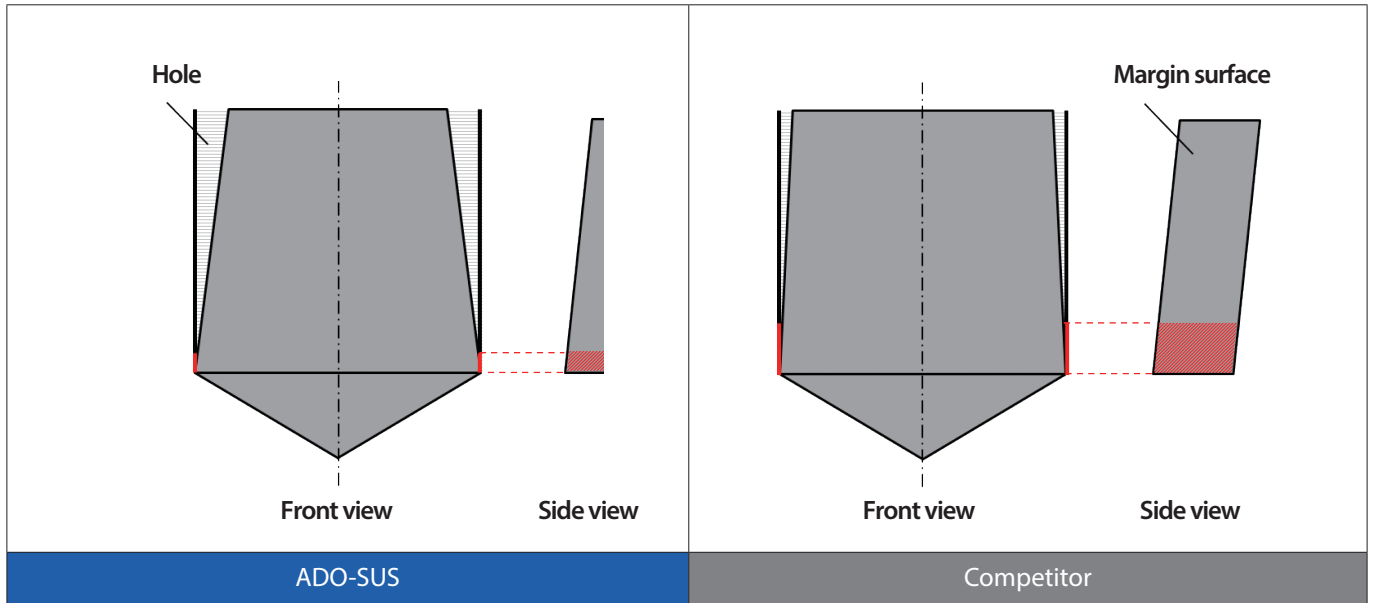




# KEY FEATURES & BENEFITS

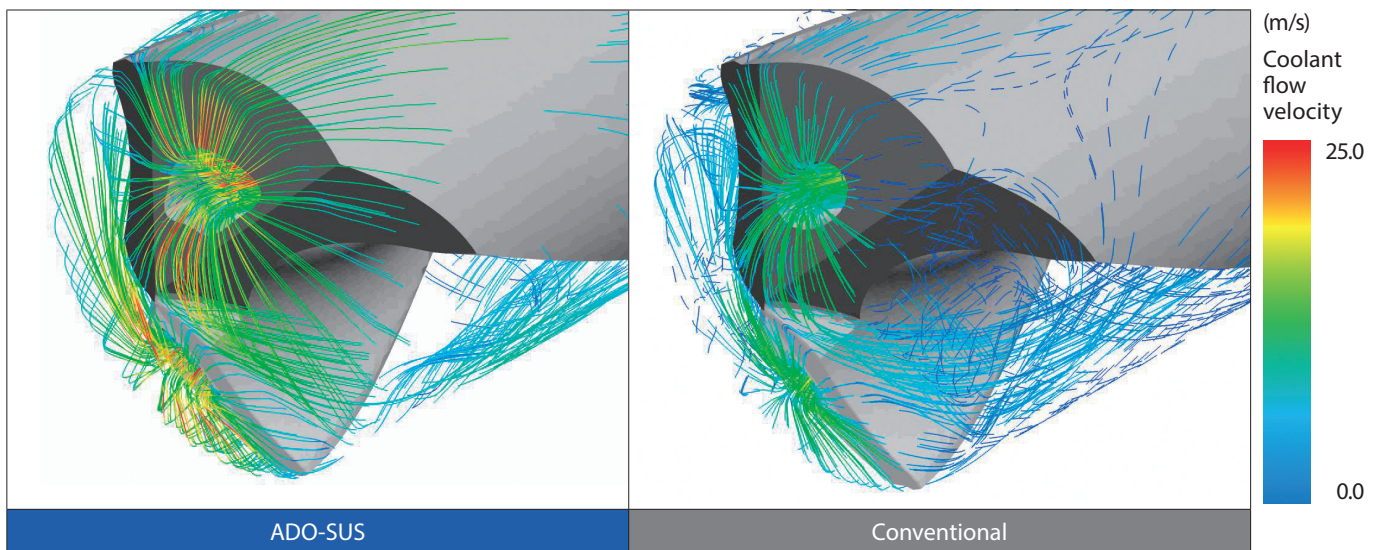
## 3 Solution for high machining heat - Special margin shape

Reduces friction and heat generation



## 4 Solution for high machining heat - New coolant hole shape

Improves coolant flow, chip evacuation and cutting heat generation



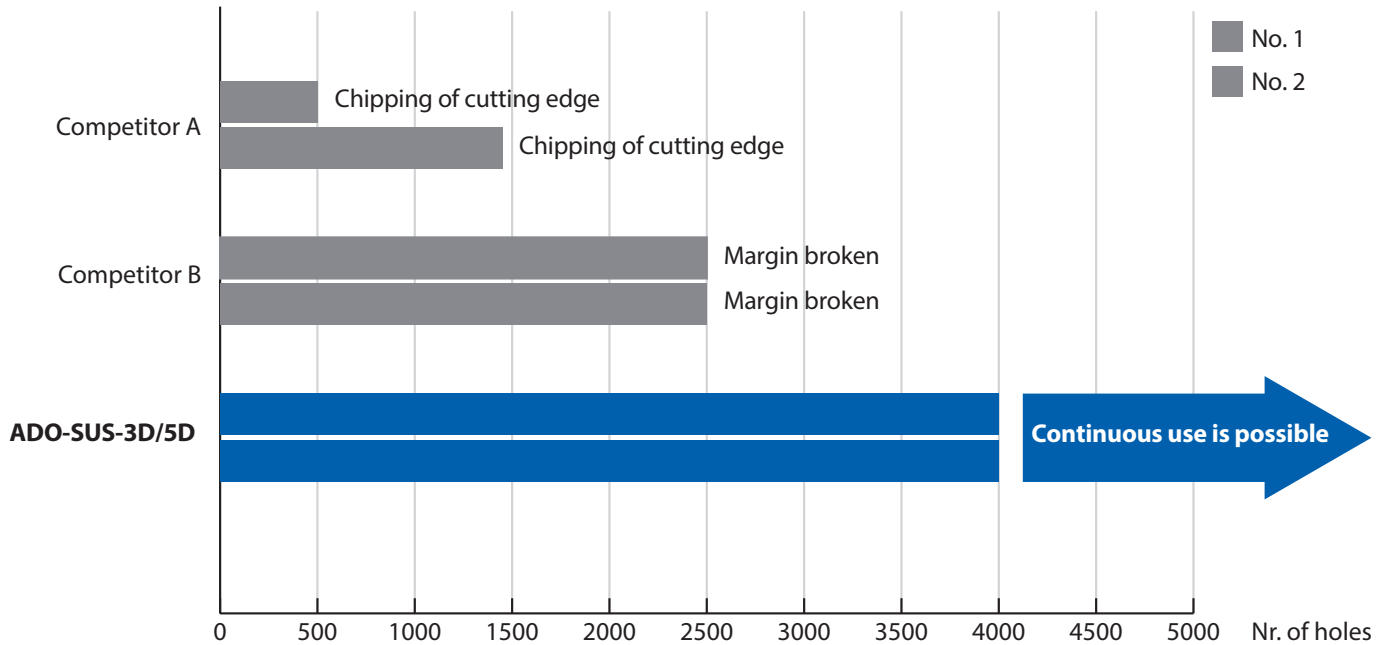
Analysis of coolant flow with spindle speed of  $2,200\text{min}^{-1}$

