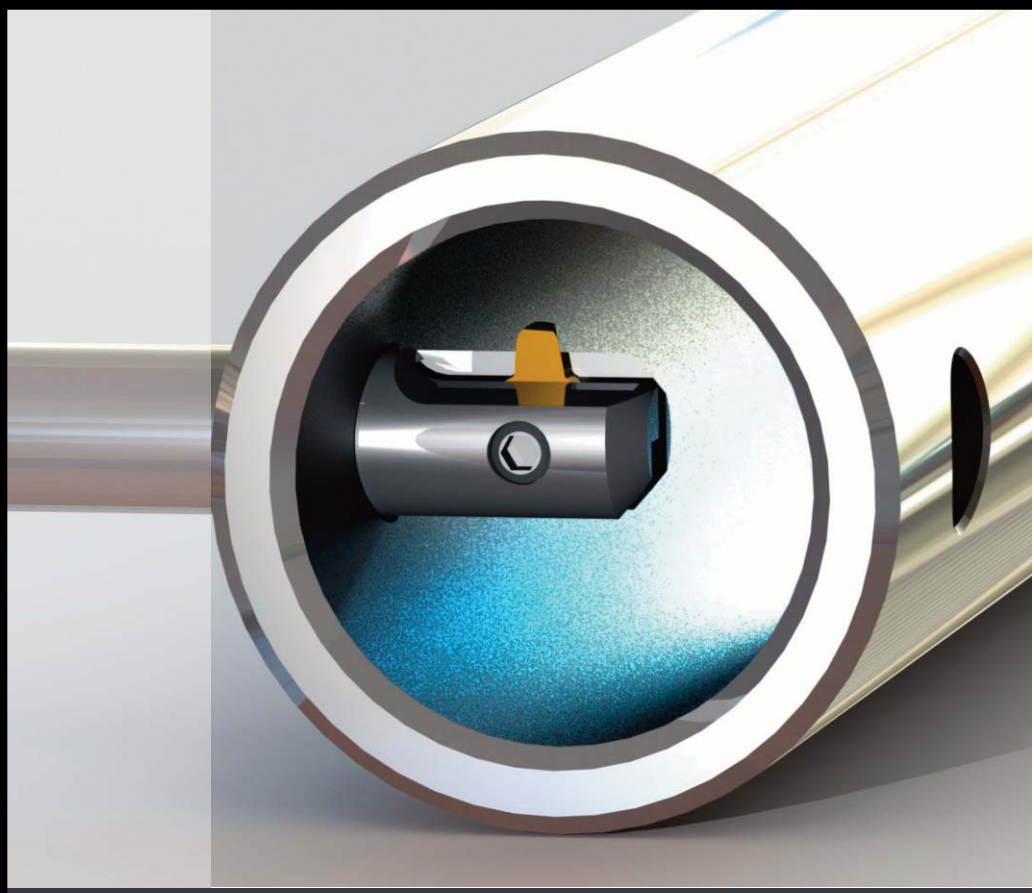
COGSDILL TOOL PRODUCTS, INC.

SEDT

Smooth Edge Deburring TOOL

Smooth Edge Deburring

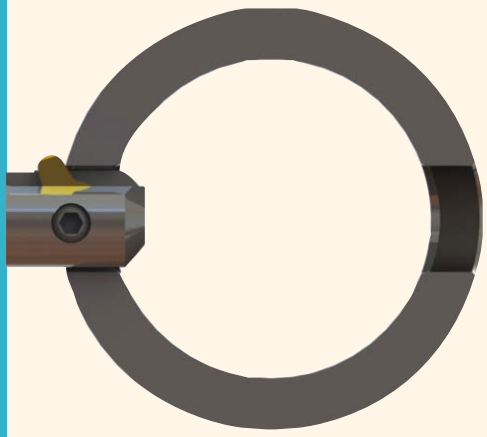


DEBURRS HOLES IN:	• FLAT SURFACES • ANGLED SURFACES • ELLIPTICAL SURFACES

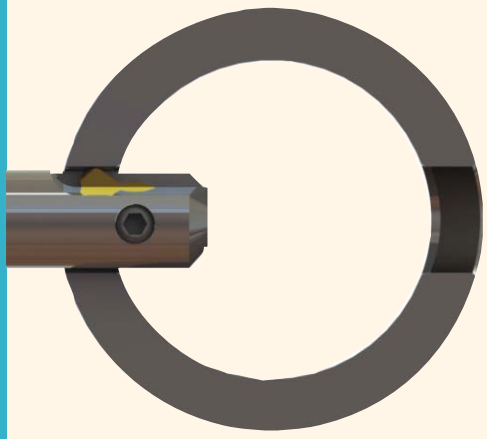
COGSDILL TOOL PRODUCTS, INC.

