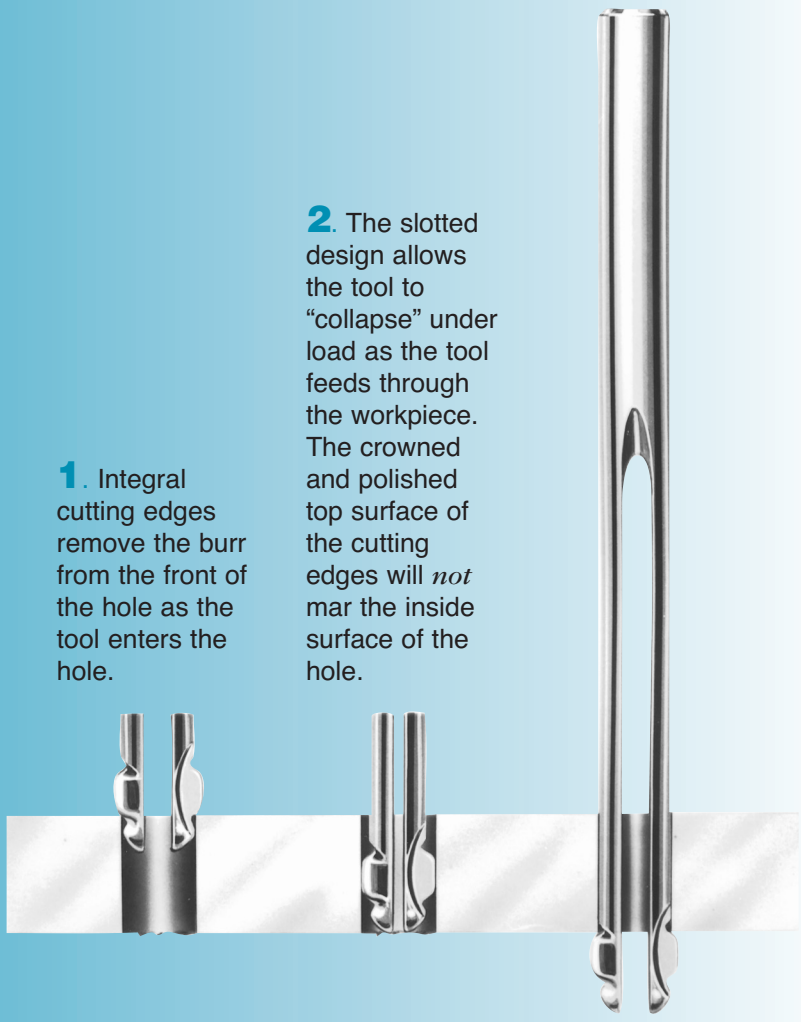
How it works

Burr-Off

1. Integral cutting edges remove the burr from the front of the hole as the tool enters the hole.

2. The slotted design allows the tool to "collapse" under load as the tool feeds through the workpiece. The crowned and polished top surface of the cutting edges will *not* mar the inside surface of the hole.

3. The back of the hole is deburred on the return stroke.



The BURR-OFF® operates on the same basic principle as the BURRAWAY®, but is designed for high-production, automated deburring operations. The open-slot design of the "clothespin tool" allows chips to clear easily, which makes the tool ideal for automatic equipment and multi-spindle machines.

Just like the BURRAWAY, the BURR-OFF deburrs the front, back, or both sides of holes in one fast pass.

Design features

The BURR-OFF® is a simple one-piece construction. The integral cutting edges can be altered upon request for front or back-cutting only.

Standard and special tool designs to suit your requirements

In addition to our standard BURR-OFF tools, custom tools are available upon request. Larger sizes, altered standards, and special designs can be supplied to suit your requirements.

Furnish a part print for a quotation, or inquire about our free trial and evaluation service.

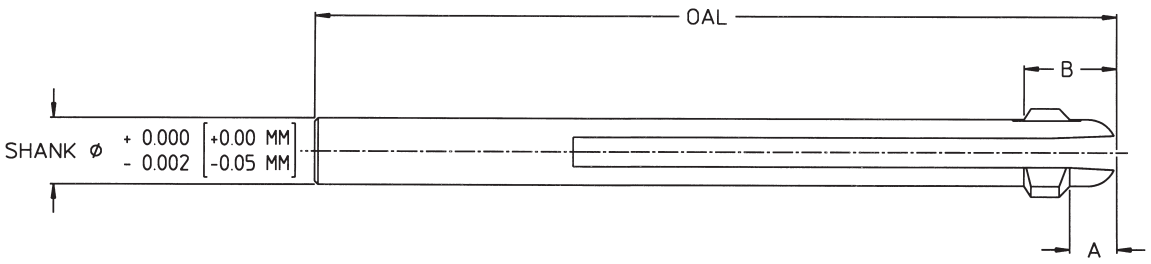
CP-4 through -13, for hole sizes from .062 inch (1.57mm) through .219 inch (5.56mm), have a single cutting edge. Larger tools feature two cutting edges.

