

DEBURRING RECOMMENDATIONS

Burr Diameter	Minimum RPM	Medium RPM	Maximum RPM (Stainless)
1/16	50000	75000	100000
1/8	30000	60000	90000
3/16	25000	50000	75000
1/4	20000	40000	65000
5/16	15000	35000	60000
3/8	15000	35000	60000
7/16	15000	35000	60000
1/2	10000	30000	50000
5/8	10000	30000	50000
3/4	10000	20000	35000
1	5000	15000	30000

**SINGLE CUT**

IDEAL FOR FINISHING

**DOUBLE CUT**

IDEAL FOR MATERIAL REMOVAL

**ALUMA CUT**

IDEAL FOR NON-FERROUS MATERIALS

Industry Designation	Shape	Application
SA	Cylinder	Universal Surface Grinding
SB	Cylinder with End Cut	Blind holes & Inner Contours
SC	Cylinder with Radius	Contouring & Bore holes
SD	Ball	Contouring & Bore holes
SE	Oval / Egg	Molds & Fillet Welds
SF	Radius Tree	Molds & Contouring
SG	Pointed Tree	Chamfering & Bore Holes
SH	Flame	Molds & Contouring
SJ	60° Cone	Chamfering & Beveling & Countersinking
SK	90° Cone	Chamfering & Beveling & Countersinking
SL	Taper with Radius	Contouring & Difficult to Access Areas
SM	Pointed Cone	Conical Holes & Grooves & Model Building
SN	Inverted Cone	Inner Edges & Conical Profiles