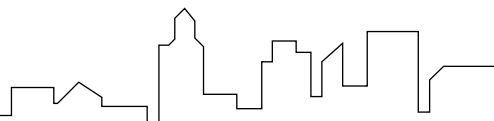


GÜHRING

THE SPECIALISTS FOR LIGHTWEIGHT **ALUMINIUM CONSTRUCTIONS**

- ▶ perfect combination of roughing and finishing process for deep pockets and thin walls
- ▶ excellent surface quality
- ▶ accurate angularity

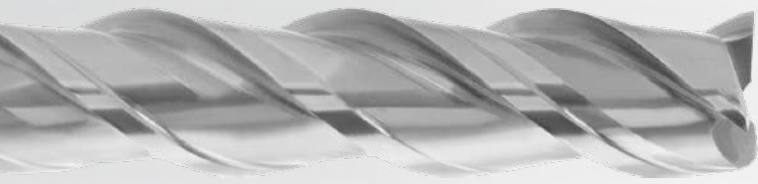
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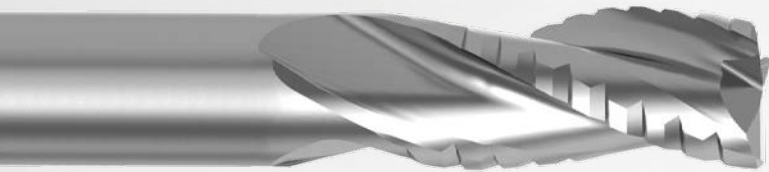
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Ratio®



Finishing end mills Alu RF 100 **SKYLINER F**

- ▶ new cutting-edge geometry
- ▶ for finishing without vibrations for machining depths of up to 5xD
- ▶ Optimal surface finish on wall and base geometries
- ▶ perfect angularity of milled walls
- ▶ Finishing at highest feed rate even with close corner radii and large angle engagement

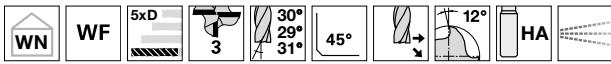


Roughing end mills Alu RF 100 **SKYLINER R**

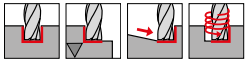
- ▶ highest metal removal rate and low stress on the machine
- ▶ optimized face geometry for helical plunging and with acute ramping angles
- ▶ optimal chip evacuation thanks to optimised roughing geometry and internal cooling



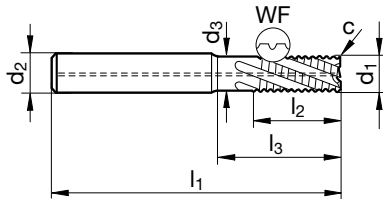
Roughing end mills Alu RF 100 SkyLiner R



Tool material **VHM**
Surface ○



- for aluminium, non-ferrous metals and plastics
- with axial coolant ducts
- with neck clearance

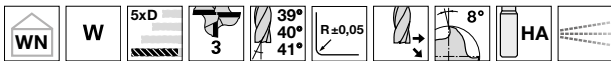


special tool

d1 h10	d2 h6	d3	l1	l2	l3	c	Z	Code no.
mm	mm	mm	mm	mm	mm	mm x 45°		
12.00	12.00	11.50	108	26	61	0.12	3	02000 007253
16.00	16.00	15.50	132	32	82	0.16	3	02000 007254
20.00	20.00	19.50	154	38	102	0.20	3	02000 007255
25.00	25.00	24.00	185	45	127	0.25	3	02000 007256

ISO	Hardness	v _c	f _z (mm/z) / Ø							v _c	f _z (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
N	≤ 7% Si	375	0.011	0.021	0.028	0.037	0.044	0.059	0.074	440	0.012	0.024	0.032	0.043	0.051	0.068	0.085
	≥ 7% Si	180	0.010	0.019	0.026	0.035	0.042	0.056	0.070		210	0.011	0.022	0.029	0.040	0.048	0.064
NE	≤ 850 N/mm ²	200	0.010	0.019	0.026	0.035	0.042	0.056	0.070	230	0.011	0.022	0.029	0.040	0.048	0.064	0.081

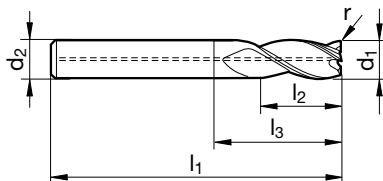
Finishing end mills Alu RF 100 SkyLiner F



Tool material **VHM**
Surface ○



- Aluminum, non-ferrous metals and plastics
- with axial coolant ducts



special tool

d1 e8	d2 h6	l1	l2	l3	r	Z	Code no.
mm	mm	mm	mm	mm	mm		
6.00	6.00	75	31	39	0.2	3	02000 007278
8.00	8.00	86	41	50	0.2	3	02000 007279
10.00	10.00	100	51	60	0.2	3	02000 007280
12.00	12.00	120	62	75	0.2	3	02000 007281
16.00	16.00	150	82	102	0.2	3	02000 007282
20.00	20.00	175	102	125	0.2	3	02000 007283
25.00	25.00	210	127	154	0.2	3	02000 007284

ISO	Hardness	v _c	f _z (mm/z) / Ø							v _c	f _z (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
N	≤ 7% Si	400	0.016	0.031	0.042	0.064	0.080	0.100	0.130	450	0.010	0.020	0.026	0.040	0.048	0.064	0.080
	≥ 7% Si	200	0.013	0.027	0.035	0.048	0.060	0.080	0.100		210	0.008	0.017	0.022	0.030	0.036	0.048
NE	≤ 850 N/mm ²	190	0.013	0.027	0.035	0.048	0.060	0.080	0.100	220	0.008	0.017	0.022	0.030	0.036	0.048	0.060



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