

Using Carbide Rotary Burrs is a effective way to realize mechanization in hand work operations. In the industries of airplane, shipbuilding, automobile, machinery, chemistry etc. Carbide Rotary Burrs can be widely used in machining iron, steel casting, carbon steel, alloy steel, stainless steel, hardened steel, copper aluminum etc.

Machining various kinds of metal material including <HRC65 hardened steel.

- Instead of small emery wheels, without powder pollution.
- Increasing productivity of several ten times than using hand tools and three to five times than using small emery wheels
- Having long life of ten times than high speed steel burrs and fifty times than small emery wheels.
- Finish machining various kinds of die cavities.
- Removing the burrs of the castings, forgings and the welding spatter on the weld assemblies.
- Chamfering angle, circular bead or flute on the mechanical components.
- Chamfering or burring the pipes.
- Polishing the impeller channel.
- Grinding the hole to an accurate shape.

The machines which are used for Carbide Rotary Burrs are usually hand-held, powered either by compressed air or electricity. Be careful about mounting and handling the burr correctly. Only at high speed, can carbide rotary burrs show their remarkable performance. Recommended spindle speeds.

**Notes :**

- It may be necessary to adjust the rates shown to acheive optimum performance.
- Harder Materials require slower speeds.
- Smaller burrs require faster speeds.
- Extra long burrs(>150 mm long) require slower speeds.
- Apply constant movement and light pressure when in use.
- Running below the optimum speed will cause tooth wear.
- Allowing the tool to become too hot may cause the braze to melt and detach the head from the shank.
- Using tools and collets that have become worn will encourage chipping.
- Do not sink the burr for more than one third of its periphery.

**Technical Data : ( guide to running speeds )**

Materials	Ø	Ø	Ø	Ø	Ø
	3mm	6mm	10mm	12mm	16mm
Steel	60,000-90,000	45,000-60,000	30,000-40,000	22,500-30,000	18,000-24,000
Hardened Steel	60,000-90,000	30,000-45,000	19,000-30,000	15,000-22,500	12,000-18,000
Stainless Steel	60,000-90,000	30,000-45,000	19,000-30,000	15,000-22,500	12,000-18,000
Cast Iron	45,000-90,000	22,500-60,000	15,000-40,000	11,000-30,000	09,000-24,000
Titanium	60,000-90,000	30,000-45,000	19,000-30,000	15,000-22,500	12,000-18,000
Nickel	60,000-90,000	30,000-45,000	19,000-30,000	15,000-22,500	12,000-18,000
Copper / Copper Alloys	45,000-90,000	22,500-60,000	15,000-40,000	11,000-30,000	09,000-24,000
Aluminium	30,000-90,000	15,000-70,000	10,000-50,000	07,000-38,000	06,000-30,000
Plastics	30,000-90,000	15,000-70,000	10,000-50,000	07,000-38,000	06,000-30,000
Cermet	60,000-90,000	30,000-45,000	19,000-30,000	15,000-22,500	12,000-18,000