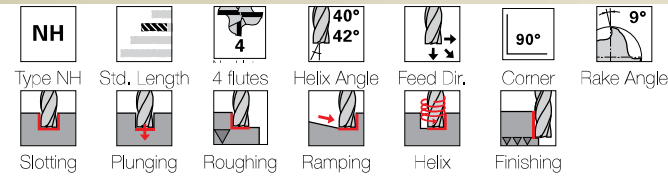
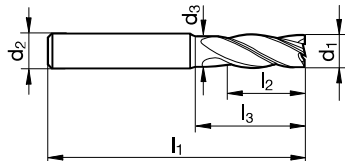


RF 100 F 90° - Metric diameters



P	•
M	•
K	
N	
S	•
H	

center cutting · without corner protection chamfer



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



Metric diameter end mills are stocked in Germany

Guhring Series

6764

d1 h10 mm	d2 h6 mm	d3 mm	l1 mm	l2 mm	l3 mm	Code no.	EDP Number
3.00	6.00	2.80	57	8	15	3.000	9067640030000
4.00	6.00	3.80	57	11	18	4.000	9067640040000
5.00	6.00	4.80	57	13	18	5.000	9067640050000
6.00	6.00	5.70	57	13	20	6.000	9067640060000
8.00	8.00	7.70	63	19	26	8.000	9067640080000
10.00	10.00	9.50	72	22	30	10.000	9067640100000
12.00	12.00	11.50	83	26	36	12.000	9067640120000
16.00	16.00	15.50	92	32	42	16.000	9067640160000
20.00	20.00	19.50	104	38	52	20.000	9067640200000

Feeds and Speeds -- Slotting = up to 1xd; Roughing = 0.4 up to 0.9 x d; Finishing = 0.01 up to 0.1 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	Slotting	590	0.0007	0.0014	0.0018	0.0024	0.0028	0.0035	0.0039
		Roughing	655	0.0008	0.0016	0.0022	0.0028	0.0335	0.0039	0.0047
		Finishing	920	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037
P Steels: Alloyed heat-treatable, tool steels, high speed steels	28 to 44 HRc	Slotting	445	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037
		Roughing	525	0.0008	0.0016	0.0020	0.0026	0.0031	0.0037	0.0043
		Finishing	655	0.0006	0.0012	0.0016	0.0020	0.0024	0.0028	0.0035
M Stainless Steel: Easy to machine / sulphured	up to 22 HRc	Slotting	395	0.0006	0.0012	0.0016	0.0020	0.0024	0.0028	0.0035
		Roughing	460	0.0007	0.0014	0.0018	0.0024	0.0028	0.0035	0.0039
		Finishing	590	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037
M Stainless Steel: Moderately difficult to machine	over 22 HRc	Slotting	230	0.0005	0.0010	0.0012	0.0016	0.0018	0.0024	0.0028
		Roughing	330	0.0006	0.0010	0.0014	0.0018	0.0020	0.0026	0.0031
		Finishing	395	0.0006	0.0010	0.0014	0.0018	0.0020	0.0026	0.0031
S High-Temperature Alloys Nimonic, Inconel, Monel, Hastelloy	up to 40 HRc	Slotting	100	0.0004	0.0006	0.0008	0.0010	0.0012	0.0016	0.0020
		Roughing	115	0.0004	0.0008	0.0012	0.0014	0.0016	0.0022	0.0026
		Finishing	150	0.0006	0.0010	0.0014	0.0018	0.0020	0.0026	0.0031
S Titanium alloys	up to 40 HRc	Slotting	195	0.0006	0.0010	0.0014	0.0018	0.0020	0.0026	0.0031
		Roughing	295	0.0006	0.0012	0.0016	0.0022	0.0026	0.0031	0.0037
		Finishing	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.

For high speed milling up to 2 x d deep, multiply slotting values by the below chip thinning factors:

Width of Cut	SFM factor	IPT factor
.25 x d	SFM x 1,6	IPT x 1,5
.1 x d	SFM x 1,8	IPT x 2,3
.05 x d	SFM x 1,9	IPT x 3,3