SEDT

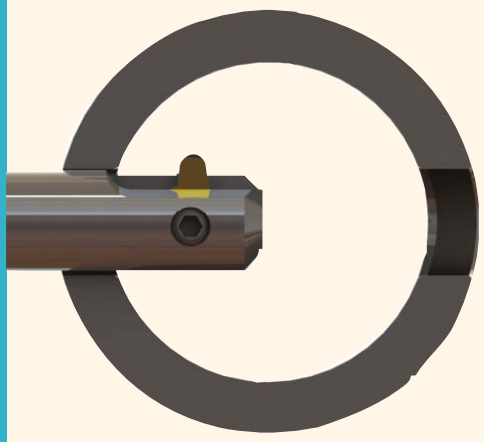
HOW IT WORKS: A ONE-PASS solution to your hole-deburring needs



1 Upon entry, spring tension holds the ***replaceable*** and ***adjustable*** cutting blade in the extended position as it removes the burr on the front of the hole.



2 As the feed load increases, the pre-set spring tension is exceeded and the blade retracts automatically as the tool passes through the workpiece. (The crowned and polished top surface of the blade will ***not*** mar the inside surface of the hole.)



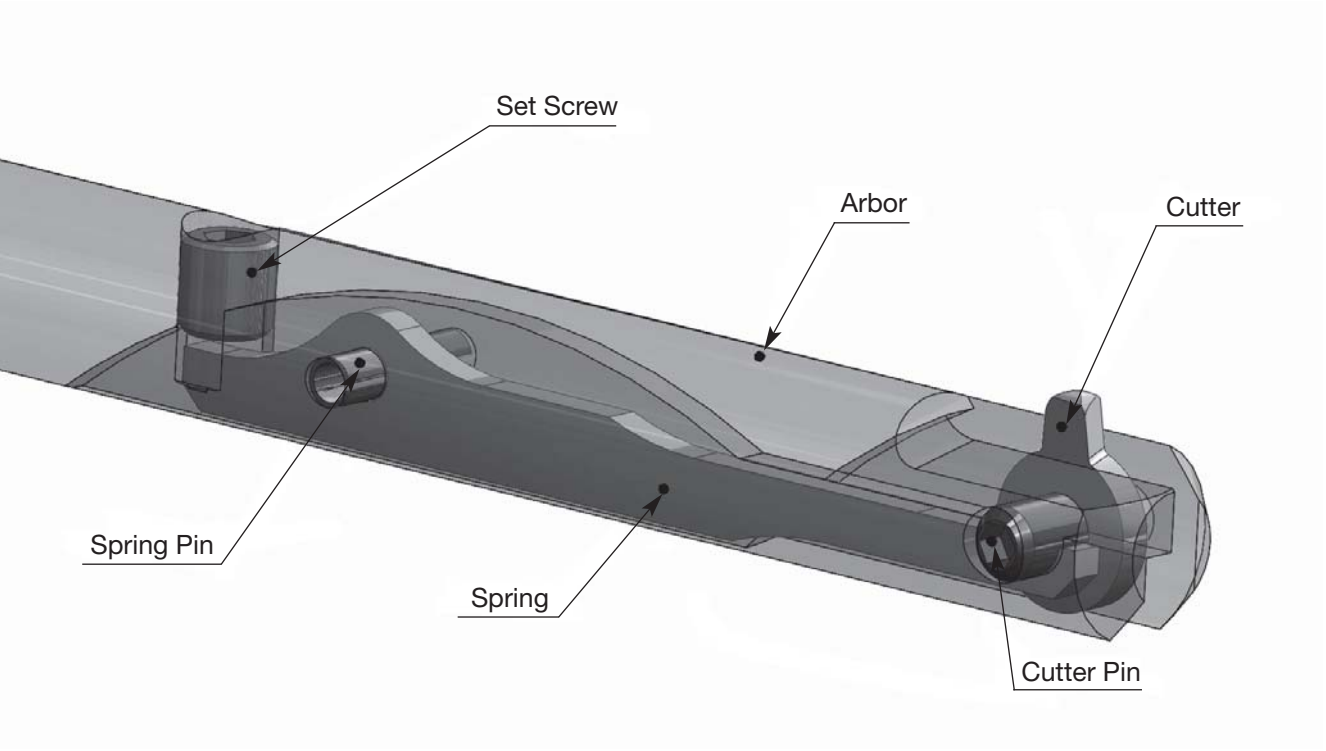
3 Spring tension again causes the blade to extend as it emerges from the ID of the part; the burr is removed on the back side of the hole on the return stroke.

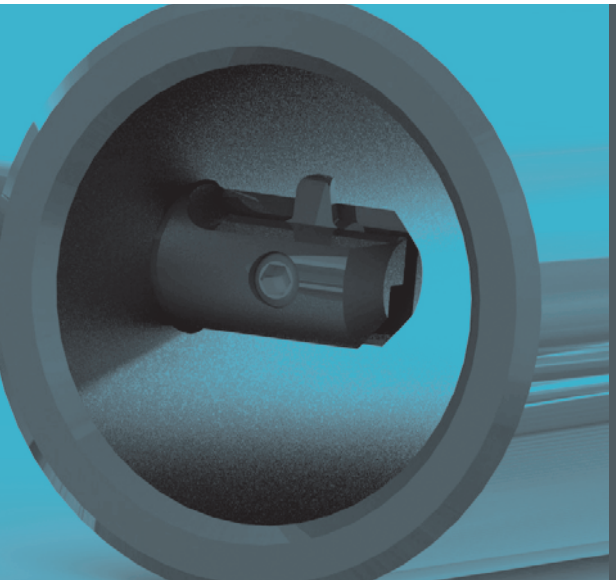
*SEDT tools are available in both **inch** and **metric** programs (see tool specifications). All tools have metric hardware and come with hex wrenches for adjustment and blade replacement. Both are available from stock at standard prices.*

SEDT tools feature an inexpensive replaceable cutting blade which adjusts to control the amount of edge break.

