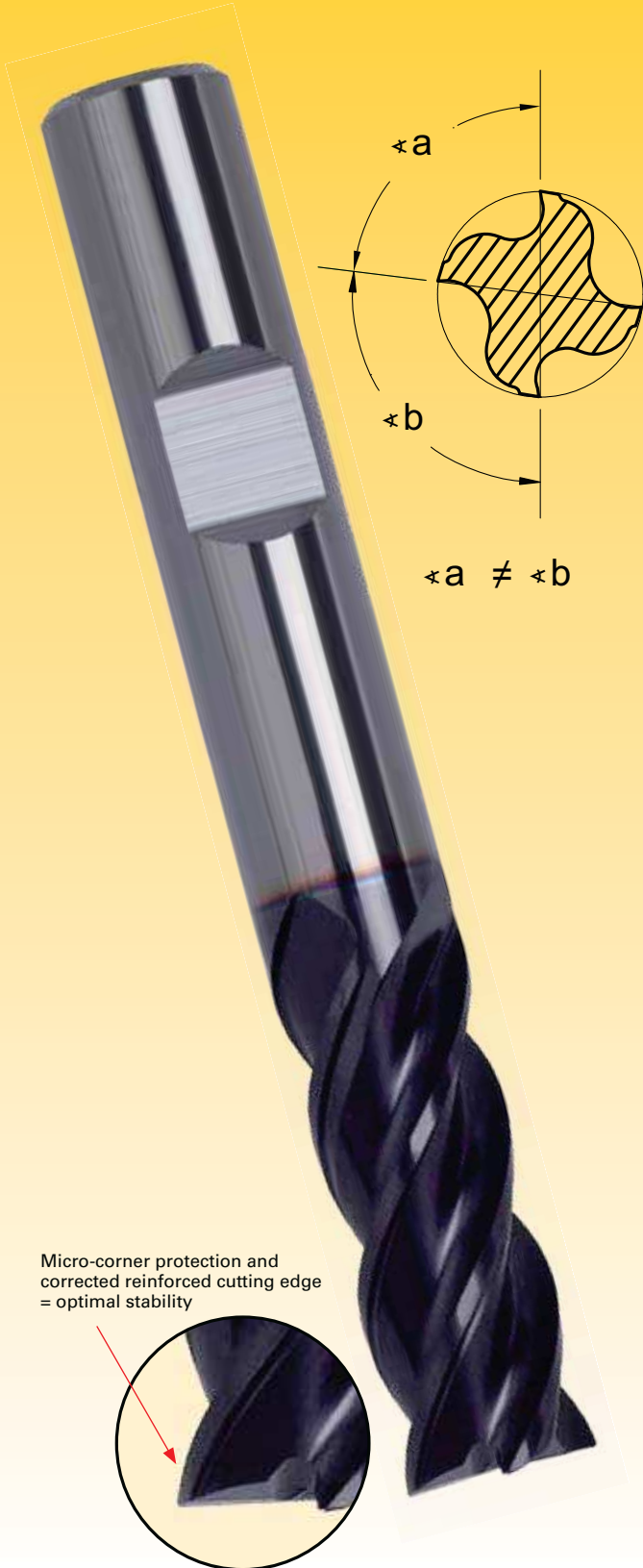


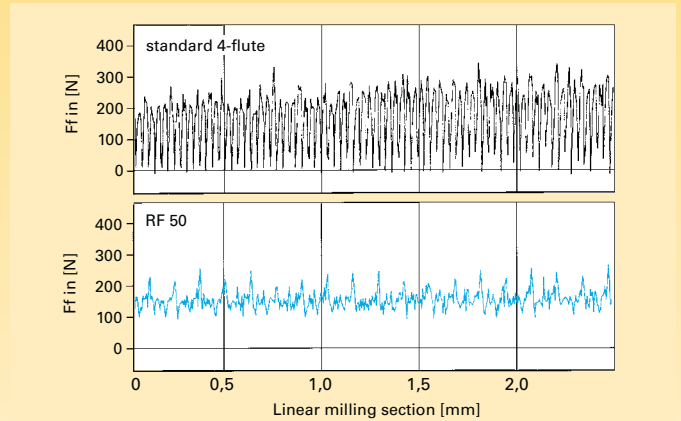
# Guhring RF 50 variable flute end mills for materials < 54 HRC



We have developed the RF 50 end mill with variable flute spacing primarily to prevent chatter and the so-called corkscrew effect (as found when withdrawing tools having a large spiral angle)

However, the variable flute spacing does not only combat these two unwanted effects but offers the following additional advantages:

- Higher feed rates
- longer tool life
- increased milling depths
- vibration-free machining
- suitable for roughing and finishing
- increased surface finish quality
- straighter cutting



A cutting force comparison between a conventional type N and a RF 50 variable helix end mill clearly shows the RF 50 end mill's quieter and more stable machining characteristics.

Material	Alloyed Steel	Tool Steel	Cast iron	Stainless steel	Aluminium	Ti-special alloys	H
Hardness tensile strength	up to 28Hrc	over 28 HRC	up to 180 HB 30 over 180 HB 30	up to 28 HRC over 28 HRC	up to 3% Si over 3% Si	Ti-based Ni-based	up to 52 HRC up to 52 HRC
RF 100 U	○	●	●			●	○

● = optimal suitability      ○ = limited suitability