## 5 Solution for welding - WXL<sup>®</sup> coating

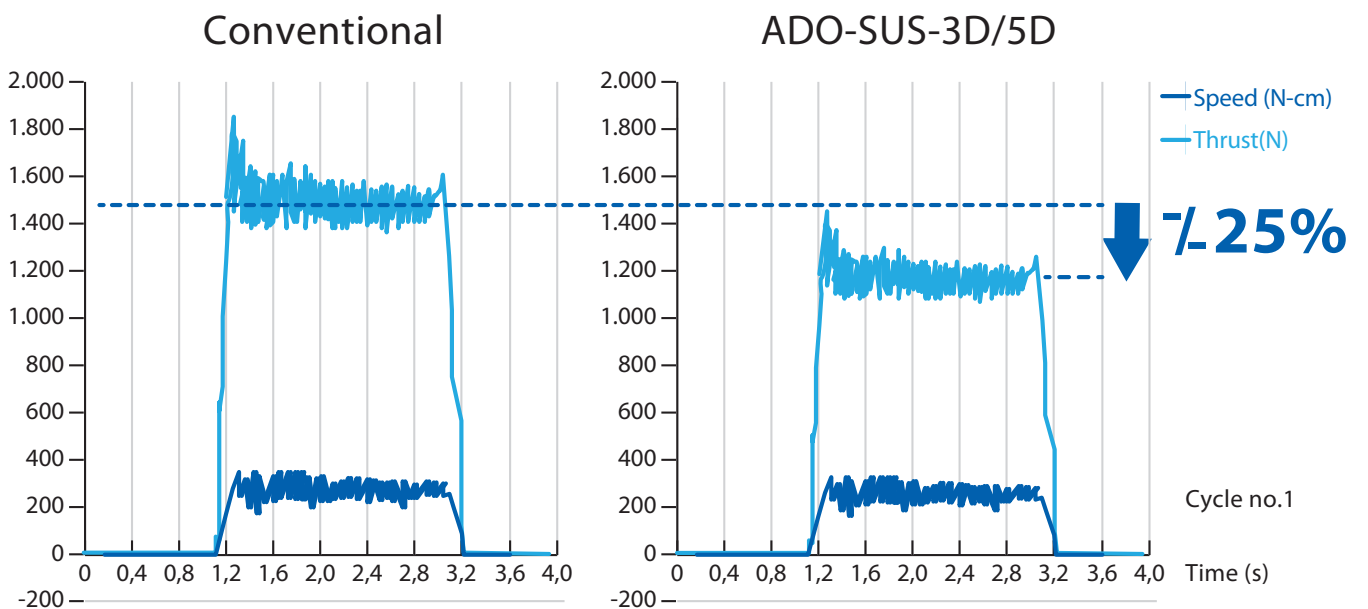
High adhesion strength, which minimizes the possibility of chipping

# PERFORMANCE ADO-SUS-3D/5D VERSUS CONVENTIONAL TYPE IN STAINLESS STEEL

|             |                 |           |                     |               |                              |
|-------------|-----------------|-----------|---------------------|---------------|------------------------------|
| Cutting Dia | Ø6              | Speed     | 80m/min             | Depth of Hole | 25mm (Through hole)          |
| Material    | SUS304 (1.4301) | Feed Rate | 0,18mm/rev (3% x D) | Coolant       | Internal - Emulsion - 1,5Mpa |



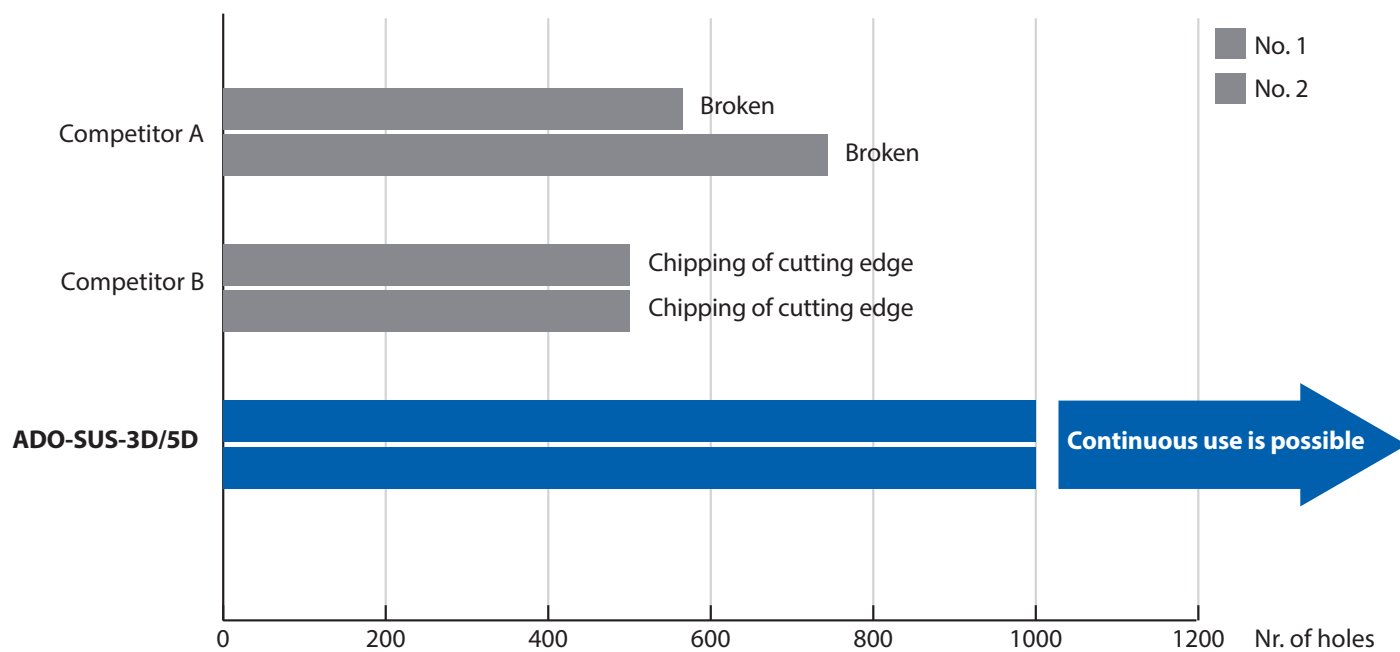
## CONVENTIONAL TYPE VERSUS ADO-SUS-3D/5D





# PERFORMANCE ADO-SUS-3D/5D VERSUS CONVENTIONAL TYPE IN CARBON STEEL

|             |               |           |                     |               |                              |
|-------------|---------------|-----------|---------------------|---------------|------------------------------|
| Cutting Dia | Ø10           | Speed     | 100m/min            | Depth of Hole | 50mm (Through hole)          |
| Material    | S50C (1.1213) | Feed Rate | 0,30mm/rev (3% x D) | Coolant       | Internal - Emulsion - 1,5Mpa |



