# Tungsten Carbide Rotary Burrs

## Standard Cut (Single Cut):

This flute structure is designed for superior material removal and general purpose application. These can be used on Steel, Steel alloys, Cast Iron, Stainless steel, Hard Bronze and Copper. Produces longer chips.

## Supreme Cut (Double Cut / Cross Cut):

This Burr allows for efficient stock removal in the harder materials. Its design reduces tool chatter and breaks the chips into granular shapes. These smaller chip also helps to eliminate loading on the flutes. This design helps to have better control on the burr and grinder.

## Deluxe Cut (Diamond Cut):

This design of tool is like triangular style of point, which produces extremely small chips (powder like chips). This cut eliminates the pulling action of the main cut, and offers the operator good control over the tool and produces excellent finish. Effective in heat treated Steels and Tough alloy steels.

## Chip Breaker:

In this style there is addition of chip breaker on single spiral flute patterns. There will be a better control on the tool and chips will be broken down. Surface finish may be slightly reduced due to the chip breaker design. Used on all Steel, Cast-Iron, Brass, Bronze and Copper.

## Aluma Cut:

Designed for rapid stock removal on Non-ferrous materials. Recommended to work on Aluminium, Zinc alloy, Magnesium, Plastic, Hand rubber and Wood.

## SPEED RECOMMENDATION CHART - Approx. R.P.M. in 1000's

| Material | 3mm | 6mm | 8mm | 10mm | 12mm | 16mm | 20mm | 25mm |
|---|---|---|---|---|---|---|---|---|
| Steel | 60-90 | 30-45 | 25-35 | 20-30 | 15-25 | 10-18 | 10-14 | 8-10 |
| Hardened / Tool Steel | 30-40 | 15-20 | 10-15 | 10-15 | 8-10 | 5-8 | 4-7 | 3-5 |
| Stainless Steel | 30-50 | 15-25 | 12-20 | 10-15 | 9-12 | 7-10 | 5-7 | 4-5 |
| Nickel / Titanium | 30-40 | 15-20 | 10-15 | 10-15 | 8-10 | 5-8 | 4-7 | 3-5 |
| Cast Iron | 60-90 | 30-45 | 25-35 | 20-30 | 15-2 | 10-18 | 10-14 | 8-10 |
| Aluminium / Plastics | 30-90 | 15-60 | 12-50 | 10-50 | 8-35 | 6-30 | 5-20 | 4-15 |
| Brass | 40-50 | 20-30 | 15-20 | 13-17 | 10-15 | 8-12 | 6-8 | 5-6 |
| Copper | 30-90 | 15-60 | 12-50 | 10-50 | 8-35 | 6-30 | 5-20 | 4-15 |
| Zinc | 60-90 | 30-45 | 25-35 | 20-30 | 15-25 | 10-18 | 10-14 | 8-10 |

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