

# QUICK-FINDER - RF 100 Variable Helix end mill selection guide

Application			Slot drilling  1 x d	Roughing  0.3-0.8 x d	Finishing  > 0.1 x d	Super finishing  0.1 x d
Material/ Application group	Hardness tensile strength	Example material	Rigid conditions:  - good cooling - sufficient performance - short-chipping	Unstable conditions:  - standard cooling - average performance - medium- to long-chipping	Finishing: 	
Steel 	up to 28 HRc	1045 / 5115	RF 100 F Series #3078 <b>Page 39</b>	RF 100 VA/NF Series #3081 <b>Page 47</b>	RF 100 S/F Series #3115 <b>Page 63</b>	
	above 28 HRc	4140	RF 100 U Series #3114 <b>Page 27</b>	RF 100 U/HF Series #3082 <b>Page 34</b>		
Stainless steel 	up to 28 HRc	304 / 303	RF 100 VA Series #3080 <b>Page 41</b>	RF 100 VA/NF Series #3081 <b>Page 47</b>		
	above 28 HRc	316Ti	RF 100 F Series #3078 <b>Page 39</b>	RF 100 VA/NF Series #3081 <b>Page 47</b>		
Cast iron 	up to 180 HB 30	Gray Cast	RF 100 F Series #3078 <b>Page 39</b>	RF 100 U/HF Series #3082 <b>Page 34</b>		
	above 180 HB 30	GGG / GGT / GGv ductile	RF 100 U Series #3114 <b>Page 27</b>	RF 100 U/HF Series #3082 <b>Page 34</b>		
Aluminium 	up to 3% Si	Wrought Alloys	RF 100 A Series #4265 <b>Page 54</b>	RF 100 A/WF Series #4266 <b>Page 51</b>	RF 100 A Series #3077 <b>Page 53</b>	
	above 3% Si	Cast Alloys	RF 100 F Series #4265 <b>Page 54</b>	RF 100 A/WF Series #4266 <b>Page 51</b>	RF 100 F Series #3078 <b>Page 39</b>	
Ti- special alloys 	Ti-basis	TiAl6V4 Inconel 625	RF 100Ti Series #3876 <b>Page 57</b>	RF 100 U/HF Series #3082 <b>Page 34</b>	RF 100 S/F Series #3115 <b>Page 63</b>	
	Ni-basis	Inconel 728	RF 100 F Series #3078 <b>Page 39</b>	RF 100 VA/NF Series #3081 <b>Page 47</b>		
Hardened steel <b>H</b>	up to 52 HRC	H11	RF 100 U Series #3114 <b>Page 27</b>	RF 100 U/HF Series #3082 <b>Page 34</b>		
	above 52 HRC	D2	RF 100 H Series #3896 <b>Page 65</b>	—	RF 100 H Series #3895 <b>Page 65</b>	