Tungsten Carbide Burrs with Cut STEEL

High-Capacity Burr

PFERD

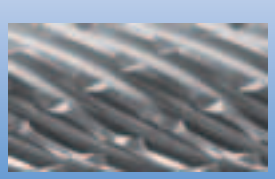
TRUST BLUE

- Up to 50 % higher stock removal rates for applications on steel and cast steel compared to conventional burrs with cross cut
- Tangible aggressiveness, large chips and very good chip removal through the innovative tooth geometry
- Comfortable working with reduced vibrations and less noise

Tungsten Carbide Burrs with Cut STEEL

for Use on Steel and Cast Steel

Cut STEEL



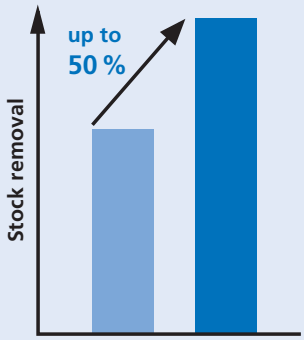
With its innovative cut STEEL, PFERD has developed unique burrs for machining steel and cast steel, that are distinguished by a **tangible aggressiveness** with good guidability. Thus they ensure safe and precise work.

Their extremely **high stock removal performance** makes these burrs with cut STEEL impressive, with **significant time savings** and **high economic value**.

Advantages

- Tangible aggressiveness, large chips and very good chip removal through the innovative tooth geometry.
- Significant time savings through the extremely high stock removal performance.
- Protection of the workpiece and tool through much lower thermal loads.
- Comfortable and ergonomic working through quieter operation with reduced vibration and less noise.

Performance values for application on steel and cast steel



- Conventional burrs with cross cut
- Tungsten carbide burrs, cut STEEL

PFERDERGONOMICS

PFERDERGONOMICS recommends tungsten carbide burrs with cut STEEL as an innovative tool solution for use on steel and cast steel. They stand out through smoother milling characteristics, significantly reduced vibrations and less noise development.

For further information and suitable PFERD tools see the brochure "**PFERD**ERGONOMICS – The Focus is on People".

Recommended rotational speed range [RPM]

To determine the recommended cutting speed [m/min], please proceed as follows:

❶ Select the material group that is to be processed.
❷ Determine the type of application.
❸ Select the cut.
❹ Establish the cutting speed range.

To determine the recommended rotational speed [RPM], please proceed as follows:
❺ Select the required burr diameter.
❻ The cutting speed range and burr diameter determine the rotational speed range [RPM].

❶ Material groups			❷ Application	❸ Cut	❹ Cutting speed
Steel, cast steel	Non-hardened, non-heat treated steels up to 1200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steels	Coarse machining = high stock removal	STEEL	450 - 750 m/min
	Hardened, heat-treated steels exceeding 1200 N/mm² (> 38 HRC)	Tool steels, tempering steels, alloyed steels, cast steels			

❺ Burr dia. [mm]	❹ Cutting speed [m/min]	
	450	750
	❻ Rotational speed [RPM]	
6	24.000	40.000
8	18.000	30.000
10	14.000	24.000
12	12.000	20.000

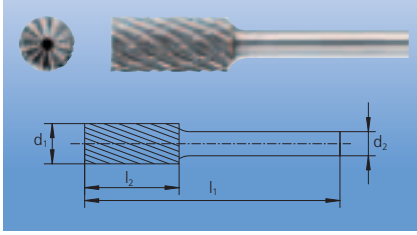
Example:
TC burr, cut STEEL,
burr dia. 12 mm.
Cutting speed: 450-750 m/min
Rotational speed: 12.000-20.000 RPM

Cylindrical burr according to DIN 8032, shape ZYAS with circumferential and end cut.

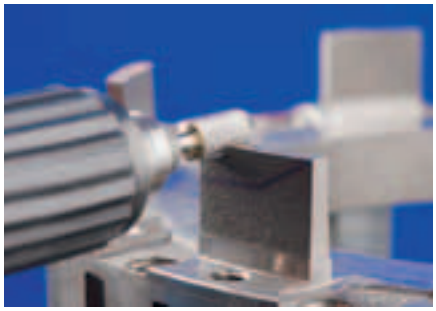
Ordering example:
EAN 4007220**937259**
ZYAS 0616/6 STEEL

Vibration Filter Noise Filter

Cylindrical shape ZYA
Cylindrical shape with end cut ZYAS



	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm without end cut							
N!	ZYA 0616/6	937198	6	6 x 16	55	24.000 - 40.000	1	23
N!	ZYA 0820/6	937211	6	8 x 20	60	18.000 - 30.000	1	24
N!	ZYA 1020/6	937235	6	10 x 20	60	14.000 - 24.000	1	32
N!	ZYA 1225/6	937242	6	12 x 25	65	12.000 - 20.000	1	60
	Shank dia. 6 mm with end cut							
N!	ZYAS 0616/6	937259	6	6 x 16	55	24.000 - 40.000	1	23
N!	ZYAS 0820/6	937266	6	8 x 20	60	18.000 - 30.000	1	24
N!	ZYAS 1020/6	937310	6	10 x 20	60	14.000 - 24.000	1	32
N!	ZYAS 1225/6	937341	6	12 x 25	65	12.000 - 20.000	1	60

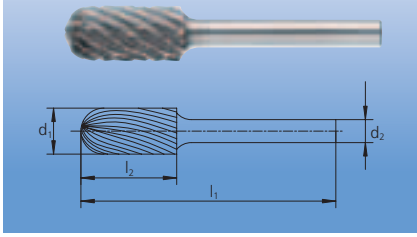


Cylindrical burr with radius end according to DIN 8032.

