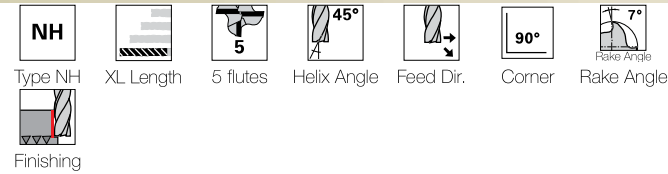


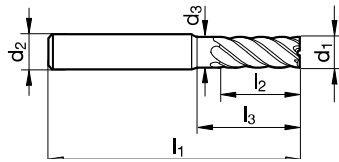
RF 100 SF 90° - Metric diameters



Tool material	Solid Carbide
Surface	nano-A
Type	RF 100 SF 90°
Shank design	HA

P	•
M	•
K	•
N	•
S	•
H	

center cutting · without corner protection chamfer



Metric diameter end mills are stocked in Germany



Guhring Series

6763

d1 h10 mm	d2 h6 mm	d3 mm	l1 mm	l2 mm	l3 mm	Code no.	EDP Number
4.000	6.00	3.80	65	12	26	4.000	9067630040000
5.000	6.00	4.80	65	15	26	5.000	9067630050000
6.000	6.00	5.70	65	18	28	6.000	9067630060000
8.000	8.00	7.70	75	24	32	8.000	9067630080000
10.000	10.00	9.50	80	30	32	10.000	9067630100000
12.000	12.00	11.50	93	36	46	12.000	9067630120000
16.000	16.00	15.50	108	48	58	16.000	9067630160000
20.000	20.00	19.50	126	60	74	20.000	9067630200000

Feeds and Speeds -- Maximum recommended depth of cut (a_p) = 2 x d

	Material	Hardness	Maximum Recommended Width of Cut a_e	Cutting Speed SFM	Feed Rate - IPT per Ø						
					3mm	6mm	8mm	10mm	12mm	16mm	20mm
P	Steels: Structural, free-cutting, unalloyed heat-treatable, case hardened	up to 28 HRc	0.3 x d	920	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037
	Steels: Alloyed heat-treatable, tool steels, high speed steels	28 to 44 HRc	0.2 x d	720	0.0006	0.001	0.0014	0.0018	0.002	0.0026	0.0031
M	Stainless Steel: Easy to machine / sulphured	up to 22 HRc	0.2 x d	590	0.0006	0.001	0.0014	0.0018	0.002	0.0026	0.0031
	Stainless Steel: Moderately difficult to machine	over 22 HRc	0.2 x d	395	0.0006	0.001	0.0014	0.0018	0.002	0.0026	0.0031
K	Cast iron, grey cast iron, spheroidal graphite and malleable cast iron	over 240 HB 30	0.2 x d	655	0.0007	0.0014	0.0018	0.002	0.0026	0.0031	0.0047
N	Aluminium-cast alloys	up to 7% Si	0.2 x d	3280	0.0007	0.0014	0.0018	0.002	0.0026	0.0031	0.0047
S	High-Temperature Alloys	up to 40 HRc	0.15 x d	150	0.0004	0.0008	0.0012	0.0014	0.0016	0.0022	0.0026
	Nimonic, Inconel, Monel, Hastelloy	up to 40 HRc	0.15 x d	425	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037

"Gührojet" peripheral cooling is recommended for optimal cooling and tool life.