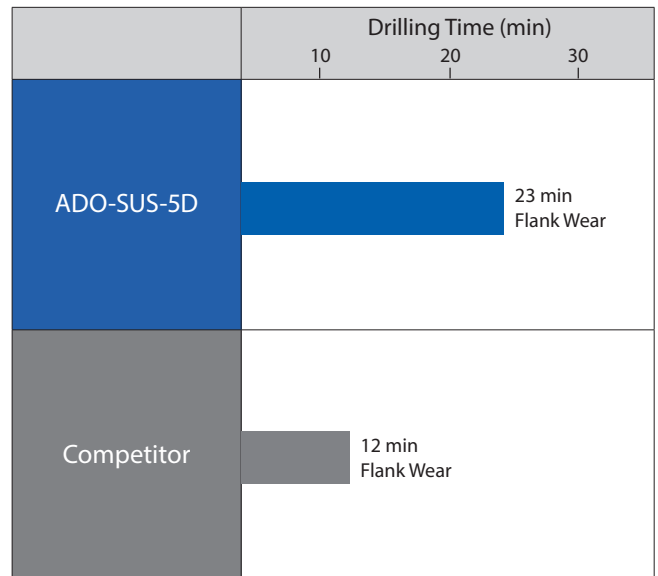
## CUTTING CONDITIONS ADO-SUS-3D/5D/8D

| Vc | Carbon Steel<br>S50C      |                | Alloy Steel<br>SCM440     |                | Alloy Steel<br>SCM440 • 30HRC |                | Stainless Steel<br>SUS304 - SUS316 |                | Super Duplex<br>SUS630 • 17-4PH • 15-5PH |                | Ti Alloy                  |                |
|----|---------------------------|----------------|---------------------------|----------------|-------------------------------|----------------|------------------------------------|----------------|--|----------------|---------------------------|----------------|
|    | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev.) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev.) | S<br>(min <sup>-1</sup> )     | F<br>(mm/rev.) | S<br>(min <sup>-1</sup> )          | F<br>(mm/rev.) | S<br>(min <sup>-1</sup> )                | F<br>(mm/rev.) | S<br>(min <sup>-1</sup> ) | F<br>(mm/rev.) |
| 2  | 12.700                    | 0,04~0,08      | 12.700                    | 0,04~0,08      | 11.900                        | 0,04~0,08      | 12.700                             | 0,04~0,08      | 9.500                                    | 0,04~0,08      | 6.400                     | 0,04~0,08      |
| 3  | 10.600                    | 0,06~0,12      | 10.600                    | 0,06~0,12      | 7.400                         | 0,06~0,12      | 8.500                              | 0,06~0,12      | 4.800                                    | 0,06~0,09      | 3.700                     | 0,05~0,09      |
| 4  | 8.000                     | 0,08~0,16      | 8.000                     | 0,08~0,16      | 5.600                         | 0,08~0,16      | 6.400                              | 0,08~0,16      | 3.600                                    | 0,08~0,12      | 2.800                     | 0,06~0,12      |
| 5  | 6.400                     | 0,10~0,20      | 6.400                     | 0,10~0,20      | 4.500                         | 0,10~0,20      | 5.100                              | 0,10~0,20      | 2.900                                    | 0,10~0,15      | 2.200                     | 0,08~0,15      |
| 6  | 5.300                     | 0,12~0,24      | 5.300                     | 0,12~0,24      | 3.700                         | 0,12~0,24      | 4.200                              | 0,12~0,24      | 2.400                                    | 0,12~0,18      | 1.900                     | 0,09~0,18      |
| 7  | 4.500                     | 0,14~0,26      | 4.500                     | 0,14~0,26      | 3.200                         | 0,14~0,26      | 3.600                              | 0,14~0,26      | 2.000                                    | 0,14~0,21      | 1.600                     | 0,11~0,21      |
| 8  | 4.000                     | 0,16~0,28      | 4.000                     | 0,16~0,28      | 2.800                         | 0,16~0,28      | 3.200                              | 0,16~0,28      | 1.800                                    | 0,16~0,24      | 1.400                     | 0,12~0,24      |
| 9  | 3.500                     | 0,18~0,30      | 3.500                     | 0,18~0,30      | 2.500                         | 0,18~0,30      | 2.800                              | 0,18~0,30      | 1.600                                    | 0,18~0,27      | 1.200                     | 0,14~0,27      |
| 10 | 3.200                     | 0,20~0,30      | 3.200                     | 0,20~0,30      | 2.200                         | 0,20~0,30      | 2.500                              | 0,20~0,30      | 1.400                                    | 0,20~0,30      | 1.100                     | 0,15~0,30      |
| 11 | 2.900                     | 0,20~0,30      | 2.900                     | 0,20~0,30      | 2.000                         | 0,20~0,30      | 2.300                              | 0,20~0,30      | 1.300                                    | 0,20~0,30      | 1.000                     | 0,15~0,30      |
| 12 | 2.700                     | 0,21~0,30      | 2.700                     | 0,21~0,30      | 1.900                         | 0,21~0,30      | 2.100                              | 0,21~0,30      | 1.200                                    | 0,21~0,30      | 900                       | 0,16~0,30      |
| 13 | 2.400                     | 0,21~0,33      | 2.400                     | 0,21~0,33      | 1.700                         | 0,21~0,33      | 2.000                              | 0,21~0,33      | 1.100                                    | 0,21~0,33      | 900                       | 0,18~0,33      |
| 14 | 2.300                     | 0,22~0,35      | 2.300                     | 0,22~0,35      | 1.600                         | 0,22~0,35      | 1.800                              | 0,22~0,35      | 1.000                                    | 0,22~0,35      | 800                       | 0,19~0,35      |
| 16 | 2.000                     | 0,25~0,36      | 2.000                     | 0,25~0,36      | 1.400                         | 0,25~0,36      | 1.600                              | 0,25~0,36      | 900                                      | 0,25~0,36      | 700                       | 0,22~0,36      |
| 18 | 1.800                     | 0,28~0,38      | 1.800                     | 0,28~0,38      | 1.200                         | 0,28~0,38      | 1.400                              | 0,28~0,38      | 800                                      | 0,28~0,38      | 600                       | 0,24~0,38      |
| 20 | 1.600                     | 0,30~0,40      | 1.600                     | 0,30~0,40      | 1.100                         | 0,30~0,40      | 1.300                              | 0,30~0,40      | 700                                      | 0,30~0,40      | 600                       | 0,27~0,40      |

# MACHINING DATA OF STAINLESS STEEL

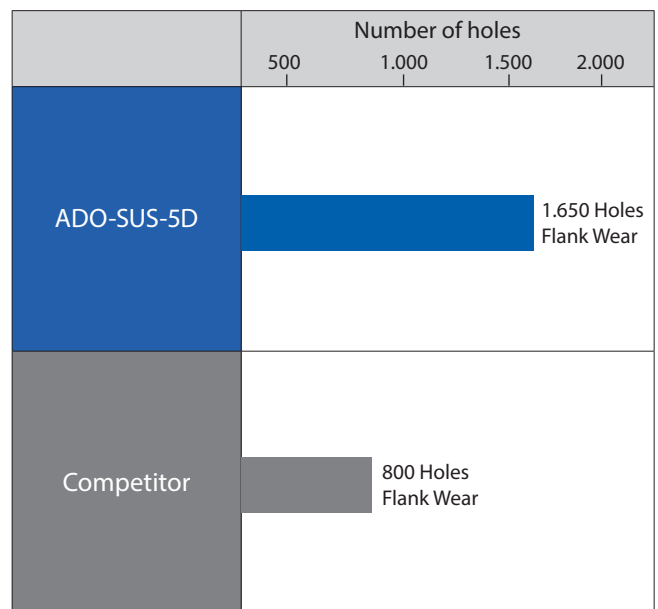
## Machining precipitation hardening Stainless Steel

| Tool          | ADO-SUS-5D                         | Competitor |
|---------------|------------------------------------|------------|
| Size          | Ø 6,7                              |            |
| Work Material | 15-5 PH                            |            |
| Cutting Speed | 50m/min (2.377 min <sup>-1</sup> ) |            |
| Feed Rate     | 357 mm/min (0,15 mm/rev)           |            |
| Depth of Hole | 45 mm (Blind)                      |            |
| Coolant       | Water Soluble (Internal)           |            |
| Machine       | Horizontal Machining Center        |            |



