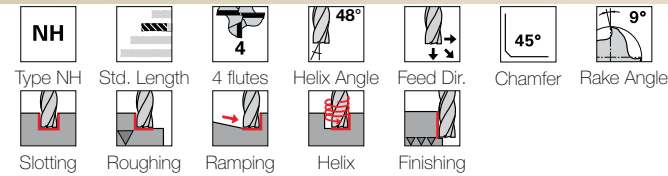
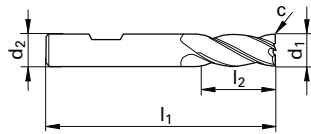


RF 100 Speed - Inch, standard length



P	•	center cutting
M	•	
K		
N		
S	•	
H		



Tool material	Solid Carbide	
Surface	nano-A a	
Type	RF 100 Speed	
Shank design	HA	HB



Series no. **6773** **6773**

d1 h10	d2 h6	l1	l2	c	Code no.	EDP Number
inch	inch	inch	inch	inch x 45°		
1/8	1/8	1 1/2	3/8	0.002	3.170	9067730031700
3/16	3/16	2	5/8	0.002	4.760	9067730047600
1/4	1/4	2 1/2	3/4	0.004	6.350	9067730063500
5/16	5/16	2 1/2	13/16	0.005	7.940	9067730079400
3/8	3/8	2 1/2	1	0.006	9.520	9067730095200
1/2	1/2	3 1/2	1 1/4	0.007	12.700	9067730127000
5/8	5/8	3 1/2	1 1/4	0.009	15.870	9067730158700
3/4	3/4	4	1 1/2	0.012	19.050	9067730190500

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

	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	0.0006	0.0017	0.0020	0.0023	0.0029	0.0039	0.0045
	Steels: Alloyed heat-treatable, tool steels, high speed steels	28 to 44 HRc	0.25 x d	590	0.0006	0.0013	0.0020	0.0023	0.0029	0.0039	0.0038
M	Stainless Steel: Easy to machine / sulphured	up to 22 HRc	0.2 x d	490	0.0006	0.0013	0.0016	0.0019	0.0025	0.0027	0.0034
	Stainless Steel: Moderately difficult to machine	over 22 HRc	0.15 x d	330	0.0006	0.0013	0.0016	0.0019	0.0025	0.0027	0.0034
S	High-Temperature Alloys Nimonic, Inconel, Monel, Hastelloy	up to 40 HRc	0.1 x d	115	0.0004	0.0006	0.0010	0.0013	0.0018	0.0020	0.0030
	Titanium alloys	up to 40 HRc	0.15 x d	425	0.0007	0.0010	0.0014	0.0019	0.0025	0.0031	0.0038

"Gührojet" peripheral cooling is recommended for optimal cooling and tool life. *Slotting and roughing cuts greater than the maximum recommended can be taken with the standard length RF 100 Speed up to .8 x d deep, however, the SFM and IPT must be reduced by 30%.