

SV-BURR: Recommendations and Applications

Speed Range:

- Operate the burr within the limits of the recommended speed range
- Running below the optimum speed may cause chipping
- Running above recommended speed will cause tooth wear
- Harder materials or gummy metals such as Titanium, require slower speeds

Do's:

- Choose the correct shape, diameter and cut style for each specific application
- Set the maximum length of the burr in the collet
- Slow down the speed for extra-long burrs, and do not exceed more than 15,000 RPM
- When selecting the appropriate air tool, ensure that it is regularly maintained
- Check the air tool before use to ensure it is running correctly
- Hold the air tool firmly and securely fix the workpiece
- Apply smooth cutting action with continuous movement
- Use light pressure and let the **SV-Burr** do the job!

Dont's :

- Do not use the burr above the Maximum Operating Speed (See the Recommended Speed Guide on page 6)
- Do not use the burr too slowly (See the Recommended Speed Guide on page 6)
- Do not expose the burr to excessive mechanical or thermal shock
- Do not drop the burr to more than one third of its periphery
- Do not clog the burr into gaps, pockets, grooves, crevices or cavities
- Avoid overheating to ensure that the brazed burr will not soften or detach the head from the shank *

* **Note:** This applies to burrs with a larger head diameter than shank diameter.

Recommended Speed Guide

The chart below provides general and comparative recommendations.
To reach desired results, you may need to try a few variations.
Long shank burrs should be used at reduced speeds.

Burr Diameter mm (Inch)	RPM
3mm (1/8") Solid Carbide	45,000 - 50,000
5mm (3/16") Solid Carbide	35,000 - 40,000
5mm (3/16") Carbide Head Brazed to 3mm (1/8") Steel Shank	30,000 - 35,000
6mm (1/4") Solid Carbide	30,000 - 35,000
6mm (1/4") Carbide Head Brazed to 3mm (1/8") Steel Shank	25,000 - 30,000
8mm (5/16") Carbide Head Brazed to 6mm (1/4") Steel Shank	25,000 - 30,000
10mm (3/8") Carbide Head Brazed to 6mm (1/4") Steel Shank	25,000 - 30,000
11mm (7/16") Carbide Head Brazed to 6mm (1/4") Steel Shank	20,000 - 25,000
12mm (1/2") Carbide Head Brazed to 6mm (1/4") Steel Shank	20,000 - 25,000
16mm (5/8") Carbide Head Brazed to 6mm (1/4") Steel Shank	15,000 - 20,000
18mm (3/4") Carbide Head Brazed to 6mm (1/4") Steel Shank	15,000 - 20,000
25mm (1") Carbide Head Brazed to 6mm (1/4") Steel Shank	12,000 - 18,000

