

GUHRING



Ratio®

- For HSC finishing up to 4xD cutting edge length
- HPC roughing and finishing up to 48 HRC
- High running smoothness and low cutting pressure

RF 100 U extra length

GUHRING - YOUR WORLD-WIDE PARTNER

RF 100 U extra length



Field of application

- for HPC roughing with 0.05-0.15xD
- for HPC finishing with 4xD cutting edge length
- for finishing in steel, cast iron and high-tensile materials
- universal for all materials up to 1600 N/mm² (48 HRC)

high running smoothness

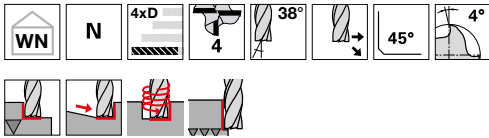
thanks to **38° helix** and **unequal orientation** of cutting edges

optimal surface quality
with **fine-finishing operations**

high accuracy and
reduced cutting pressure
as a multipurpose cutter

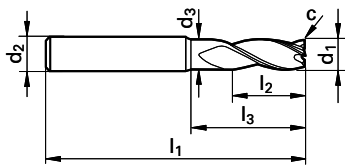


Standard Ratio end mill RF 100 U extra length 4xD



P	•
M	
K	•
N	
S	
H	

Tool material	Solid carbide	
Surface finish		
Type	RF 100 U	RF 100 U
Shank form	HA	HB
Discount group	106	106



Gühring no. **6767** **6768**

Code no.	d1 h10	d2 h6	d3	l1	l2	l3	c	Z	Availability	
	mm	mm	mm	mm	mm	mm	mm			
6.000	6.00	6.00	5.70	65	24	29	0.12	4	•	•
8.000	8.00	8.00	7.70	75	32	39	0.16	4	•	•
10.000	10.00	10.00	9.50	100	40	60	0.20	4	•	•
12.000	12.00	12.00	11.50	100	48	55	0.24	4	•	•
16.000	16.00	16.00	15.50	125	64	77	0.32	4	•	•
20.000	20.00	20.00	19.50	150	80	100	0.40	4	•	•
25.000	25.00	25.00	24.00	175	100	119	0.50	4	•	•

	Hardness	Cutting depth a_p	Cutting width a_e	Cutting speed v_c	f_z (mm/z) with nom. Ø							
					3	6	8	10	12	16	20	25
P	≤ 850 N/mm ²	2-4xd	0.05-0.15xd	160	0.015	0.025	0.035	0.045	0.05	0.065	0.08	0.12
	850 - 1400 N/mm ²	2-4xd	0.05-0.15xd	130	0.015	0.025	0.035	0.045	0.05	0.065	0.08	0.12
K	≥ 240 HB 30	2-4xd	0.05-0.15xd	140	0.015	0.025	0.035	0.045	0.05	0.065	0.08	0.12

"Gührojet" peripheral cooling is recommended for optimal cooling and tool life.

DRILLING

TAPPING/THREAD MILLING/
FLUTELESS TAPPING

MILLING

REAMING

PCD



SPECIAL SOLUTIONS COUNTERSINKING

MODULAR SYSTEMS

SERVICES

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