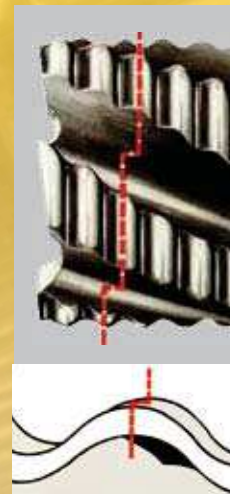


ROUGH-TECH 56 GS 100 H roughing cutters for materials < 54 HRC



GS 100 roughing cutters excel primarily thanks to their general purpose application possibilities enabling almost any combination of cutting depth (DOC) and cutting width (WOC). In comparison to roughing/finishing cutters with a flat knuckle-type geometry, the considerably lower power requirement ensures a reliable and economical machining process especially with less powerful machines.



GS 100 H: special geometry for materials < 54 HRC:

- GS 100 H excels in the machining of difficult-to-machine materials over 1000 N/mm², cast iron and grey cast iron as well as hardened materials up to approximately 52 to 54 HRC thanks to its 20° helix and its small rake angle.

Advantages at a glance:

- reduced power requirement and cutting pressure
- suitable for less powerful and less stable machines
- suitable for less favorable workpiece and tool clamping conditions
- high metal removal rate thanks to the utilisation of the complete cutting edge length

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	over 52 HRC
Rough-Tech 48	●	●	●	○	●	○	○	○	○	○		
Rough-Tech 56	○	●	●	●					○	●	●	○

● = optimal suitability

○ = limited suitability