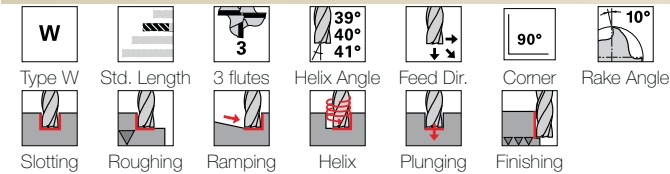
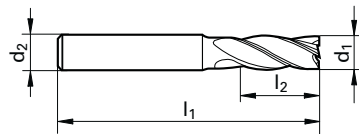


RF 100 A 90° - Inch diameters

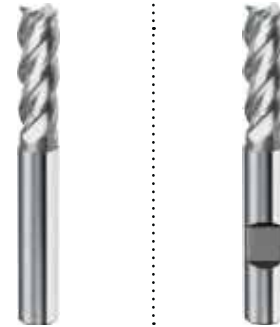


P	
M	
K	
N	•
S	
H	

center cutting · without corner protection chamfer



Tool material	Solid Carbide
Surface	Bright ○
Type	RF 100 A 90°
Shank design	HA HB



Guhring Series

6775

d1 h10	d2 h6	l1	l2	Code no.	EDP Number
inch	inch	inch	inch		
1/8	1/8	2	1/2	3.170	9067750031700
3/16	3/16	2	5/8	4.760	9067750047600
1/4	1/4	2 1/2	3/4	6.350	9067750063500
5/16	5/16	2 1/2	13/16	7.940	9067750079400
3/8	3/8	2 1/2	1	9.520	9067750095200
1/2	1/2	3 1/2	1 1/4	12.700	9067750127000
5/8	5/8	3 1/2	1 1/4	15.870	9067750158700
3/4	3/4	4	1 1/2	19.050	9067750190500

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						
				1/8	1/4	5/16	3/8	1/2	5/8	3/4
N Aluminum, Al-wrought alloys, Al-alloys 2024, 6061, 7075, 1050, 6351, 5005, 2017, 7075	up to 3% Si	Slotting	1640	.0008	.0017	.0020	.0024	.0033	.0037	.0041
		Roughing	1970	.0008	.0017	.0021	.0026	.0035	.0039	.0045
		Finishing	3280	.0008	.0015	.0018	.0023	.0029	.0035	.0038
Aluminium-cast alloys 3.2131 G-AISI5Cu1, 3.2153 G-AISI7Cu3, 3.2573 G-AISI9, 3.2581 G-AISI12, 3.2583 G-AISI12Cu, - G-AISI12CuNiMg	up to 7% Si	Slotting	755	.0007	.0013	.0016	.0021	.0027	.0031	.0036
		Finishing	1150	.0008	.0015	.0018	.0023	.0029	.0035	.0038

“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