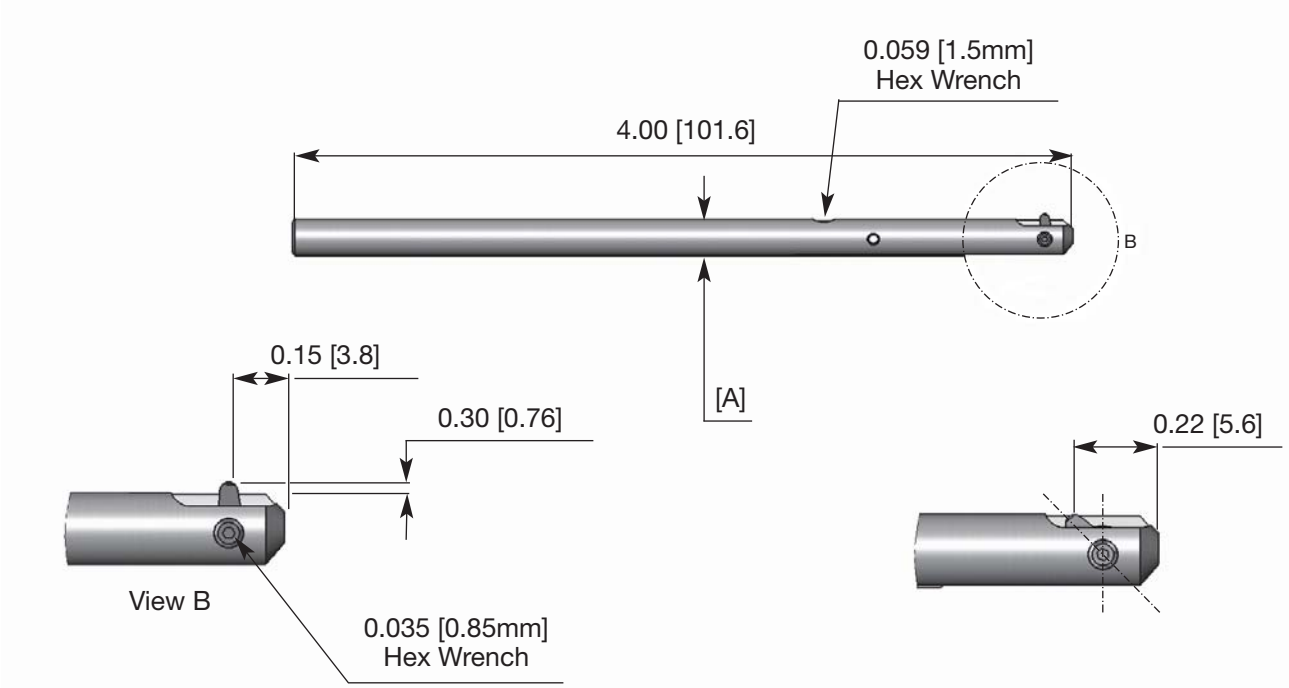
Smooth Edge Deburring Tool

SEDT basic tool design features



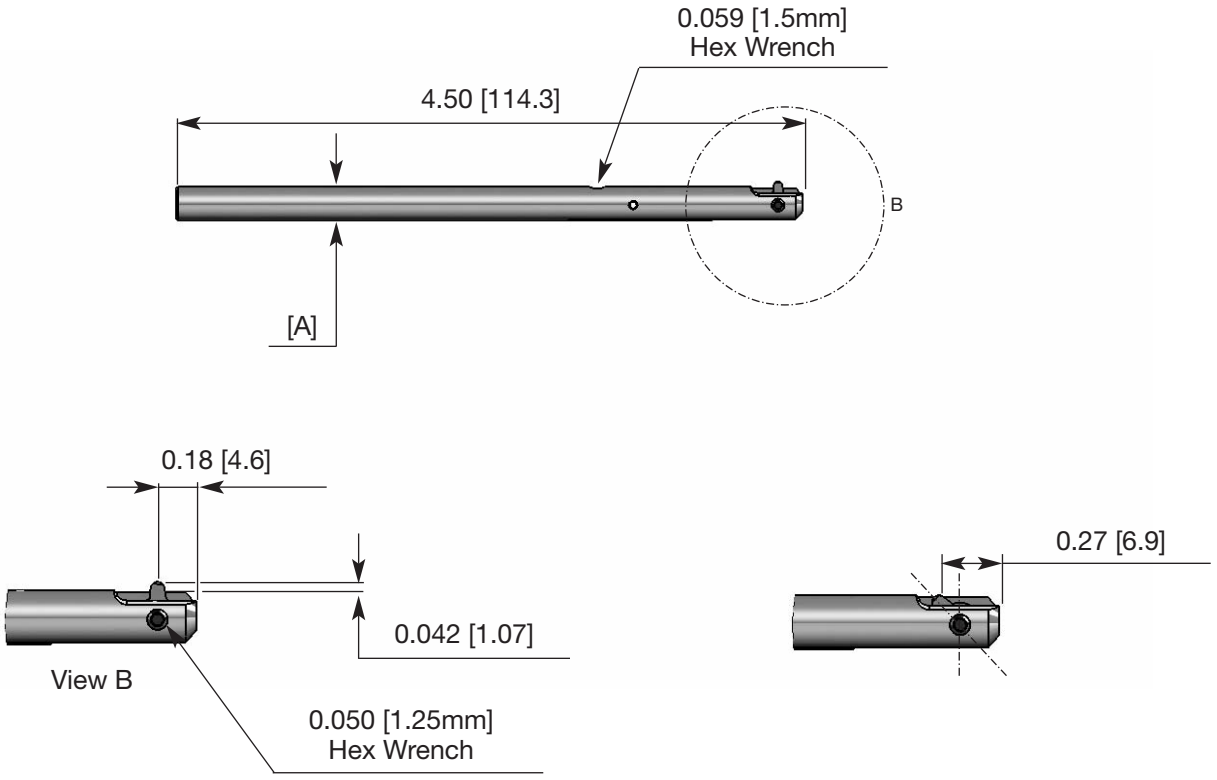


- **Deburrs holes in flat surfaces, angled surfaces, and elliptical surfaces.**
- **Size range 13/64 to 1/2 inch in 1/64 increments and 5.0 to 12.5 mm in 0.5 mm increments.**
- **Replaceable carbide blade with TiN coating as standard.**
- **4 cutters cover the entire range.**
- **Adjustable cutting load without having to remove the tool from the machine.**
- **Replaceable cutter without the need of special tools.**