Ordering example:
EAN 4007220**937129**
WRC 0616/6 STEEL

Vibration Filter Noise Filter

Cylindrical shape with radius end WRC



	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm							
N!	WRC 0616/6	937129	6	6 x 16	55	24.000 - 40.000	1	22
N!	WRC 0820/6	937150	6	8 x 20	60	18.000 - 30.000	1	25
N!	WRC 1020/6	937174	6	10 x 20	60	14.000 - 24.000	1	29
N!	WRC 1225/6	936696	6	12 x 25	65	12.000 - 20.000	1	49

Tungsten Carbide Burrs with Cut STEEL

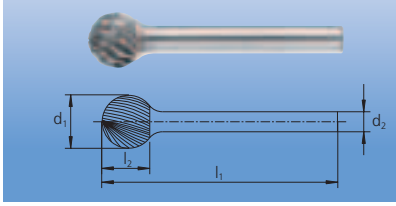
for Use on Steel and Cast Steel

Ball-shaped burr according to DIN 8032.

Ordering example:
EAN 4007220**936832**
KUD 0605/6 STEEL

Vibration Filter Noise Filter

Ball shape KUD



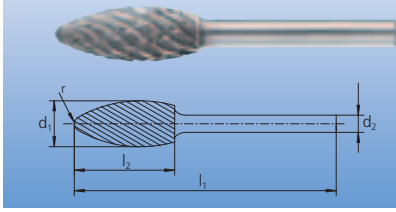
	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm							
N!	KUD 0605/6	936832	6	6 x 5	45	24.000 - 40.000	1	18
N!	KUD 0807/6	936849	6	8 x 7	47	18.000 - 30.000	1	14
N!	KUD 1009/6	936863	6	10 x 9	49	14.000 - 24.000	1	17
N!	KUD 1210/6	936870	6	12 x 10	51	12.000 - 20.000	1	25

Flame-shaped burr according to ISO 7755/8.

Ordering example
EAN 4007220**936719**
B 0820/6 STEEL

Vibration Filter Noise Filter

Flame shape B



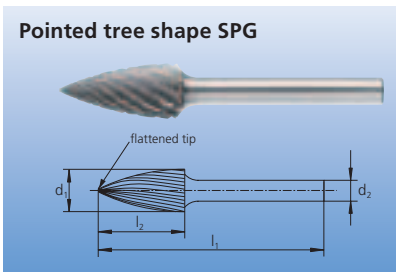
	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Radius r [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm								
N!	B 0820/6	936719	6	8 x 20	60	1,5	18.000 - 30.000	1	18
N!	B 1230/6	936764	6	12 x 30	70	2,1	12.000 - 20.000	1	53

Pointed tree-shaped burr according to DIN 8032, flattened tip.

Ordering example:
EAN 4007220**937013**
SPG 1020/6 STEEL

Vibration Filter Noise Filter

Pointed tree shape SPG



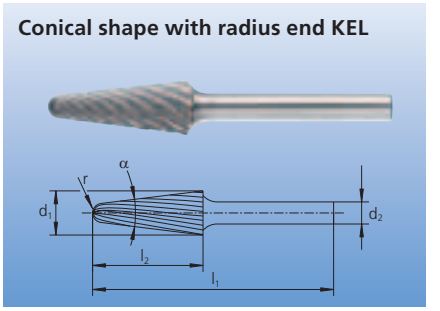
	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm							
N!	SPG 0618/6	936979	6	6 x 18	55	24.000 - 40.000	1	21
N!	SPG 0820/6	936993	6	8 x 20	60	18.000 - 30.000	1	18
N!	SPG 1020/6	937013	6	10 x 20	60	14.000 - 24.000	1	23
N!	SPG 1225/6	937082	6	12 x 25	70	12.000 - 20.000	1	46

Conical burr with radius end according to DIN 8032.

Ordering example:
EAN 4007220**936818**
KEL 1230/6 STEEL

Vibration Filter Noise Filter

Conical shape with radius end KEL



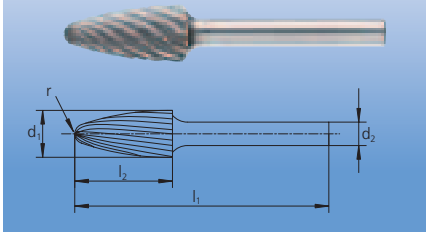
	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Angle α	Radius r [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm									
N!	KEL 1020/6	936771	6	10 x 20	60	14°	2,9	18.000 - 30.000	1	23
N!	KEL 1230/6	936818	6	12 x 30	70	14°	2,6	12.000 - 20.000	1	54

Tree-shaped burr with radius end according to DIN 8032.

Ordering example:
EAN 4007220**936887**
RBF 0618/6 STEEL

Vibration Filter Noise Filter

Tree shape with radius end RBF



	Order No.	Cut STEEL EAN 4007220	Shank dia. d_2 [mm]	Burr dia. x length d_1 x l_2 [mm]	Overall length l_1 [mm]	Radius r [mm]	Recom. speed [min^{-1}]		g
	Shank dia. 6 mm								
N!	RBF 0618/6	936887	6	6 x 18	55	1,5	24.000 - 40.000	1	21
N!	RBF 0820/6	936900	6	8 x 20	60	1,2	18.000 - 30.000	1	18
N!	RBF 1020/6	936924	6	10 x 20	60	2,5	14.000 - 24.000	1	24
N!	RBF 1225/6	936931	6	12 x 25	65	2,5	12.000 - 20.000	1	47

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