## Machining Duplex Stainless Steel

| Tool          | ADO-SUS-5D                         | Competitor |
|---------------|------------------------------------|------------|
| Size          | Ø 10,3                             |            |
| Work Material | SUS329J3L                          |            |
| Cutting Speed | 65m/min (2.010 min <sup>-1</sup> ) |            |
| Feed Rate     | 462 mm/min (0,23 mm/rev)           |            |
| Depth of Hole | 48 mm (Through)                    |            |
| Coolant       | Water Soluble (Internal)           |            |
| Machine       | Multifunction Lathe                |            |

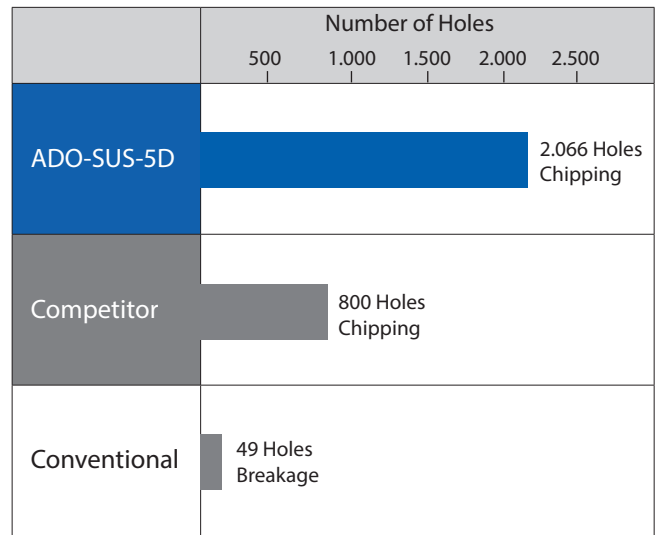




# MACHINING DATA OF TITANIUM ALLOY

## ADO-SUS-3D in Titanium Alloy

|                      |  |
|----------------------|--|
| <b>Tool</b>          | ADO-SUS-3D Ø 5,1                                 |
| <b>Work Material</b> | Ti-6Al-4V (34~36 HRC)<br>(After aging treatment) |
| <b>Cutting Speed</b> | 40m/min (2.498 min <sup>-1</sup> )               |
| <b>Feed Rate</b>     | 300 mm/min (0,12 mm/rev)                         |
| <b>Depth of Hole</b> | 17 mm (Through)                                  |
| <b>Coolant</b>       | Water Soluble (Internal)                         |
| <b>Machine</b>       | Horizontal Machining Center                      |

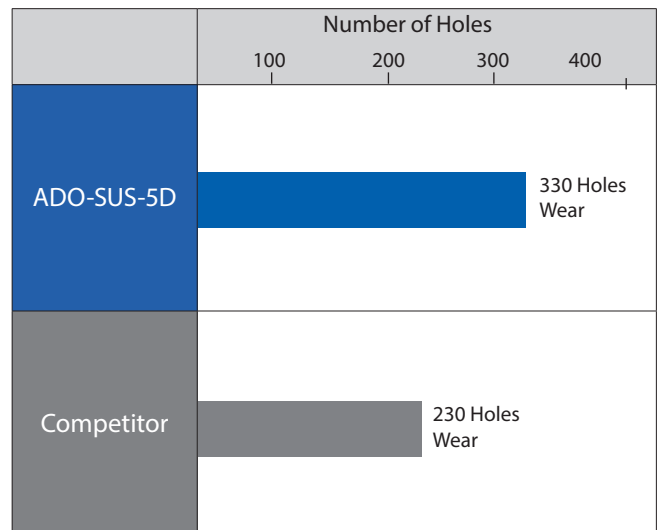


Cutting chips



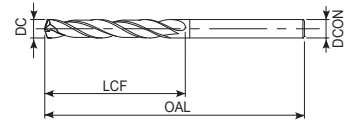
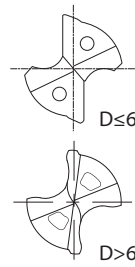
## ADO-SUS-5D in Titanium Alloy

|                      |                                    |
|----------------------|------------------------------------|
| <b>Tool</b>          | ADO-SUS-5D Ø 10,5                  |
| <b>Work Material</b> | Ti-6Al-4V                          |
| <b>Cutting Speed</b> | 45m/min (1.365 min <sup>-1</sup> ) |
| <b>Feed Rate</b>     | 177,5 mm/min (0,13 mm/rev)         |
| <b>Depth of Hole</b> | 29 mm (Blind)                      |
| <b>Coolant</b>       | Water Soluble (Internal)           |
| <b>Machine</b>       | Horizontal Machining Center        |



# ADO-SUS-3D NEW SIZES

Drilling | Solid carbide | 3xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 3xD
- Designed for stainless steel and titanium alloys
- 179 sizes



Drilling | Solid carbide

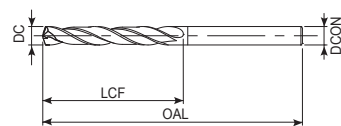
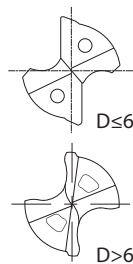
3xD

| EDP     | DC   | LCF | OAL | DCON | EDP     | DC   | LCF | OAL | DCON |
|---------|------|-----|-----|------|---------|------|-----|-----|------|
| 8665200 | 2    | 12  | 66  | 3    | 8680555 | 5,55 | 28  | 82  | 6    |
| 8665210 | 2,1  | 13  | 66  | 3    | 8665560 | 5,6  | 28  | 82  | 6    |
| 8665220 | 2,2  | 14  | 66  | 3    | 8665570 | 5,7  | 29  | 82  | 6    |
| 8665230 | 2,3  | 14  | 66  | 3    | 8665580 | 5,8  | 29  | 82  | 6    |
| 8665240 | 2,4  | 15  | 66  | 3    | 8665590 | 5,9  | 30  | 82  | 6    |
| 8665250 | 2,5  | 15  | 66  | 3    | 8665600 | 6    | 30  | 82  | 6    |
| 8665260 | 2,6  | 16  | 66  | 3    | 8680610 | 6,1  | 31  | 88  | 8    |
| 8665270 | 2,7  | 17  | 66  | 3    | 8680620 | 6,2  | 31  | 88  | 8    |
| 8665280 | 2,8  | 17  | 66  | 3    | 8680630 | 6,3  | 32  | 88  | 8    |
| 8665283 | 2,83 | 17  | 66  | 3    | 8680640 | 6,4  | 32  | 88  | 8    |
| 8665287 | 2,87 | 18  | 66  | 3    | 8680650 | 6,5  | 33  | 88  | 8    |
| 8665290 | 2,9  | 18  | 66  | 3    | 8680660 | 6,6  | 33  | 88  | 8    |
| 8665300 | 3    | 18  | 66  | 3    | 8680670 | 6,7  | 34  | 88  | 8    |
| 8665310 | 3,1  | 19  | 74  | 4    | 8680680 | 6,8  | 34  | 88  | 8    |
| 8665315 | 3,15 | 19  | 74  | 4    | 8680690 | 6,9  | 35  | 88  | 8    |
| 8665320 | 3,2  | 20  | 74  | 4    | 8680700 | 7    | 35  | 88  | 8    |
| 8665326 | 3,26 | 20  | 74  | 4    | 8665710 | 7,1  | 36  | 94  | 8    |
| 8665330 | 3,3  | 20  | 74  | 4    | 8665720 | 7,2  | 36  | 94  | 8    |
| 8665340 | 3,4  | 21  | 74  | 4    | 8665725 | 7,25 | 37  | 94  | 8    |
| 8665350 | 3,5  | 21  | 74  | 4    | 8665730 | 7,3  | 37  | 94  | 8    |
| 8665360 | 3,6  | 22  | 74  | 4    | 8665740 | 7,4  | 37  | 94  | 8    |
| 8665370 | 3,7  | 23  | 74  | 4    | 8680745 | 7,45 | 38  | 94  | 8    |
| 8665373 | 3,73 | 23  | 74  | 4    | 8665750 | 7,5  | 38  | 94  | 8    |
| 8665375 | 3,75 | 23  | 74  | 4    | 8680755 | 7,55 | 38  | 94  | 8    |
| 8665380 | 3,8  | 23  | 74  | 4    | 8665760 | 7,6  | 38  | 94  | 8    |
| 8665390 | 3,9  | 24  | 74  | 4    | 8665770 | 7,7  | 39  | 94  | 8    |
| 8665400 | 4    | 24  | 74  | 4    | 8665775 | 7,75 | 39  | 94  | 8    |
| 8680410 | 4,1  | 25  | 80  | 6    | 8665780 | 7,8  | 39  | 94  | 8    |
| 8680420 | 4,2  | 26  | 80  | 6    | 8665790 | 7,9  | 40  | 94  | 8    |
| 8680430 | 4,3  | 26  | 80  | 6    | 8665800 | 8    | 40  | 94  | 8    |
| 8680440 | 4,4  | 27  | 80  | 6    | 8680810 | 8,1  | 41  | 101 | 10   |
| 8680445 | 4,45 | 27  | 80  | 6    | 8680820 | 8,2  | 41  | 101 | 10   |
| 8680450 | 4,5  | 27  | 80  | 6    | 8680830 | 8,3  | 42  | 101 | 10   |
| 8680460 | 4,6  | 28  | 80  | 6    | 8680840 | 8,4  | 42  | 101 | 10   |
| 8680465 | 4,65 | 28  | 80  | 6    | 8680850 | 8,5  | 43  | 101 | 10   |
| 8680470 | 4,7  | 29  | 80  | 6    | 8680860 | 8,6  | 43  | 101 | 10   |
| 8680480 | 4,8  | 29  | 80  | 6    | 8680870 | 8,7  | 44  | 101 | 10   |
| 8665485 | 4,85 | 29  | 80  | 6    | 8680880 | 8,8  | 44  | 101 | 10   |
| 8680490 | 4,9  | 30  | 80  | 6    | 8680890 | 8,9  | 45  | 101 | 10   |
| 8680500 | 5    | 25  | 80  | 6    | 8680900 | 9    | 45  | 101 | 10   |
| 8665510 | 5,1  | 26  | 82  | 6    | 8665910 | 9,1  | 46  | 106 | 10   |
| 8665520 | 5,2  | 26  | 82  | 6    | 8665920 | 9,2  | 46  | 106 | 10   |
| 8665525 | 5,25 | 27  | 82  | 6    | 8665925 | 9,25 | 47  | 106 | 10   |
| 8665530 | 5,3  | 27  | 82  | 6    | 8665930 | 9,3  | 47  | 106 | 10   |
| 8665540 | 5,4  | 27  | 82  | 6    | 8665940 | 9,4  | 47  | 106 | 10   |
| 8665550 | 5,5  | 28  | 82  | 6    | 8665950 | 9,5  | 48  | 106 | 10   |