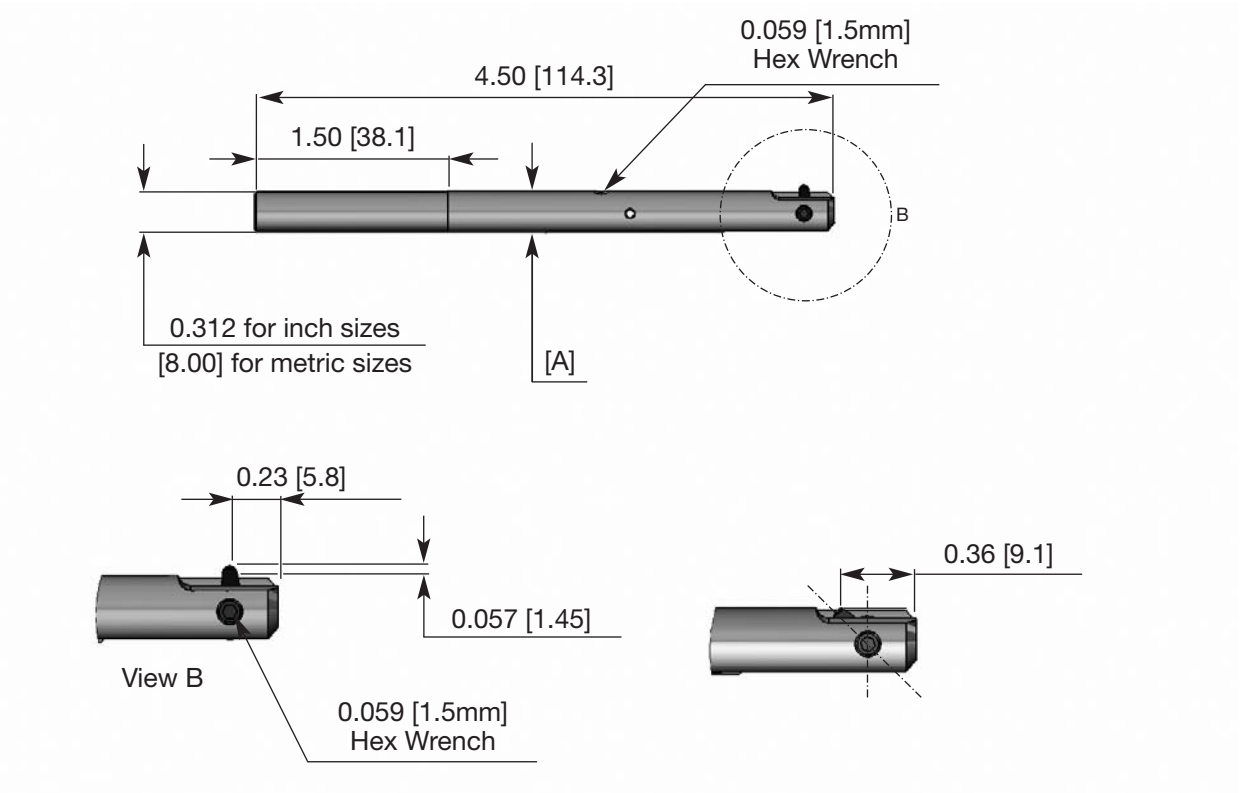


SERIES	HOLE SIZE	DECIMAL EQUIV.	COMPLETE TOOL ASSEMBLY	ARBOR DIA. [A]	ARBOR ASSEMBLY	CUTTER	CUTTER PIN	CUTTER PIN DIA.	ADJUSTING SCREW	ADJUSTING HEX WRENCH	ASSEMBLY HEX WRENCH
30	5.0 MM	0.197	SEDT-5.0M	0.194	SEDT-A5.0-ARB	SEDT-C30	SEDT-CPIN30	0.0925	M3 X 3MM LG DOG PT.	0.059" [1.5 MM]	0.050" [1.25 MM]
	13/64	0.203	SEDT-02030	0.199	SEDT-A203-ARB						
	5.5 MM	0.217	SEDT-5.5M	0.214	SEDT-A5.5-ARB						
	7/32	0.219	SEDT-02190		SEDT-A219-ARB						
	15/64	0.234	SEDT-02340	0.230	SEDT-A234-ARB						
	6.0 MM	0.236	SEDT-6.0M		SEDT-A6.0-ARB						

