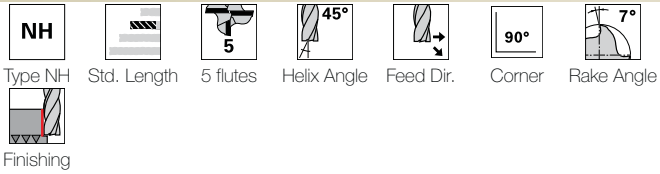
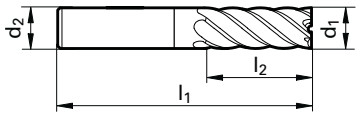
RF 100 SF 90° - Inch diameters



P	•
M	•
K	•
N	•
S	•
H	

center cutting · without corner protection chamfer



Tool material	Solid Carbide
Surface	nano-A (a)
Type	RF 100 SF 90°
Shank design	HA / HB

Guhring Series 6776

d1 h10 inch	d2 h6 inch	l1 inch	l2 inch	Code no.	EDP Number
3/16	3/16	2	5/8	4.760	9067760047600
1/4	1/4	2 1/2	3/4	6.350	9067760063500
5/16	5/16	2 1/2	13/16	7.940	9067760079400
3/8	3/8	2 1/2	1	9.520	9067760095200
1/2	1/2	3 1/2	1 1/4	12.700	9067760127000
5/8	5/8	3 1/2	1 1/4	15.870	9067760158700
3/4	3/4	4	1 1/2	19.050	9067760190500

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 1/8	1/4	5/16	3/8	1/2	5/8	3/4
P	Steels: Structural, free-cutting, unalloyed heat-treatable, case hardened	up to 28 HRc	0.3 x d	920	.0007	.0013	.0016	.0021	.0027	.0031	.0036
P	Steels: Alloyed heat-treatable, tool steels, high speed steels	28 to 44 HRc	0.2 x d	720	.0006	.0010	.0014	.0017	.0021	.0025	.0030
M	Stainless Steel: Easy to machine / sulphured	up to 22 HRc	0.2 x d	590	.0006	.0010	.0014	.0017	.0021	.0025	.0030
M	Stainless Steel: Moderately difficult to machine	over 22 HRc	0.2 x d	395	.0006	.0010	.0014	.0017	.0021	.0025	.0030
K	Cast iron, grey cast iron, spheroidal graphite and malleable cast iron	over 240 HB 30	0.2 x d	655	.0008	.0015	.0018	.0019	.0027	.0031	.0045
N	Aluminium-cast alloys	up to 7% Si	0.2 x d	3280	.0008	.0015	.0018	.0019	.0027	.0031	.0045
S	High-Temperature Alloys Nimonic, Inconel, Monel, Hastelloy	up to 40 HRc	0.15 x d	150	.0006	.0010	.0014	.0017	.0021	.0025	.0030
S	Titanium alloys	up to 40 HRc	0.15 x d	425	.0007	.0013	.0016	.0021	.0027	.0031	.0036

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