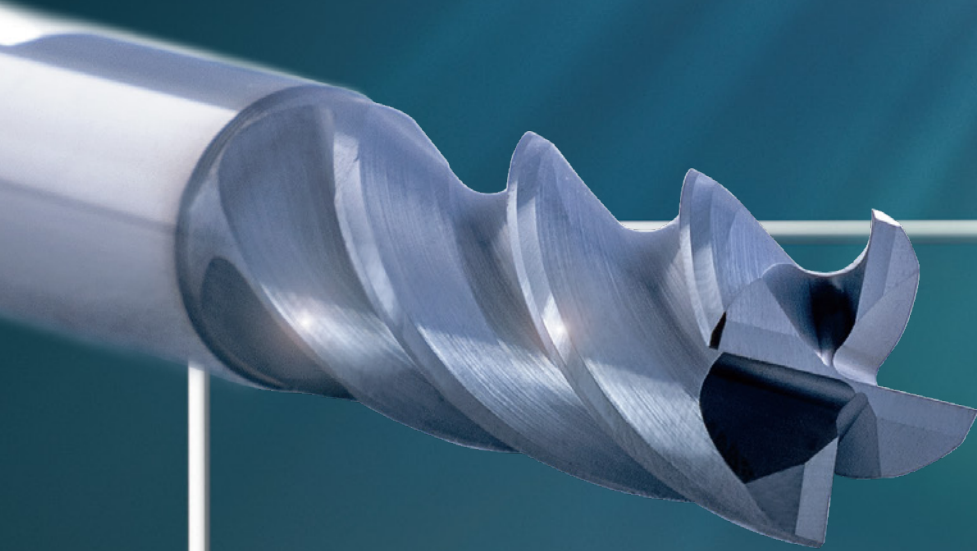


GÜHRING

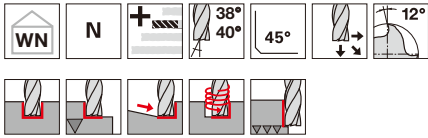
德國鈷領 RF 100 Sharp 銑刀



The new solid carbide milling cutter.

RF100
SHARP

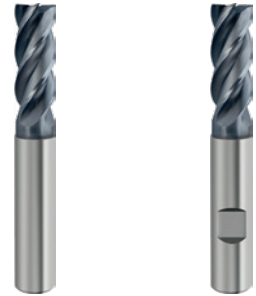
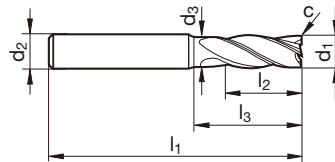
Ratio end mills RF 100 Sharp



材質	Solid carbide	
鍍層	P	P
Type	N	N
柄部形式	HA	HB

P ● **GÜHRING NAVIGATOR**

- M** ● especially for soft, tough and high-alloyed materials
- K** ● longer cutting edge than DIN 6527 L
- N** ● neck clearance
- S** ● centre cutting
- H** ● 特別適用於軟、堅韌和高合金材料
- 中長型切削刃
- 縮頸設計
- 端面底面過中心

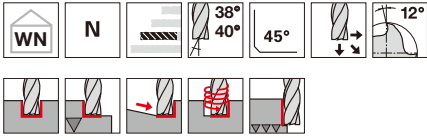


編號： 6478 6479

d1 e8	d2 h6	d3	l1	l2	l3	c	Z	Code no.	價格	
mm	mm	mm	mm	mm	mm	mm x 45°				
1.000	4.000	0.920	50.000	3.000	4.000	0.020	4	1.000	970	
1.500	4.000	1.400	50.000	4.500	6.000	0.030	4	1.500	970	
2.000	6.000	1.900	50.000	6.000	8.000	0.040	4	2.000	1,030	
2.500	6.000	2.400	50.000	7.500	10.000	0.050	4	2.500	1,030	
3.000	6.000	2.900	57.000	10.000	15.000	0.060	4	3.000	1,070	
4.000	6.000	3.800	57.000	14.000	18.000	0.080	4	4.000	1,070	1,150
5.000	6.000	4.800	57.000	15.000	20.000	0.100	4	5.000	1,070	1,150
6.000	6.000	5.700	57.000	16.000	20.000	0.120	4	6.000	1,070	1,150
8.000	8.000	7.700	63.000	21.000	26.000	0.160	4	8.000	1,460	1,570
10.000	10.000	9.500	72.000	25.000	31.000	0.200	4	10.000	2,200	2,400
12.000	12.000	11.500	83.000	28.000	37.000	0.240	4	12.000	2,850	3,020
14.000	14.000	13.500	83.000	28.000	37.000	0.280	4	14.000	3,800	3,990
16.000	16.000	15.500	92.000	36.000	43.000	0.320	4	16.000	4,900	5,200
20.000	20.000	19.500	104.000	41.000	53.000	0.400	4	20.000	7,500	7,950