Series 40 SEDT

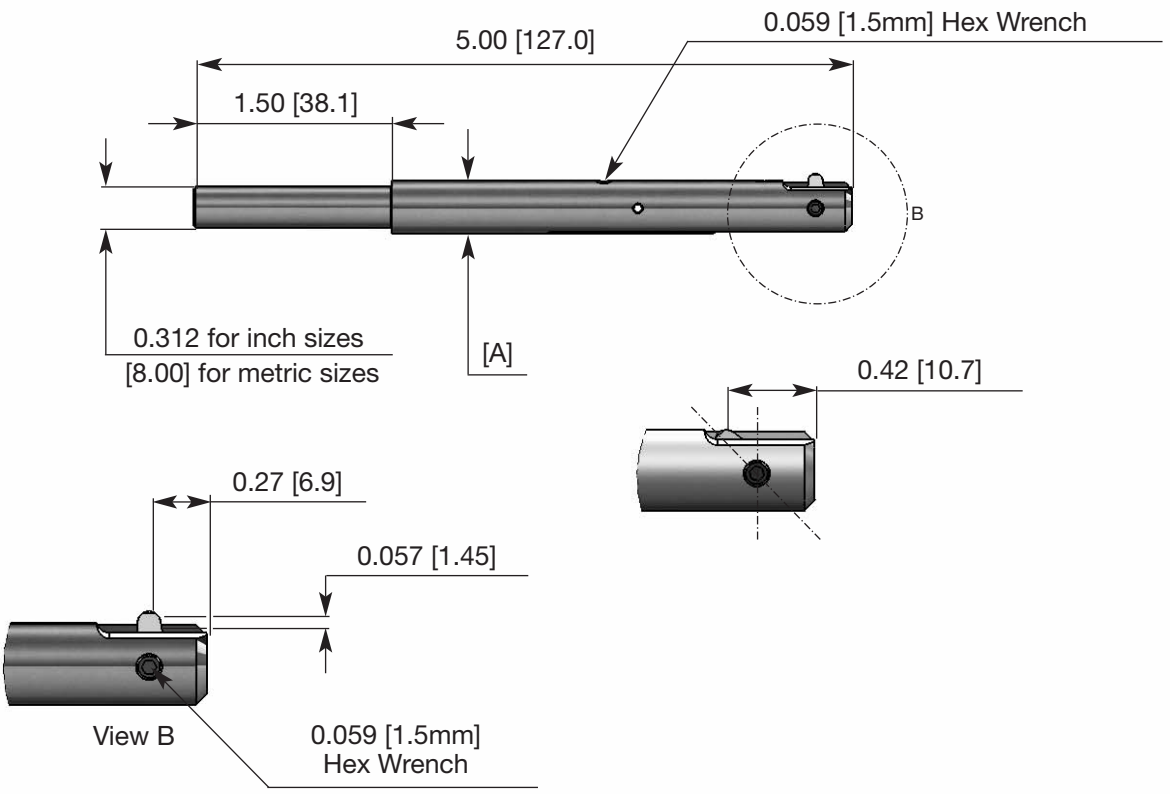


SERIES	HOLE SIZE	DECIMAL EQUIV.	COMPLETE TOOL ASSEMBLY	ARBOR DIA. [A]	ARBOR ASSEMBLY	CUTTER	CUTTER PIN	CUTTER PIN DIA.	ADJUSTING SCREW	ADJUSTING HEX WRENCH	ASSEMBLY HEX WRENCH
40	1/4	0.250	SEDT-02500	0.246	SEDT-A250-ARB	SEDT-C40	SEDT-CPIN40	0.0925	M3 X 3MM LG DOG PT.	0.059" [1.5 MM]	0.050" [1.25 MM]
	6.5 MM	0.256	SEDT-6.5M	0.252	SEDT-A6.5-ARB						
	17/64	0.266	SEDT-02660	0.262	SEDT-A266-ARB						
	7.0 MM	0.275	SEDT-7.0M	0.271	SEDT-A7.0-ARB						
	9/32	0.281	SEDT-02810	0.277	SEDT-A281-ARB						
	7.5 MM	0.295	SEDT-7.5M	0.290	SEDT-A7.5-ARB						
	19/64	0.297	SEDT-02970		SEDT-A297-ARB						
	5/16	0.313	SEDT-03130	0.306	SEDT-A313-ARB						
	8.0 MM	0.315	SEDT-8.0M		SEDT-A8.0-ARB						



SERIES	HOLE SIZE	DECIMAL EQUIV.	COMPLETE TOOL ASSEMBLY	ARBOR DIA. [A]	ARBOR ASSEMBLY	CUTTER	CUTTER PIN	CUTTER PIN DIA.	ADJUSTING SCREW	ADJUSTING HEX WRENCH	ASSEMBLY HEX WRENCH
50	21/64	0.328	SEDT-03280	0.321	SEDT-A328-ARB	SEDT-C50	SEDT-CPIN50	0.1236	M3 X 4MM LG DOG PT.	0.059" [1.5 MM]	0.059" [1.5 MM]
	8.5 MM	0.334	SEDT-8.5M	0.330	SEDT-A8.5-ARB						
	11/32	0.344	SEDT-03440	0.337	SEDT-A344-ARB						
	9.0 MM	0.354	SEDT-9.0M	0.351	SEDT-A9.0-ARB						
	23/64	0.359	SEDT-03590	0.355	SEDT-A359-ARB						
	9.5 MM	0.374	SEDT-9.5M	0.370	SEDT-A9.5-ARB						
	3/8	0.375	SEDT-03750		SEDT-A375-ARB						
