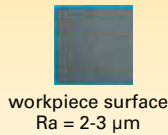
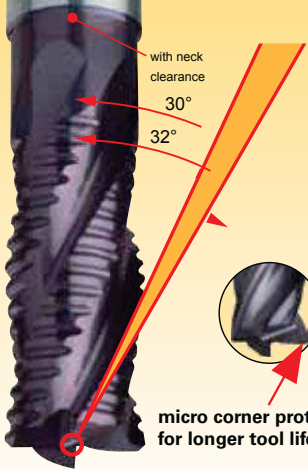


RF 100 U/HF - high-performance roughing end mills for materials up to 1600 N/mm² (48 HRC)

Based on our RF 100 end mill with variable helix angles in combination with a newly developed roughing geometry. The result is a dramatic increase in tool life in comparison to conventional rough milling cutters with round or flat knuckle-type teeth. At the same time, the surface quality of the workpiece is improved to a peak-to-valley height of appr. Ra = 2-3 µm, making in many cases finishing operations unnecessary.

Simultaneously, the innovative design reduces power consumption in comparison to conventional RF 100 end mills allowing the application in unstable conditions and on less powerful machines.

- Summary of advantages
- low cutting pressure and power consumption
 - vibration-free operation
 - increased feed rates possible
 - increased surface qualities (R_s = 2-3 µm)
 - longer tool life



Type	RF 100 U smooth cutting	RF 100 U/HF
Performance index	100%	70%
Workpiece surface	R _s = 1-2 µm 	R _s = 2-3 µm
Tool life index	100%	75%
Power consumption	160%	100%
Cutting pressure	150%	100%

FRACTIONAL

RF 100 U/HF 4-Flute

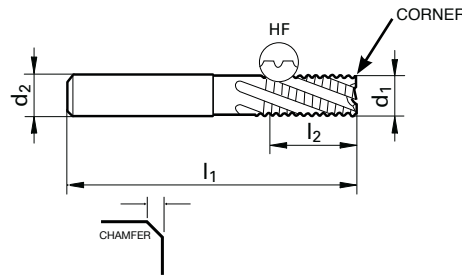
Variable helix, Rougher, FIREX[®] coated

Includes Series
INCH
3082
4256

TYPE **HF**

HELIX ANGLE **30°**
32°

NUMBER of TEETH **4**



d₁ tolerance h10
d₂ tolerance h6
See table on page 150

Diameter	Shank Diameter	OAL	LOC	Corner	HA		HB	
(d1) Frac	(d2) Frac	(l1) Frac	(l2) Frac	Chamfer Inch	EDP No.	Series Number	EDP No.	Series Number
1/4	1/4	2 1/2	3/4	0.012	9030820063500	3082		
1/4	1/4	3 1/4	1 1/4	0.012	9042560063500	4256		
5/16	5/16	2 1/2	13/16	0.012	9030820079400	3082		
5/16	5/16	3 1/4	1 1/2	0.012	9042560079400	4256		
3/8	3/8	2 1/2	1	0.012	9030820095200	3082		
3/8	3/8	4	1 3/4	0.012	9042560095200	4256		
1/2	1/2	3 1/2	1 1/4	0.020			9030820127000	3082
1/2	1/2	4 1/2	2	0.020			9042560127000	4256
5/8	5/8	3 1/2	1 1/4	0.020			9030820158700	3082
5/8	5/8	5	2 1/4	0.020			9042560158700	4256
3/4	3/4	4	1 1/2	0.020			9030820190500	3082
3/4	3/4	5	2 1/4	0.020			9042560190500	4256
1	1	4	1 1/2	0.031			9030820254000	3082
1	1	5	2 1/4	0.031			9042560254000	4256