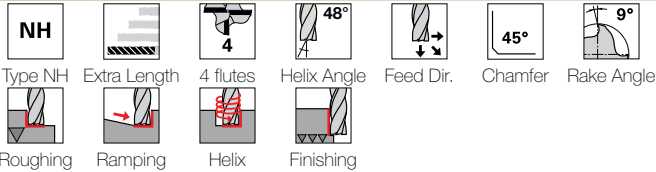
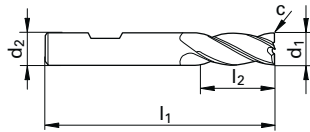


RF 100 Speed - Inch, extra length



P	•
M	•
K	
N	
S	•
H	

with chip breaker · center cutting



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



Series no. 6774 6774

d1 h10	d2 h6	l1	l2	c	Code no.	EDP Number
inch	inch	inch	inch	inch x 45°		
3/16	3/16	2 1/2	3/4	0.002	4.760	9067740047600
1/4	1/4	3	1	0.002	6.350	9067740063500
5/16	5/16	3	1 1/4	0.004	7.940	9067740079400
3/8	3/8	3 1/2	1 1/2	0.005	9.520	9067740095200
1/2	1/2	4 1/2	2	0.006	12.700	9067740127000
5/8	5/8	5	2 1/4	0.007	15.870	9067740158700
3/4	3/4	5	2 1/2	0.009	19.050	9067740190500

Feeds and Speeds -- Maximum recommended depth of cut (a_p) = 3 x d

	Hardness	Maximum Recommended Width of Cut a_p	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	0.2 x d	920	.0006	.0017	.0020	.0023	.0029	.0039	.0045
	Steels: Alloyed heat-treatable, tool steels, high speed steels	28 to 44 HRc	0.15 x d	590	.0006	.0013	.0020	.0023	.0029	.0039	.0038
M	Stainless Steel: Easy to machine / sulphured	up to 22 HRc	0.15 x d	490	.0006	.0013	.0016	.0019	.0025	.0027	.0034
	Stainless Steel: Moderately difficult to machine	over 22 HRc	0.1 x d	330	.0006	.0013	.0016	.0019	.0025	.0027	.0034
S	High-Temperature Alloys Nimonic, Inconel, Monel, Hastelloy	up to 40 HRc	0.05 x d	115	.0004	.0006	.0010	.0013	.0018	.0020	.0030
	Titanium alloys	up to 40 HRc	0.1 x d	425	.0007	.0010	.0014	.0019	.0025	.0031	.0038

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