	25/64	0.391	SEDT-03910	0.388	SEDT-A391-ARB						
	10 MM	0.394	SEDT-10.0M		SEDT-A10.0-ARB						

Series 60 SEDT

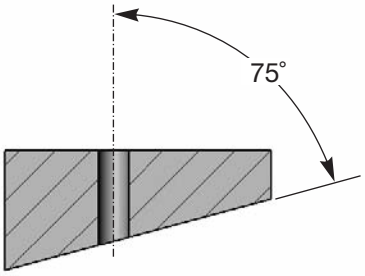


SERIES	HOLE SIZE	DECIMAL EQUIV.	COMPLETE TOOL ASSEMBLY	ARBOR DIA. [A]	ARBOR ASSEMBLY	CUTTER	CUTTER PIN	CUTTER PIN DIA.	ADJUSTING SCREW	ADJUSTING HEX WRENCH	ASSEMBLY HEX WRENCH
60	13/32	0.406	SEDT-04060	0.399	SEDT-A406-ARB	SEDT-C60	SEDT-CPIN60	0.1236	M3 X 5MM LG DOG PT.	0.059" [1.5 MM]	0.059" [1.5 MM]
	10.5 MM	0.413	SEDT-10.5M	0.409	SEDT-A10.5-ARB						
	27/64	0.422	SEDT-04220	0.418	SEDT-A422-ARB						
	11.0 MM	0.433	SEDT-11.0M	0.429	SEDT-A11.0-ARB						
	7/16	0.438	SEDT-04380	0.434	SEDT-A438-ARB						
	11.5 MM	0.452	SEDT-11.5M	0.447	SEDT-A11.5-ARB						
	29/64	0.453	SEDT-04530		SEDT-A453-ARB						
	15/32	0.469	SEDT-04690	0.466	SEDT-A469-ARB						
	12.0 MM	0.472	SEDT-12.0M		SEDT-A12.0-ARB						
	31/64	0.484	SEDT-04840	0.480	SEDT-A484-ARB						
	12.5 MM	0.492	SEDT-12.5M	0.488	SEDT-A12.5-ARB						
	1/2	0.500	SEDT-05000	0.496	SEDT-A500-ARB						

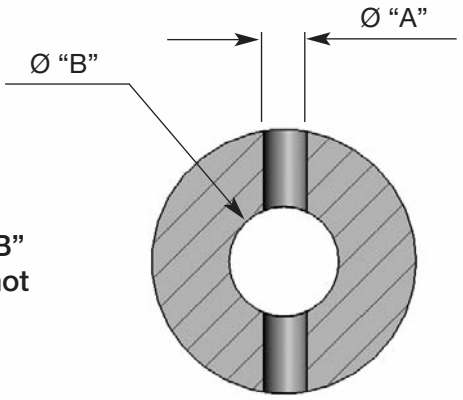
Operating parameters

SEDT

MATERIAL	CUTTING SPEED		FEED RATE	
	S.F.M.	M/MIN	IN/REV	MM/REV
LOW CARBON STEEL	200-300	65-100	0.012	0.30
ALLOY STEEL	120-180	40-60	0.012	0.30
STAINLESS STEEL	80-150	25-50	0.008	0.20
GREY & NODULAR CAST IRON	100-200	30-65	0.010	0.25
ALUMINUM	200-350	65-115	0.014	0.35
TITANIUM	20-60	6-20	0.008	0.20



