

## Sets

Size Ref.	Description	d <sub>1</sub>	Qty	Item #
<b>Bur Sets Metric</b>				
SCB5A	SA300, SA500, SC300, SC500, SF300	3/8 & 1/2	5	B901 SCB5A

## Application



### Double Cut

The double cut bur allows for rapid stock removal in the harder materials. The chisel tooth pattern not only minimises tool chatter but reduces the chip to a granular shape, in most materials, thereby reducing or eliminating the sharp sliver chips that are normally experienced.

This chip reduction also helps eliminate loading of the flutes.

An improvement in tool control will be realised as the double cut tends to reduce the pulling action of the main flute pattern.

Although some finish reduction may be experienced, improvement in material removal and, therefore, increased production will be realised.

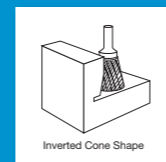
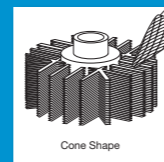
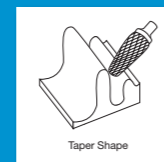
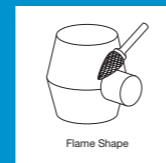
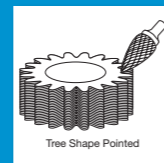
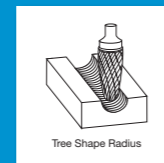
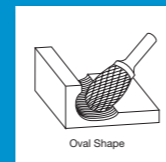
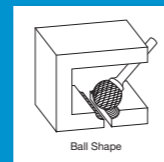
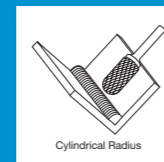
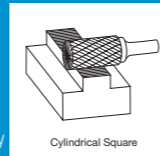


### Aluminium Cut

This flute pattern is recommended for rapid material removal of aluminium or other soft materials such as brass, copper and plastics that would normally load other cuts.

The extra deep flute structure should eliminate bur loading.

Carbide burs are used in various applications for deburring, cylinder head porting, mould making, tool & die, metalworking, tool grinding, foundry, aerospace, automotive, dental laboratory, wood carving, farmers, metal smithing, sculpting, welding, chamfering, jewellery manufacturing, die & metal casting.



## Usage Guide

### Recommended Cutting Speeds (RPM) - Standard Length Burs

Ø	Double Cut		Aluminium Cut	Max RPM
	Steels, alloys & non-ferrous	Stainless Steel	Aluminium	
1/16	33,000	50,000	-	78,000
3/32	26,000	40,000	-	60,000
1/8	23,000	35,000	-	53,000
3/16	17,000	25,000	-	38,000
1/4	15,000	22,000	30,000	33,000
5/16	13,000	20,000	25,000	30,000
3/8	12,000	18,000	20,000	27,000
7/16	11,500	17,000	18,000	26,000
1/2	11,000	16,000	15,000	24,000
5/8	10,000	15,000	12,000	23,000
3/4	9,000	14,000	10,000	21,000
7/8	8,500	13,000	-	20,000
1	8,000	12,000	-	18,000

Note: Recommend reduce speeds by 50% when using long shank carbide burs.

### Safety Tips

- Eye protection must be worn at and around bur application
- For use in air & electric die grinders, do not use in conventional electric drills as insufficient speed can cause breakage
- Chuck carbide bur to full capacity of machine chuck
- Do not use driving tool with worn bearings
- Endeavour to use double cut wherever possible as standard cut can produce harmful slivers

### Hints for Use

- Position bur in drive as close as possible to head of collet
- Allow tool to do its own cutting – do not force the cut or use excessive pressure
- Allow tool to be running at full speed before making contact with the work piece
- To prevent loading on aluminium burs – coat bur with bees wax or oven cleaner before use
- If sparks are evident in use, either bur is dull and should be replaced or material is too hard



Product Range  
**CARBIDE BURS**

[www.suttontools.co.nz](http://www.suttontools.co.nz)

**suttontools**  
world class cutting tools

