



Tungsten carbide burr inverted cone WKN dia. 12x13 mm shank dia. 6 mm Z3 universal medium



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Cut 3 is especially well-suited to machining of cast iron, steel, stainless steel (INOX), nickel-based alloys and titanium alloys. It is characterized by its high stock removal rate and achieves a good surface.

Tungsten carbide burs for general applications are suitable for fine and coarse stock removal on the key materials used in industrial manufacturing. They provide a good stock removal rate and are not specific to a particular material.

Inverted cone-shaped rotary cutter, tapered towards the shank according to DIN 8032 with cut conforming to DIN 8033. Suitable for work on hard-to-reach, reverse-side edges.

Due to their special shapes, tungsten carbide burs for flexible work on edges achieve almost precise chamfers or radii and can also be used flexibly in hard-to-reach areas. They are mainly used in steel and aluminium construction and have been specifically designed for chamfering, deburring and rounding of edges.

Technical information

Angle	20 °
Cut	3
Dia. external	12 mm
Dia. shank	6 mm
Length, cut	13 mm
Length, total	53 mm
RPM, grey cast iron, white cast iron	12.000 - 16.000 RPM
RPM, hard non-ferrous metals	7.000 - 9.000 RPM
RPM, hardened, heat-treated steels over 1,200 N/mm ²	7.000 - 9.000 RPM
RPM, rust and acid-resistant steels	7.000 - 9.000 RPM
RPM, soft non-ferrous metals	12.000 - 16.000 RPM

Advantages

- ✓ Good stock removal rate through optimum matching of tungsten carbide, geometry, cut and available coating.
- ✓ Long tool life.
- ✓ The highly accurate concentricity enables impactfree working without creating chatter marks. This considerably reduces wear on the tool and tool drive.

Recommendations for use

- ✓ 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.

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 aluminium alloys
 - ✓ Soft non-ferrous metal
 - ✓ Stainless steel (INOX)
 - ✓ Steel
 - ✓ Steel, cast steel
 - ✓ 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

- ✓ Chamfering
- ✓ Countersinking
- ✓ Cutting out holes
- ✓ Deburring
- ✓ Leveling
- ✓ Milling
- ✓ Milling out
- ✓ Surface work
- ✓ Working on edges
- ✓ Work on weld seams

Drive types

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



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