Surface incline should not exceed 75°



Maximum ratio of mainbore "B" to the cross hole "A" should not be less than 2:1

Blade replacement & tool adjustment

SEDT

Cutter removal

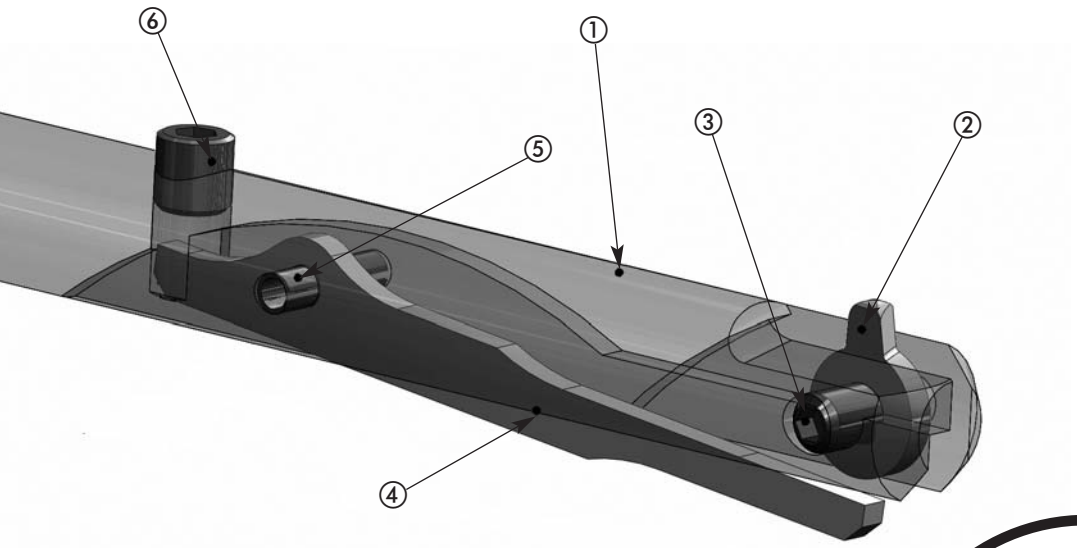
- Loosen Adjusting Set Screw (Detail 6) so that the Spring (Detail 4) can be rotated down pivoting on Spring Pin (Detail 5).
- Using Cutter Pin (Detail 3) hex wrench, push Cutter Pin (Detail 3) out of the Arbor (Detail 1) in the direction from bottom of Cutter to top of Cutter.
- Cutter (Detail 2) and Cutter Pin (Detail 3) are now removed from the Arbor (Detail 1).

Cutter assembly

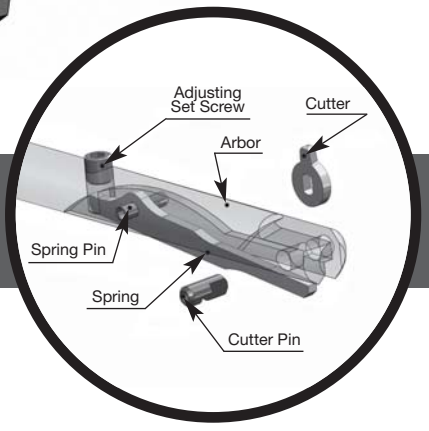
- Spring (Detail 4) should be loose and slightly below Arbor (Detail 1) outside diameter.
- Using the Cutter Pin (Detail 3) hex wrench as an assembly aid, insert Cutter into Arbor (Detail 1) slot noting that the cutting edge should be opposite the Spring. Note that the bottom of the cutter is not coated as an aid in tool assembly. Align the slot in the Cutter with the Cutter Pin hole in the Arbor.
- Using the Cutter Pin hex wrench as an assembly tool, insert the hex wrench in the Cutter Pin hex and carefully assemble the Cutter Pin into the Arbor. Note that the slot in the Cutter Pin should be aligned with the Spring. Use the hex wrench to slightly rotate the Cutter Pin until the Cutter Pin engages with the Cutter.
- Adjust the Adjusting Set Screw (Detail 6) to engage the Spring with the Cutter.

Tool adjustment

- Rotate the Adjusting Set Screw (Detail 6) slightly in either direction to increase or decrease the spring pressure on the Cutter. Slight adjustment may be required based on size of the burr to be removed and the toughness of the material to be deburred.