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- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 3xD
- Designed for stainless steel and titanium alloys
- 179 sizes



| EDP     | DC    | LCF | OAL | DCON |
|---------|-------|-----|-----|------|
| 8680955 | 9,55  | 48  | 106 | 10   |
| 8665960 | 9,6   | 48  | 106 | 10   |
| 8665970 | 9,7   | 49  | 106 | 10   |
| 8665975 | 9,75  | 49  | 106 | 10   |
| 8665980 | 9,8   | 49  | 106 | 10   |
| 8665990 | 9,9   | 50  | 106 | 10   |
| 8666000 | 10    | 50  | 106 | 10   |
| 8681010 | 10,1  | 51  | 113 | 12   |
| 8681020 | 10,2  | 51  | 113 | 12   |
| 8681030 | 10,3  | 52  | 113 | 12   |
| 8681040 | 10,4  | 52  | 113 | 12   |
| 8681050 | 10,5  | 53  | 113 | 12   |
| 8681060 | 10,6  | 53  | 113 | 12   |
| 8681070 | 10,7  | 54  | 113 | 12   |
| 8681080 | 10,8  | 54  | 113 | 12   |
| 8681090 | 10,9  | 55  | 113 | 12   |
| 8681100 | 11    | 55  | 113 | 12   |
| 8666110 | 11,1  | 56  | 120 | 12   |
| 8666120 | 11,2  | 56  | 120 | 12   |
| 8666130 | 11,3  | 57  | 120 | 12   |
| 8666140 | 11,4  | 57  | 120 | 12   |
| 8666150 | 11,5  | 58  | 120 | 12   |
| 8666160 | 11,6  | 58  | 120 | 12   |
| 8666170 | 11,7  | 59  | 120 | 12   |
| 8666180 | 11,8  | 59  | 120 | 12   |
| 8666190 | 11,9  | 60  | 120 | 12   |
| 8666200 | 12    | 60  | 120 | 12   |
| 8681210 | 12,1  | 61  | 128 | 14   |
| 8681220 | 12,2  | 61  | 128 | 14   |
| 8681230 | 12,3  | 62  | 128 | 14   |
| 8681240 | 12,4  | 62  | 128 | 14   |
| 8681250 | 12,5  | 63  | 128 | 14   |
| 8681260 | 12,6  | 63  | 128 | 14   |
| 8681270 | 12,7  | 64  | 128 | 14   |
| 8681280 | 12,8  | 64  | 128 | 14   |
| 8681290 | 12,9  | 65  | 128 | 14   |
| 8681300 | 13    | 65  | 128 | 14   |
| 8666310 | 13,1  | 66  | 134 | 14   |
| 8666320 | 13,2  | 67  | 134 | 14   |
| 8666330 | 13,3  | 68  | 134 | 14   |
| 8666340 | 13,4  | 67  | 134 | 14   |
| 8681343 | 13,43 | 68  | 134 | 14   |
| 8666350 | 13,5  | 68  | 134 | 14   |
| 8681355 | 13,55 | 68  | 134 | 14   |
| 8666360 | 13,6  | 68  | 134 | 14   |
| 8666370 | 13,7  | 69  | 134 | 14   |

| EDP      | DC    | LCF | OAL | DCON |
|----------|-------|-----|-----|------|
| 8666380  | 13,8  | 69  | 134 | 14   |
| 8666390  | 13,9  | 70  | 134 | 14   |
| 8666400  | 14    | 70  | 134 | 14   |
| 8681410  | 14,1  | 71  | 140 | 16   |
| 8681420  | 14,2  | 71  | 140 | 16   |
| 8681430  | 14,3  | 72  | 140 | 16   |
| 8681440  | 14,4  | 72  | 140 | 16   |
| 8681450  | 14,5  | 73  | 140 | 16   |
| 8681460  | 14,6  | 73  | 140 | 16   |
| 8681470  | 14,7  | 74  | 140 | 16   |
| 8681480  | 14,8  | 74  | 140 | 16   |
| 8681490  | 14,9  | 75  | 140 | 16   |
| 8681500  | 15    | 75  | 140 | 16   |
| 8666510  | 15,1  | 76  | 145 | 16   |
| 8666520  | 15,2  | 76  | 145 | 16   |
| 8666530  | 15,3  | 77  | 145 | 16   |
| 8666540  | 15,4  | 77  | 145 | 16   |
| 8666550  | 15,5  | 78  | 145 | 16   |
| 8681555  | 15,55 | 78  | 145 | 16   |
| 8666560  | 15,6  | 78  | 145 | 16   |
| 8666570  | 15,7  | 79  | 145 | 16   |
| 8666580  | 15,8  | 79  | 145 | 16   |
| 8666590  | 15,9  | 80  | 145 | 16   |
| 8666600  | 16    | 80  | 145 | 16   |
| 48350161 | 16,1  | 80  | 145 | 18   |
| 8681650  | 16,5  | 83  | 150 | 18   |
| 8681670  | 16,7  | 84  | 150 | 18   |
| 8681700  | 17    | 85  | 150 | 18   |
| 8681730  | 17,3  | 87  | 155 | 18   |
| 8666750  | 17,5  | 88  | 155 | 18   |
| 8681755  | 17,55 | 88  | 155 | 18   |
| 48350178 | 17,8  | 90  | 155 | 18   |
| 8666800  | 18    | 90  | 155 | 18   |
| 48350181 | 18,1  | 90  | 155 | 20   |
| 8681850  | 18,5  | 93  | 160 | 20   |
| 8681870  | 18,7  | 94  | 160 | 20   |
| 8681900  | 19    | 95  | 160 | 20   |
| 8681930  | 19,3  | 97  | 165 | 20   |
| 8666950  | 19,5  | 98  | 165 | 20   |
| 8681955  | 19,55 | 98  | 165 | 20   |
| 8667000  | 20    | 100 | 165 | 20   |

