



Tungsten carbide high-performance burr ALLROUND tree shape with radius end RBF dia. 12x25mm shank dia. 6mm universal coarse

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With the innovative ALLROUND cut, PFERD TOOLS has developed unique burrs for versatile use on key materials such as steel and cast steel, stainless steel (INOX), non-ferrous metals and cast iron. The ALLROUND cut offers all the benefits of the tried-and-tested 3 PLUS cut, but its stock removal rate is up to 30 % higher for steel. It enables comfortable working with reduced vibration and less noise. The ALLROUND cut also helps users save considerable time when working, thus making it an economically efficient option.

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

Technical information

Cut	ALLROUND
Dia. external	12 mm
Dia. shank	6 mm
Length, cut	25 mm
Length, total	65 mm
RPM, grey cast iron, white cast iron	12.000 - 24.000 RPM
RPM, hard non-ferrous metals	12.000 - 16.000 RPM
RPM, hardened, heat-treated steels over 1,200 N/mm ²	7.000 - 12.000 RPM
RPM, rust and acid-resistant steels	12.000 - 16.000 RPM
RPM, soft non-ferrous metals	12.000 - 20.000 RPM
RPM, steels up to 1,200 N/mm ²	12.000 - 20.000 RPM
Radius corner design	2.5 mm

Advantages

- ✔ Significantly better stock removal rate than burrs with a conventional cross cut.
- ✔ Saves time and money thanks to its very high stock removal rate on key materials.
- ✔ Comfortable working thanks to reduced vibration and less noise.
- ✔ The highly accurate concentricity enables impactfree working without creating chatter marks. This considerably reduces wear on the tool and tool drive.

Recommendations for use

- ✓ To prevent vibrations, place the tools on powerful drives with an elastically supported spindle wherever possible.
- ✓ Observe the recommended rotational speeds.
- ✓ If the smallest area of the burr diameter is being used, the recommended rotational speed can be increased accordingly.
- ✓ To ensure costeffective use of burrs, use a higher rotational speed and cutting speed. Use burrs with a shank diameter of 6 mm with drives with a power output from 300 watts.

Safety notes

- ✓ The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.
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Materials that can be worked

- ✓ Annealed cast iron
 - ✓ Black annealed cast iron (GTS, GJMB)
 - ✓ Brass
 - ✓ Bronze
 - ✓ Case-hardened steels
 - ✓ Cast iron
 - ✓ Cast steel
 - ✓ Copper
 - ✓ Grey/nodular cast iron (GG/GJL, GGG/GJS)
 - ✓ Hard aluminium alloys
 - ✓ Hardened, heat-treated steels over 1.200 N/mm² (< 38 HRC)
 - ✓ Hard non-ferrous metal
 - ✓ Soft non-ferrous metal
 - ✓ Stainless steel (INOX)
 - ✓ Steel
 - ✓ Steel, cast steel
 - ✓ Steel materials with a hardness > 54 HRC
 - ✓ Steels over 700 N/mm² (> 220 HB)
 - ✓ Steels up to 1,200 N/mm² (< 38 HRC)
 - ✓ Steels up to 700 N/mm² (< 220 HB)
 - ✓ Titanium
 - ✓ Titanium alloys
 - ✓ Tool steels
 - ✓ White annealed cast iron (GTW, GJMW)
 - ✓ Zinc
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Applications

- ✓ Cutting out holes
 - ✓ Deburring
 - ✓ Leveling
 - ✓ Milling
 - ✓ Milling out
 - ✓ Surface work
 - ✓ Work on weld seams
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Drive types

- ✓ Drive spindle
 - ✓ Flexible shaft drive
 - ✓ Robot
 - ✓ Stationary machines
 - ✓ Straight grinder
 - ✓ Tool machine
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