Standard tool specifications

Burr-Off®

TOOL NUMBER	RANGE OF HOLE SIZES		SHANK DIAMETER		OVERALL LENGTH		DIM. A		DIM. B	
	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm
CP-4	.062-.078	1.57-1.98	.061	1.55	3.00	76.2	.08	2.11	.22	5.56
CP-5	.078-.094	1.98-2.39	.077	1.96	3.00	76.2	.08	2.11	.22	5.56
CP-6	.093-.109	2.36-2.77	.092	2.34	4.00	101.6	.09	2.36	.25	6.35
CP-7	.109-.125	2.77-3.17	.108	2.74	4.00	101.6	.09	2.36	.25	6.35
CP-8	.125-.140	3.17-3.55	.124	3.14	4.00	101.6	.13	3.30	.30	7.62
CP-9	.140- .156	3.55-3.96	.139	3.53	4.00	101.6	.13	3.30	.30	7.62
CP-10	.156- .172	3.96-4.36	.155	3.93	4.00	101.6	.13	3.30	.30	7.62
CP-11	.172- .187	4.36-4.74	.171	4.34	4.00	101.6	.13	3.30	.30	7.62
CP-12	.187- .203	4.74-5.15	.186	4.72	4.00	101.6	.13	3.30	.37	9.39
CP-13	.203- .219	5.15-5.56	.202	5.13	4.00	101.6	.13	3.30	.37	9.39
CP-14	.219- .234	5.56-5.94	.218	5.53	4.00	101.6	.25	6.35	.50	12.7
CP-15	.234- .250	5.94-6.35	.233	5.91	4.00	101.6	.25	6.35	.50	12.7
CP-16	.250- .266	6.35-6.75	.249	6.32	4.00	101.6	.25	6.35	.50	12.7
CP-17	.266- .281	6.75-7.13	.265	6.73	4.00	101.6	.25	6.35	.50	12.7
CP-18	.281- .297	7.13-7.54	.280	7.11	4.00	101.6	.25	6.35	.50	12.7
CP-19	.297- .313	7.54-7.95	.296	7.51	4.00	101.6	.29	7.36	.54	13.71
CP-20	.313- .328	7.95-8.33	.312	7.92	4.00	101.6	.29	7.36	.54	13.71
CP-21	.328- .343	8.33-8.71	.327	8.3	4.00	101.6	.29	7.36	.54	13.71
CP-22	.343- .359	8.71-9.11	.342	8.68	4.00	101.6	.29	7.36	.54	13.71
CP-23	.359- .375	9.11-9.52	.358	9.09	4.00	101.6	.29	7.36	.54	13.71
CP-24	.375- .390	9.52-9.9	.374	9.49	4.43	112.5	.32	8.12	.55	13.97
CP-25	.390- .406	9.9-10.31	.389	9.88	4.43	112.5	.32	8.12	.55	13.97
CP-26	.406- .422	10.31-10.71	.405	10.28	4.43	112.5	.32	8.12	.55	13.97
CP-27	.422- .437	10.71-11.09	.420	10.66	4.43	112.5	.32	8.12	.55	13.97
CP-28	.437- .453	11.09-11.5	.436	11.07	5.50	139.7	.35	8.89	.62	15.74
CP-29	.453- .468	11.5-11.88	.452	11.48	5.50	139.7	.35	8.89	.62	15.74
CP-30	.468- .484	11.88-12.29	.467	11.86	5.50	139.7	.35	8.89	.62	15.74
CP-31	.484- .500	12.29-12.7	.483	12.26	5.50	139.7	.35	8.89	.62	15.74
CP-32	.500- .515	12.7-13.08	.499	12.67	7.00	177.8	.38	9.65	.68	17.27
CP-33	.515- .531	13.08-13.48	.514	13.05	7.00	177.8	.38	9.65	.68	17.27
CP-34	.531- .547	13.48-13.89	.530	13.46	7.00	177.8	.38	9.65	.68	17.27
CP-35	.547- .563	13.89-14.3	.545	13.84	7.00	177.8	.38	9.65	.68	17.27
CP-36	.563- .578	14.3-14.68	.562	14.27	7.50	190.5	.42	10.66	.82	20.82
CP-37	.578- .594	14.68-15.08	.577	14.65	7.50	190.5	.42	10.66	.82	20.82
CP-38	.594- .609	15.08-15.46	.593	15.06	7.50	190.5	.42	10.66	.81	20.57
CP-39	.609- .625	15.46-15.87	.608	15.44	7.50	190.5	.42	10.66	.81	20.57
CP-40	.625- .641	15.87-16.28	.624	15.84	7.50	190.5	.45	11.43	.88	22.35

Tools for larger hole sizes up to 1.000 inch (25.4mm) are available; request quotation.



Tool adjustment & operating recommendations

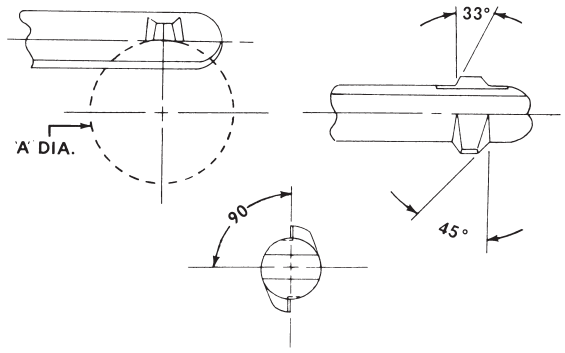
Speeds and feeds

As with BURRAWAY tools, use the same speed and feed rate as you would run a standard HSS drill.

Tool maintenance and edge resharpening

The BURR-OFF should be inspected periodically for grit and foreign particles, and cleaned as necessary.

The cutting edges may be reground up to four times in order to extend tool life. Refer to Figure 2 below for the proper regrind procedure.



TOOL SIZE	GRINDING WHEEL DIA. A	
	IN.	MM
CP-4 thru CP-11	0.62	15.7
CP-12 thru CP-27	0.75	19.1
CP-28 thru CP-35	0.87	22.1
CP-36 thru CP-40	1.25	31.7

Hand grind face .010–.015 in. (0.25mm–0.38mm), preferably with an abrasive wheel with the diameter shown in the chart (”A“ diameter). Flat face grind is optional.

Figure 2