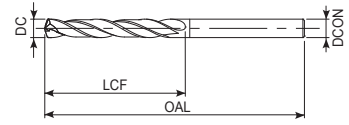
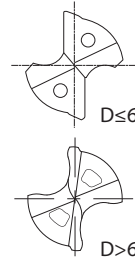
Drilling | Solid carbide



3xD

# ADO-SUS-5D NEW SIZES

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 5xD
- Designed for stainless steel and titanium alloys
- 198 sizes



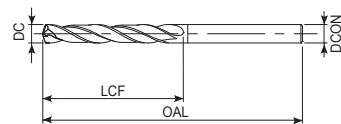
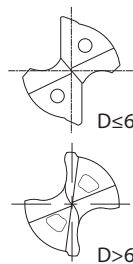
Drilling | Solid carbide

5xD

| EDP      | DC   | LCF | OAL | DCON | EDP     | DC   | LCF | OAL | DCON |
|----------|------|-----|-----|------|---------|------|-----|-----|------|
| 8667200  | 2    | 18  | 70  | 3    | 8682490 | 4,9  | 45  | 95  | 6    |
| 8667210  | 2,1  | 19  | 70  | 3    | 8682500 | 5    | 45  | 95  | 6    |
| 48349215 | 2,15 | 20  | 70  | 3    | 8667510 | 5,1  | 41  | 100 | 6    |
| 8667220  | 2,2  | 20  | 70  | 3    | 8667520 | 5,2  | 42  | 100 | 6    |
| 48349225 | 2,25 | 21  | 70  | 3    | 8667530 | 5,3  | 43  | 100 | 6    |
| 8667230  | 2,3  | 21  | 70  | 3    | 8667540 | 5,4  | 44  | 100 | 6    |
| 48349235 | 2,35 | 22  | 70  | 3    | 8667550 | 5,5  | 44  | 100 | 6    |
| 8667240  | 2,4  | 22  | 70  | 3    | 8667552 | 5,52 | 45  | 100 | 6    |
| 8667250  | 2,5  | 23  | 70  | 3    | 8667554 | 5,54 | 45  | 100 | 6    |
| 48349255 | 2,55 | 24  | 70  | 3    | 8667560 | 5,6  | 45  | 100 | 6    |
| 8667260  | 2,6  | 24  | 78  | 3    | 8667570 | 5,7  | 46  | 100 | 6    |
| 8667270  | 2,7  | 25  | 78  | 3    | 8667580 | 5,8  | 47  | 100 | 6    |
| 8667276  | 2,76 | 25  | 78  | 3    | 8667590 | 5,9  | 48  | 100 | 6    |
| 8667278  | 2,78 | 26  | 78  | 3    | 8667600 | 6    | 48  | 100 | 6    |
| 8667280  | 2,8  | 26  | 78  | 3    | 8682610 | 6,1  | 49  | 109 | 8    |
| 8667283  | 2,83 | 26  | 78  | 3    | 8682620 | 6,2  | 50  | 109 | 8    |
| 8667287  | 2,87 | 26  | 78  | 3    | 8682630 | 6,3  | 51  | 109 | 8    |
| 8667290  | 2,9  | 27  | 78  | 3    | 8682640 | 6,4  | 52  | 109 | 8    |
| 8667300  | 3    | 27  | 78  | 3    | 8682650 | 6,5  | 52  | 109 | 8    |
| 8667310  | 3,1  | 28  | 86  | 4    | 8682660 | 6,6  | 53  | 109 | 8    |
| 8667315  | 3,15 | 29  | 86  | 4    | 8682670 | 6,7  | 54  | 109 | 8    |
| 8667320  | 3,2  | 29  | 86  | 4    | 8682680 | 6,8  | 55  | 109 | 8    |
| 8667326  | 3,26 | 29  | 86  | 4    | 8682690 | 6,9  | 56  | 109 | 8    |
| 8667330  | 3,3  | 30  | 86  | 4    | 8682700 | 7    | 56  | 109 | 8    |
| 48349335 | 3,35 | 31  | 86  | 4    | 8667710 | 7,1  | 57  | 118 | 8    |
| 8667340  | 3,4  | 31  | 86  | 4    | 8667720 | 7,2  | 58  | 118 | 8    |
| 8667350  | 3,5  | 32  | 86  | 4    | 8667725 | 7,25 | 58  | 118 | 8    |
| 8667360  | 3,6  | 33  | 86  | 4    | 8667730 | 7,3  | 59  | 118 | 8    |
| 8667366  | 3,66 | 33  | 86  | 4    | 8667736 | 7,36 | 59  | 118 | 8    |
| 8667368  | 3,68 | 34  | 86  | 4    | 8667738 | 7,38 | 60  | 118 | 8    |
| 8667370  | 3,7  | 34  | 86  | 4    | 8667740 | 7,4  | 60  | 118 | 8    |
| 8667373  | 3,73 | 34  | 86  | 4    | 8682745 | 7,45 | 60  | 118 | 8    |
| 8667375  | 3,75 | 34  | 86  | 4    | 8667750 | 7,5  | 60  | 118 | 8    |
| 8667380  | 3,8  | 35  | 86  | 4    | 8667752 | 7,52 | 61  | 118 | 8    |
| 8667390  | 3,9  | 36  | 86  | 4    | 8667754 | 7,54 | 61  | 118 | 8    |
| 8667400  | 4    | 36  | 86  | 4    | 8667760 | 7,6  | 61  | 118 | 8    |
| 8682410  | 4,1  | 37  | 95  | 6    | 8667770 | 7,7  | 62  | 118 | 8    |
| 8682420  | 4,2  | 38  | 95  | 6    | 8667775 | 7,75 | 62  | 118 | 8    |
| 8682430  | 4,3  | 39  | 95  | 6    | 8667780 | 7,8  | 63  | 118 | 8    |
| 8682440  | 4,4  | 40  | 95  | 6    | 8667790 | 7,9  | 64  | 118 | 8    |
| 8682445  | 4,45 | 41  | 95  | 6    | 8667800 | 8    | 64  | 118 | 8    |
| 8682450  | 4,5  | 41  | 95  | 6    | 8682810 | 8,1  | 65  | 128 | 10   |
| 8682460  | 4,6  | 42  | 95  | 6    | 8682820 | 8,2  | 66  | 128 | 10   |
| 8682464  | 4,64 | 42  | 95  | 6    | 8682830 | 8,3  | 67  | 128 | 10   |
| 8682470  | 4,7  | 43  | 95  | 6    | 8682840 | 8,4  | 68  | 128 | 10   |
| 8682480  | 4,8  | 44  | 95  | 6    | 8682850 | 8,5  | 68  | 128 | 10   |