ISO 材料	Hardness 抗拉強度	Vc 切速	fz (mm/z)/Ø 每刃進給 / 刃徑										Vc 切速	fz (mm/z)/Ø 每刃進給 / 刃徑														
			ap = 1.0xD 切深					ae = 1.0xD 切寬						ap = 1.0xD 切深					ae max = 0.6xD 最大切寬									
			1	3	6	8	10	12	16	20	1	3		6	8	10	12	16	20	1	3	6	8	10	12	16	20	
P	< 500 N/mm ²	180	0.010	0.016	0.030	0.042	0.06	0.072	0.1	0.12	210	0.011	0.018	0.036	0.048	0.069	0.08	0.11	0.14	160	0.009	0.016	0.031	0.041	0.058	0.07	0.09	0.12
	500-900 N/mm ²	140	0.008	0.014	0.027	0.036	0.05	0.06	0.08	0.1	100	0.007	0.016	0.031	0.041	0.058	0.07	0.09	0.12	60	0.005	0.010	0.020	0.027	0.038	0.05	0.06	0.085
M	< 500 N/mm ²	120	0.006	0.012	0.025	0.032	0.045	0.055	0.075	0.085	140	0.007	0.016	0.031	0.041	0.058	0.07	0.09	0.12	100	0.006	0.013	0.025	0.034	0.048	0.06	0.08	0.1
	500-900 N/mm ²	80	0.005	0.010	0.021	0.028	0.04	0.048	0.06	0.07	60	0.005	0.010	0.020	0.027	0.038	0.05	0.06	0.085	600	0.013	0.022	0.045	0.06	0.09	0.012	0.15	0.18
S	< 900 N/mm ²	45	0.004	0.008	0.016	0.022	0.032	0.04	0.05	0.065																		
N	> 250 N/mm ²	350	0.012	0.020	0.038	0.05	0.08	0.095	0.13	0.16																		

Ratio end mills RF 100 Sharp



材質 **Solid carbide**

鍍層 **P** **P**

Type N N

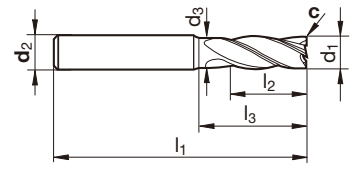
柄部形式 HA HB

P ● **GÜHRING NAVIGATOR**

- M** ● especially for soft, tough and high-alloyed materials
- K** ● medium length version
- N** ● neck clearance
- S** ● centre cutting
- H** ● 特別適用於軟、堅韌和高合金材料
- 中長型切削刃
- 縮頸設計
- 端面底面過中心



縮頸設計



編號： **6480** **6481**

d1 e8	d2 h6	d3	l1	l2	l3	c	Z	Code no.	價格	
mm	mm	mm	mm	mm	mm	mm x 45°				
1.000	4.000	0.920	50.000	3.000	5.500	0.020	4	1.000	1,310	
1.500	4.000	1.400	50.000	4.500	8.500	0.030	4	1.500	1,310	
2.000	6.000	1.900	57.000	6.000	11.500	0.040	4	2.000	1,350	
2.500	6.000	2.400	57.000	7.500	14.500	0.050	4	2.500	1,350	
3.000	6.000	2.900	65.000	10.000	20.000	0.060	4	3.000	1,390	
4.000	6.000	3.800	65.000	14.000	27.000	0.080	4	4.000	1,390	1,490
5.000	6.000	4.800	65.000	15.000	28.000	0.100	4	5.000	1,390	1,490
6.000	6.000	5.700	75.000	19.000	38.000	0.120	4	6.000	1,390	1,490
8.000	8.000	7.700	80.000	21.000	43.000	0.160	4	8.000	1,840	1,960
10.000	10.000	9.500	93.000	26.000	52.000	0.200	4	10.000	2,730	2,950
12.000	12.000	11.500	100.000	28.000	54.000	0.240	4	12.000	3,550	3,780
14.000	14.000	13.500	100.000	28.000	54.000	0.280	4	14.000	4,650	4,950
16.000	16.000	15.500	123.000	38.000	74.000	0.320	4	16.000	6,100	6,500
20.000	20.000	19.500	126.000	41.000	75.000	0.400	4	20.000	9,400	9,900