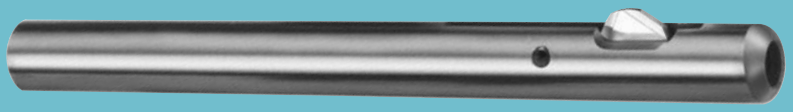
SHOWN WITH CUTTER AND CUTTER PIN REMOVED



Notes

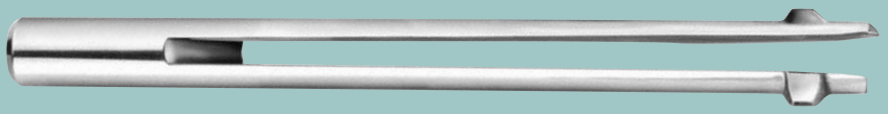
Other deburring & chamfering products

FROM ***COGSDILL TOOL PRODUCTS, INC.***



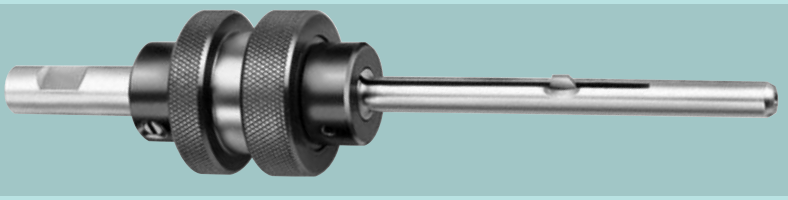
BURRAWAY

BURR-OFF



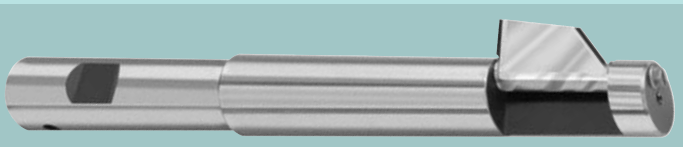
ELLIPTI-BUR

NOBUR TOOL



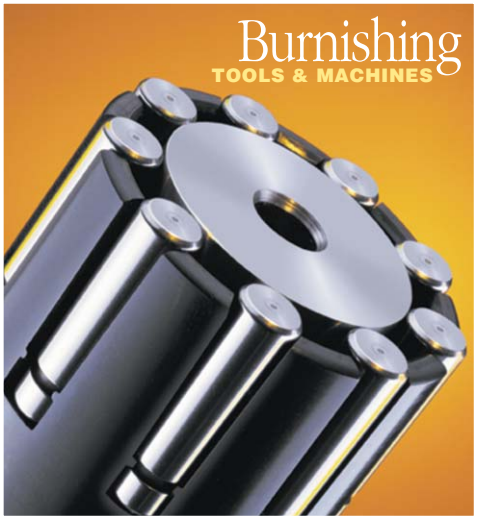
NOBUR JB

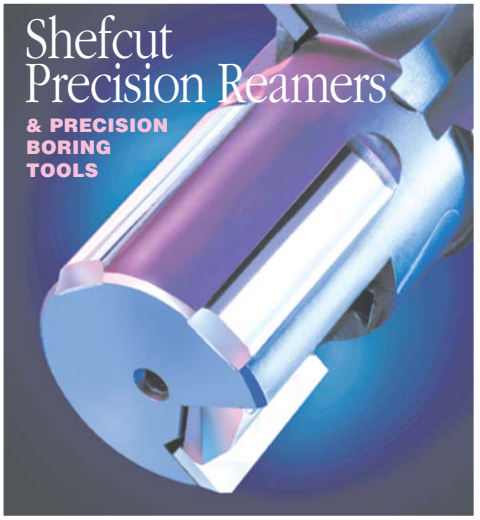
FLIPCUT

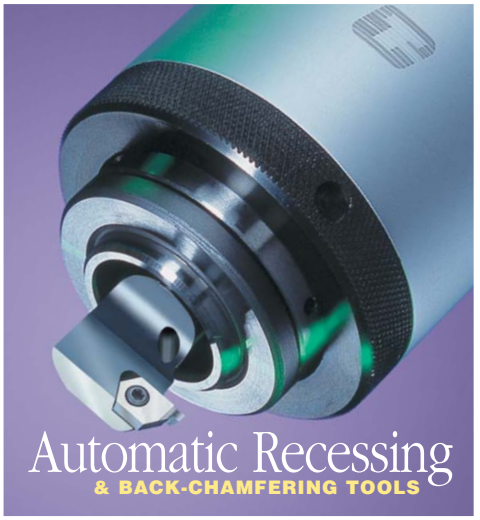


visit us at: www.cogsdill.com

OTHER PRODUCTS FROM COGSDILL TOOL PRODUCTS, INC.







COGSDILL TOOL PRODUCTS, INC.
Mailing Address
P.O. Box 7007
Camden, SC USA 29021-7007
Ph. (803) 438-4000
Fax (803) 438-5263
www.cogsdill.com
cogsdill@cogsdill.com

Shipping Address
1001 Guion Drive
Lugoff, SC 29078

COGSDILL-NUNEATON LTD.
Tenlons Road
Nuneaton, England CV10 7HR
Ph. +44 (0) 2476 383792
Fax +44 (0) 2476 344433
www.cogsdill.co.uk
sales@cogsdill.co.uk

FOR ADDITIONAL INFORMATION

Visit us online www.cogsdill.com

CATALOG NO. 150 U.S. 06-13