

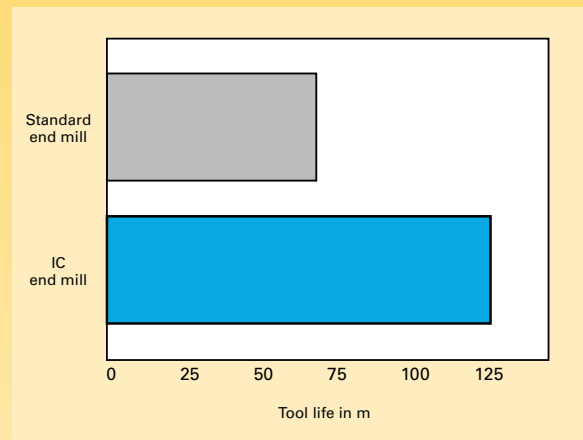
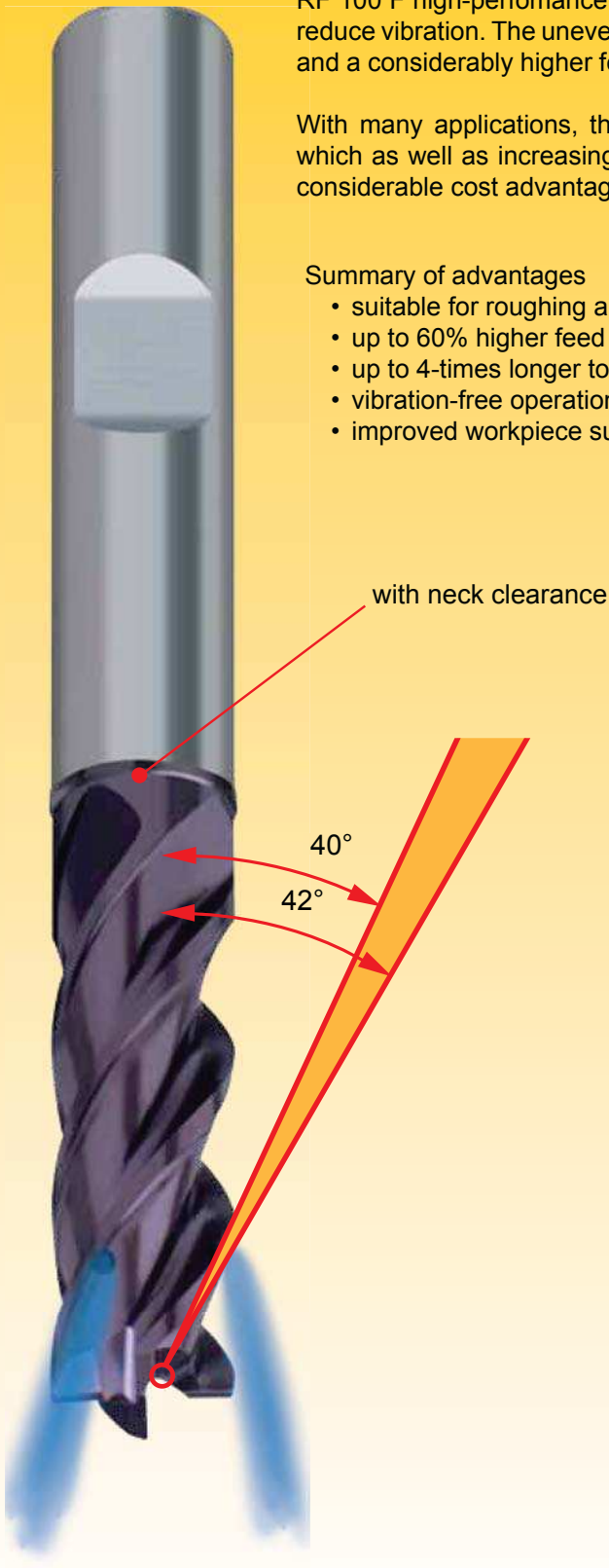
RF 100 F - high-performance roughing end mills for materials up to 850 N/mm² (25 HRC)

RF 100 F high-performance end mills excel thanks to variable 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 drilling and roughing operations are also achieved.

With many applications, the complete milling process can be covered with one RF 100 F. 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



Tool life comparison between end mills with internal cooling and conventional end mills without internal cooling with roughing operations in tool steel.

Material	Alloyed Steel		Tool Steel		Cast iron		Stainless steel		Aluminium		Ti-special alloys		H	
	up to 28Hrc	over 28Hrc	up to 180 HB 30	over 180 HB 30	up to 28Hrc	over 28Hrc	up to 3% Si	over 3% Si	Ti-based	Ni-based	up to 52 HRC	above 52 HRC		
RF 100 U	○	●	●	●						●		○		
RF 100 U/HF	○	●	●	●						○		○		
RF 100 F	●	○	○		○	●		○	○	●				
RF 100 VA	●	○	○	○	●	●		○	●	○				
RF 100 VA/NF	●	○	○	○	●	●			●	○				
RF 100 A									●	●				
RF 100 AWF									●	●				
RF 100 Ti	○	●	○	○						●	○	○		
RF 100 H		○		○									●	●
RF 100 SF	●	●	●	●	●	●	○	○	●	●	○			

● = optimal suitability

○ = limited suitability