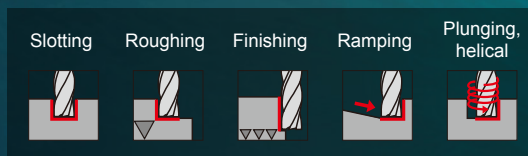
ISO 材料	Hardness 抗拉強度	vc 切速	fz (mm/z)/Ø 每刃進給 / 刃徑										vc 切速	fz (mm/z)/Ø 每刃進給 / 刃徑											
			ap=1.0xD 切深						ae=0.4xD 切寬					ap=2.0xD 切深						ae max=0.1xD 最大切寬					
			1	3	6	8	10		12	16	20	1		3	6	8	10	12		16	20				
P	< 500 N/mm ²	180	0.010	0.016	0.030	0.042	0.06	0.072	0.1	0.12	210	0.011	0.018	0.036	0.048	0.069	0.08	0.11	0.14						
	500-900 N/mm ²	140	0.008	0.014	0.027	0.036	0.05	0.06	0.08	0.1	160	0.009	0.016	0.031	0.041	0.058	0.07	0.09	0.12						
M	< 500 N/mm ²	120	0.006	0.012	0.025	0.032	0.045	0.055	0.075	0.085	140	0.007	0.016	0.031	0.041	0.058	0.07	0.09	0.12						
	500-900 N/mm ²	80	0.005	0.010	0.021	0.028	0.04	0.048	0.06	0.07	100	0.006	0.013	0.025	0.034	0.048	0.06	0.08	0.1						
S	< 900 N/mm ²	45	0.004	0.008	0.016	0.022	0.032	0.04	0.05	0.065	60	0.005	0.010	0.020	0.027	0.038	0.05	0.06	0.085						
N	> 250 N/mm ²	350	0.012	0.020	0.038	0.05	0.08	0.095	0.13	0.16	600	0.013	0.022	0.045	0.06	0.09	0.12	0.15	0.18						

★ 適用軟、堅韌和高合金材料加工

★ 從工況不佳到HPC高速度加工皆適用

★ 開槽、粗加工、斜向進刀、螺旋下刀、精加工等皆適用

★ 有較長的刃長與小尺寸可選用，8mm以上可修磨，是經濟又實惠的選擇



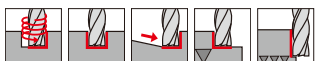
Benefit from the RF 100 Sharp promotion set:

- **exceptionally easy cutting** in soft, tough & high-alloyed materials (300 – 900 N/mm²)
- **from unstable to HPC** powerful and smooth under all operating conditions
- **full flexibility in milling operations** slotting, roughing, ramping, helical, finishing
- **more cost-efficient milling** due to its extra-long design the RF 100 Sharp reaches greater depths even with smaller diameters and can be reground more often



RF 100 SHARP

Ratio end mill sets RF 100 Sharp



- | | | |
|----------|---|---|
| P | ● | • 特別適用於軟、堅韌和高合金材料 |
| M | ● | • 中長型切削刃 |
| K | ● | • 縮頸設計 |
| N | ● | • 端面底面過中心 |
| S | ● | • 整盒包含No. 6478 或 No. 6479 |
| H | ● | • especially for soft, tough and high-alloyed materials |
| | ● | • longer cutting edge than DIN 6527 L |
| | ● | • neck clearance |
| | ● | • centre cutting |
| | ● | • consisting of art. no. 6478 or 6479 |

材質 **Solid Carbide**
 鍍層 **P**
 Type **N**



Art. no. 6478



Art. no. 6479



Variants	Ø-range mm	Pieces/set 整盒支數	Shank form	consisting of Article no.	Order no. 整盒編號
Promotion set 1	6/8/10/12/16	5	HA	6478	6482 1.000
Promotion set 2	6/8/10/12	4	HA	6478	6482 2.000
Promotion set 3	6/8/10/12/16	5	HB	6479	6483 1.000
Promotion set 4	6/8/10/12	4	HB	6479	6483 2.000

價格
11,000
6,600
11,300
6,800

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 南部辦事處：(82054) 高雄市岡山區大仁南路140號
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