# ADO-SUS-5D NEW SIZES

Drilling | Solid carbide | 5xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 5xD
- Designed for stainless steel and titanium alloys
- 198 sizes



| EDP     | DC    | LCF | OAL | DCON |
|---------|-------|-----|-----|------|
| 8682860 | 8,6   | 69  | 128 | 10   |
| 8682870 | 8,7   | 70  | 128 | 10   |
| 8682880 | 8,8   | 71  | 128 | 10   |
| 8682890 | 8,9   | 72  | 128 | 10   |
| 8682900 | 9     | 72  | 128 | 10   |
| 8667910 | 9,1   | 73  | 136 | 10   |
| 8667920 | 9,2   | 74  | 136 | 10   |
| 8667924 | 9,24  | 74  | 136 | 10   |
| 8667925 | 9,25  | 74  | 136 | 10   |
| 8667926 | 9,26  | 75  | 136 | 10   |
| 8667930 | 9,3   | 75  | 136 | 10   |
| 8667936 | 9,36  | 75  | 136 | 10   |
| 8667938 | 9,38  | 76  | 136 | 10   |
| 8667940 | 9,4   | 76  | 136 | 10   |
| 8667950 | 9,5   | 76  | 136 | 10   |
| 8667952 | 9,52  | 77  | 136 | 10   |
| 8667954 | 9,54  | 77  | 136 | 10   |
| 8667960 | 9,6   | 77  | 136 | 10   |
| 8667970 | 9,7   | 78  | 136 | 10   |
| 8667975 | 9,75  | 78  | 136 | 10   |
| 8667980 | 9,8   | 79  | 136 | 10   |
| 8667990 | 9,9   | 80  | 136 | 10   |
| 8668000 | 10    | 80  | 136 | 10   |
| 8683010 | 10,1  | 81  | 146 | 12   |
| 8683020 | 10,2  | 82  | 146 | 12   |
| 8683030 | 10,3  | 83  | 146 | 12   |
| 8683040 | 10,4  | 84  | 146 | 12   |
| 8683050 | 10,5  | 84  | 146 | 12   |
| 8683060 | 10,6  | 85  | 146 | 12   |
| 8683070 | 10,7  | 86  | 146 | 12   |
| 8683080 | 10,8  | 87  | 146 | 12   |
| 8683090 | 10,9  | 88  | 146 | 12   |
| 8683100 | 11    | 88  | 146 | 12   |
| 8668110 | 11,1  | 89  | 156 | 12   |
| 8668120 | 11,2  | 90  | 156 | 12   |
| 8668122 | 11,22 | 90  | 156 | 12   |
| 8668124 | 11,24 | 90  | 156 | 12   |
| 8668130 | 11,3  | 91  | 156 | 12   |
| 8668136 | 11,36 | 91  | 156 | 12   |
| 8668138 | 11,38 | 92  | 156 | 12   |
| 8668140 | 11,4  | 92  | 156 | 12   |
| 8668150 | 11,5  | 92  | 156 | 12   |
| 8668160 | 11,6  | 93  | 156 | 12   |
| 8668170 | 11,7  | 94  | 156 | 12   |
| 8668180 | 11,8  | 95  | 156 | 12   |
| 8668190 | 11,9  | 96  | 156 | 12   |

| EDP     | DC    | LCF | OAL | DCON |
|---------|-------|-----|-----|------|
| 8668200 | 12    | 96  | 156 | 12   |
| 8683210 | 12,1  | 97  | 167 | 14   |
| 8683220 | 12,2  | 98  | 167 | 14   |
| 8683230 | 12,3  | 99  | 167 | 14   |
| 8683240 | 12,4  | 100 | 167 | 14   |
| 8683250 | 12,5  | 100 | 167 | 14   |
| 8683260 | 12,6  | 101 | 167 | 14   |
| 8683270 | 12,7  | 102 | 167 | 14   |
| 8683280 | 12,8  | 103 | 167 | 14   |
| 8683290 | 12,9  | 104 | 167 | 14   |
| 8683300 | 13    | 104 | 167 | 14   |
| 8668310 | 13,1  | 105 | 176 | 14   |
| 8668320 | 13,2  | 106 | 176 | 14   |
| 8668325 | 13,25 | 106 | 176 | 14   |
| 8668330 | 13,3  | 107 | 176 | 14   |
| 8668340 | 13,4  | 108 | 176 | 14   |
| 8683343 | 13,43 | 108 | 176 | 14   |
| 8668350 | 13,5  | 108 | 176 | 14   |
| 8683355 | 13,55 | 109 | 176 | 14   |
| 8668360 | 13,6  | 109 | 176 | 14   |
| 8668370 | 13,7  | 110 | 176 | 14   |
| 8668380 | 13,8  | 111 | 176 | 14   |
| 8668390 | 13,9  | 112 | 176 | 14   |
| 8668400 | 14    | 112 | 176 | 14   |
| 8683410 | 14,1  | 113 | 185 | 16   |
| 8683420 | 14,2  | 114 | 185 | 16   |
| 8683430 | 14,3  | 115 | 185 | 16   |
| 8683440 | 14,4  | 116 | 185 | 16   |
| 8683450 | 14,5  | 116 | 185 | 16   |
| 8683460 | 14,6  | 117 | 185 | 16   |
| 8683470 | 14,7  | 118 | 185 | 16   |
| 8683480 | 14,8  | 119 | 185 | 16   |
| 8683490 | 14,9  | 120 | 185 | 16   |
| 8683500 | 15    | 120 | 185 | 16   |
| 8668510 | 15,1  | 121 | 193 | 16   |
| 8668520 | 15,2  | 122 | 193 | 16   |
| 8668525 | 15,25 | 122 | 193 | 16   |
| 8668530 | 15,3  | 123 | 193 | 16   |
| 8668540 | 15,4  | 124 | 193 | 16   |
| 8668550 | 15,5  | 124 | 193 | 16   |
| 8683555 | 15,55 | 125 | 193 | 16   |
| 8668560 | 15,6  | 125 | 193 | 16   |
| 8668570 | 15,7  | 126 | 193 | 16   |
| 8668580 | 15,8  | 127 | 193 | 16   |
| 8668590 | 15,9  | 128 | 193 | 16   |
| 8668600 | 16    | 128 | 193 | 16   |

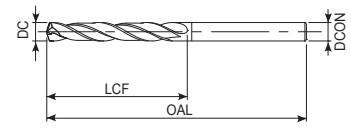
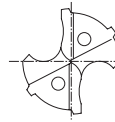






# ADO-SUS-8D

Drilling | Solid carbide | 8xD



- First choice in quality and performance
- Carbide drill with internal coolant, WXL coating
- Up to 8xD
- Designed for stainless steel and titanium alloys
- 101 sizes

|                   |                         |                    |              |               |             |              |                  |             |                    |                    |                    |
|-------------------|-------------------------|--------------------|--------------|---------------|-------------|--------------|------------------|-------------|--------------------|--------------------|--------------------|
| <b>P</b> C < 0,2% | <b>P</b> 0,25 < C < 0,4 | <b>P</b> C ≥ 0,45% | <b>P</b> SCM | <b>M</b> INOX | <b>K</b> GG | <b>K</b> GGG | <b>N</b> AC, ADC | <b>S</b> Ti | <b>H</b> 25-35 HRC | <b>H</b> 35-45 HRC | <b>H</b> 45-52 HRC |
|-------------------|-------------------------|--------------------|--------------|---------------|-------------|--------------|------------------|-------------|--------------------|--------------------|--------------------|

|          |                |            |            |                   |  |             |           |        |
|----------|----------------|------------|------------|-------------------|--|-------------|-----------|--------|
| <b>A</b> | <b>CARBIDE</b> | <b>WXL</b> | <b>30°</b> | <b>SHRINK FIT</b> |  | <b>135°</b> | <b>h8</b> | page 7 |
|----------|----------------|------------|------------|-------------------|--|-------------|-----------|--------|

