

RF 100 U - high-performance 3-flute end mills for materials up to 44 HRC



RF 100 U end mills excel thanks to unequal helix angles which considerably reduce vibration. The uneven helix angle vastly improves surface quality for finishing operations and a considerably higher feed rate for slot milling operations are also achieved. The three flute design provides additional flute space for improved chip evacuation in slot milling operations or in materials which may clog a standard four flute design.

With many applications, the complete milling process can be covered with one RF 100 U, which as well as increasing tool life and dimensional accuracy of the workpiece generates a considerable cost advantage.

Summary of advantages

- suitable for roughing and finishing
- up to 60% higher feed rates
- up to 4-times longer tool life
- vibration-free operation
- improved workpiece surface quality

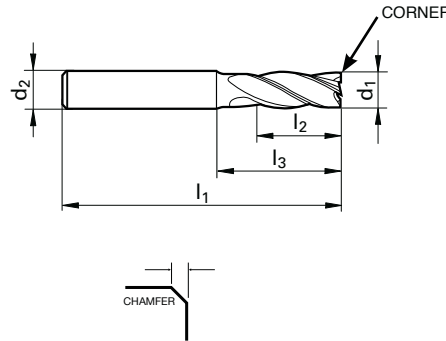
FRACTIONAL

RF 100 U 3-Flute

Variable helix, FIREX® coated

Includes Series	
INCH	
	4254
	4255

TYPE	N
HELIX ANGLE	41° 43° 45°
NUMBER of TEETH	3



d₁ tolerance h10
d₂ tolerance h6
See table on page 150

Diameter	Shank Diameter	OAL	LOC	Reach	Corner	HA		HB	
(d1) Frac	(d2) Frac	(l1) Frac	(l2) Frac	*(l3) Frac	Chamfer Inch	EDP No.	Series Number	EDP No.	Series Number
1/8	1/8	2	1/4	3/4	0.002	9042550031700	4255		
1/8	1/8	2	1/2		0.002	9042540031700	4254		
3/16	3/16	2	3/8	3/4	0.002	9042550047600	4255		
3/16	3/16	2	5/8		0.002	9042540047600	4254		
1/4	1/4	2 1/2	1/2	7/8	0.004	9042550063500	4255		
1/4	1/4	2 1/2	3/4		0.004	9042540063500	4254		
5/16	5/16	2 1/2	1/2	7/8	0.004	9042550079400	4255		
5/16	5/16	2 1/2	13/16		0.004	9042540079400	4254		
3/8	3/8	2 1/2	5/8	7/8	0.004	9042550095200	4255		
3/8	3/8	2 1/2	1		0.004	9042540095200	4254		
7/16	7/16	2 3/4	1		0.006	9042540111100	4254		
1/2	1/2	3	5/8	1 1/8	0.006			9042550127000	4255
1/2	1/2	3 1/2	1 1/4		0.006			9042540127000	4254
5/8	5/8	3 1/2	3/4	1 1/2	0.006			9042550158700	4255
5/8	5/8	3 1/2	1 1/4		0.006			9042540158700	4254
3/4	3/4	4	1	1 3/4	0.006			9042550190500	4255
3/4	3/4	4	1 1/2		0.006			9042540190500	4254
1	1	4	1	1 3/4	0.008			9042550254000	4255
1	1	4	1 1/2		0.008			9042540254000	4254