



## SELECTION BY CUT

### SINGLE CUT:



- Provides the best surface finish and largest contact patch on the work piece.
- Demands greater operator skill since the single flute direction pulls the bur into the work piece.
- USE IN - Non-hardened steel <45 HRC, hardened steel >45HRC, stainless steel, non-ferrous light metals, hardened cast. iron >45HRC, High temp resistant metals

### DOUBLE CUT:



- Most popular geometry as the dual flute direction reduces the contact patch on the work piece and therefore provides easier operator control while still maintaining a good surface finish.
- USE IN - Ferrous metals, Non-ferrous metals

### ALUMINUM CUT:



- These burs employ a coarser flute which results in improved cutting performance for aluminum and aluminum alloys.
- USE IN - Non-ferrous metals, aluminum alloys, plastics

## CARBIDE BURS - SPEEDS

CUTTING DIA	SUGGESTED RPM	MAXIMUM RPM
1/16	55,000 - 85,000	90,000
1/8	35,000 - 65,000	80,000
3/16	30,000 - 55,000	70,000
1/4	25,000 - 50,000	70,000
5/16	20,000 - 40,000	67,000
3/8	18,000 - 40,000	63,000
7/16	16,000 - 38,000	58,000
1/2	14,000 - 36,000	50,000
5/8	12,000 - 25,000	40,000
3/4	10,000 - 20,000	33,000
1	7,500 - 20,000	25,000

- When using double cut: Reduce speeds by 25% approximately
- For stainless steel material: Increase speeds by 50% approximately