| EDP     | DC  | LCF | OAL | DCON | EDP     | DC   | LCF | OAL | DCON |
|---------|-----|-----|-----|------|---------|------|-----|-----|------|
| 8686200 | 2   | 22  | 75  | 3    | 8684660 | 6,6  | 73  | 125 | 8    |
| 8686210 | 2,1 | 24  | 75  | 3    | 8684670 | 6,7  | 74  | 125 | 8    |
| 8686220 | 2,2 | 25  | 75  | 3    | 8684680 | 6,8  | 75  | 125 | 8    |
| 8686230 | 2,3 | 26  | 75  | 3    | 8684690 | 6,9  | 76  | 125 | 8    |
| 8686240 | 2,4 | 27  | 75  | 3    | 8684700 | 7    | 77  | 125 | 8    |
| 8686250 | 2,5 | 28  | 75  | 3    | 8684710 | 7,1  | 78  | 140 | 8    |
| 8686260 | 2,6 | 29  | 80  | 3    | 8684720 | 7,2  | 79  | 140 | 8    |
| 8686270 | 2,7 | 30  | 80  | 3    | 8684730 | 7,3  | 80  | 140 | 8    |
| 8686280 | 2,8 | 31  | 80  | 3    | 8684740 | 7,4  | 81  | 140 | 8    |
| 8686290 | 2,9 | 32  | 80  | 3    | 8684750 | 7,5  | 83  | 140 | 8    |
| 8686300 | 3   | 33  | 80  | 3    | 8684760 | 7,6  | 84  | 140 | 8    |
| 8684310 | 3,1 | 34  | 95  | 4    | 8684770 | 7,7  | 85  | 140 | 8    |
| 8684320 | 3,2 | 35  | 95  | 4    | 8684780 | 7,8  | 86  | 140 | 8    |
| 8684330 | 3,3 | 36  | 95  | 4    | 8684790 | 7,9  | 87  | 140 | 8    |
| 8684340 | 3,4 | 37  | 95  | 4    | 8684800 | 8    | 88  | 140 | 8    |
| 8684350 | 3,5 | 39  | 95  | 4    | 8684810 | 8,1  | 89  | 150 | 10   |
| 8684360 | 3,6 | 40  | 95  | 4    | 8684820 | 8,2  | 90  | 150 | 10   |
| 8684370 | 3,7 | 41  | 95  | 4    | 8684830 | 8,3  | 91  | 150 | 10   |
| 8684380 | 3,8 | 42  | 95  | 4    | 8684840 | 8,4  | 92  | 150 | 10   |
| 8684390 | 3,9 | 43  | 95  | 4    | 8684850 | 8,5  | 94  | 150 | 10   |
| 8684400 | 4   | 44  | 95  | 4    | 8684860 | 8,6  | 95  | 150 | 10   |
| 8684410 | 4,1 | 45  | 105 | 6    | 8684870 | 8,7  | 96  | 150 | 10   |
| 8684420 | 4,2 | 46  | 105 | 6    | 8684880 | 8,8  | 97  | 150 | 10   |
| 8684430 | 4,3 | 47  | 105 | 6    | 8684890 | 8,9  | 98  | 150 | 10   |
| 8684440 | 4,4 | 48  | 105 | 6    | 8684900 | 9    | 99  | 150 | 10   |
| 8684450 | 4,5 | 50  | 105 | 6    | 8684910 | 9,1  | 100 | 160 | 10   |
| 8684460 | 4,6 | 51  | 105 | 6    | 8684920 | 9,2  | 101 | 160 | 10   |
| 8684470 | 4,7 | 52  | 105 | 6    | 8684930 | 9,3  | 102 | 160 | 10   |
| 8684480 | 4,8 | 53  | 105 | 6    | 8684940 | 9,4  | 103 | 160 | 10   |
| 8684490 | 4,9 | 54  | 105 | 6    | 8684950 | 9,5  | 105 | 160 | 10   |
| 8684500 | 5   | 55  | 105 | 6    | 8684960 | 9,6  | 106 | 160 | 10   |
| 8684510 | 5,1 | 56  | 115 | 6    | 8684970 | 9,7  | 107 | 160 | 10   |
| 8684520 | 5,2 | 57  | 115 | 6    | 8684980 | 9,8  | 108 | 160 | 10   |
| 8684530 | 5,3 | 58  | 115 | 6    | 8684990 | 9,9  | 109 | 160 | 10   |
| 8684540 | 5,4 | 59  | 115 | 6    | 8685000 | 10   | 110 | 160 | 10   |
| 8684550 | 5,5 | 61  | 115 | 6    | 8685010 | 10,1 | 111 | 182 | 12   |
| 8684560 | 5,6 | 62  | 115 | 6    | 8685020 | 10,2 | 112 | 182 | 12   |
| 8684570 | 5,7 | 63  | 115 | 6    | 8685030 | 10,3 | 113 | 182 | 12   |
| 8684580 | 5,8 | 64  | 115 | 6    | 8685040 | 10,4 | 114 | 182 | 12   |
| 8684590 | 5,9 | 65  | 115 | 6    | 8685050 | 10,5 | 116 | 182 | 12   |
| 8684600 | 6   | 66  | 115 | 6    | 8685060 | 10,6 | 117 | 182 | 12   |
| 8684610 | 6,1 | 67  | 125 | 8    | 8685070 | 10,7 | 118 | 182 | 12   |
| 8684620 | 6,2 | 68  | 125 | 8    | 8685080 | 10,8 | 119 | 182 | 12   |
| 8684630 | 6,3 | 69  | 125 | 8    | 8685090 | 10,9 | 120 | 182 | 12   |
| 8684640 | 6,4 | 70  | 125 | 8    | 8685100 | 11   | 121 | 182 | 12   |
| 8684650 | 6,5 | 72  | 125 | 8    | 8685110 | 11,1 | 122 | 194 | 12   |

Drilling | Solid carbide 8xD







[www.osgeurope.com](http://www.osgeurope.com)



## SWEDEN

Branch office of OSG SCANDINAVIA  
Singelgatan 7  
212 28 Malmö  
Sweden  
Tel: +46 40 41 22 55  
osg@osg-scandinavia.com

## OSG SCANDINAVIA

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

## OSG NETHERLANDS

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

## OSG UK

Kelsey Close, Attleborough Fields Ind Est,  
CV11 6RS, Nuneaton  
United Kingdom  
Tel: +44 1827 720 013  
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 IBÉRICA

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

Via Ferrero, 65 A/B  
I - 10098 Rivoli  
Italy  
Tel: +39 0117705211  
Fax: +39 0117705215  
info@osg-italia.it





# OSG IN EUROPE

## CZECH REPUBLIC, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.  
Slovakia, organizačná zložka  
Račianska 22/A, Bratislava 831 02  
Slovakia  
Tel.: +421 24 32 91 295  
info@osgeurope.com

## OSG POLAND

ul. Spółdzielcza 57  
05-074 Halinów  
Polska  
Tel: +22 760 82 71  
Mob. +48 570 677 711  
osg@osg-poland.com

## ROMSAN INTERNATIONAL CO. SRL

Reprezentant Exclusiv OSG  
25C, Bucuresti-Magurele Street  
051431 Bucuresti  
România  
Tel: +40 21 322 07 47  
Fax: +40 21 321 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

## Vischer & Bolli AG

Machining and Workholding  
Im Schossacher 17  
CH-8600 Dübendorf  
Schweiz  
Tel.: +41 44 802 15 15  
Fax: +41 44 802 15 95  
info@vb-tools.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



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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  
Tel: +31 348 44 2764  
Fax: +31 348 44 2144  
info@osg-nl.com

#### **OSG UK**

Kelsey Close, Attleborough Fields Ind Est,  
CV11 6RS, Nuneaton, United Kingdom.  
Tel: +44 1827 720 013  
uk\_sales@osg-uk.com

#### **CZECH, SLOVAKIA, HUNGARY**

OSG Europe Logistics S.A.  
Slovakia organizacna zlozka  
Racianská 22/A, SK-83102 Bratislava  
Slovakia  
Tel. +421 24 32 91 295  
Orders-osgsvk@osgeurope.com

#### **OSG POLAND Sp. z o.o.**

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  
Singelgatan 7  
212 28 Malmö - Sweden  
Tel: +46 40 41 22 55  
osg@osg-scandinavia.com

#### **OSG IBERICA**

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

#### **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  
25C, Bucuresti-Magurele Street  
051431 Bucuresti - România  
Tel: +40 21 322 07 47  
Fax: +40 21 321 56 00  
romsan.int@romsan.ro

#### **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 ITALIA**

Via Ferrero, 65 A/B3  
I - 10098 Rivoli - Italy  
Tel: +39 0117705211  
Fax: +39 0117705215  
info@osg-italia.it

#### **Vischer & Bolli AG**

Machining and Workholding  
Im Schossacher 17  
CH-8600 Dübendorf  
T +41 44 802 15 15  
F +41 44 802 15 95  
info@vb-tools.com

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