

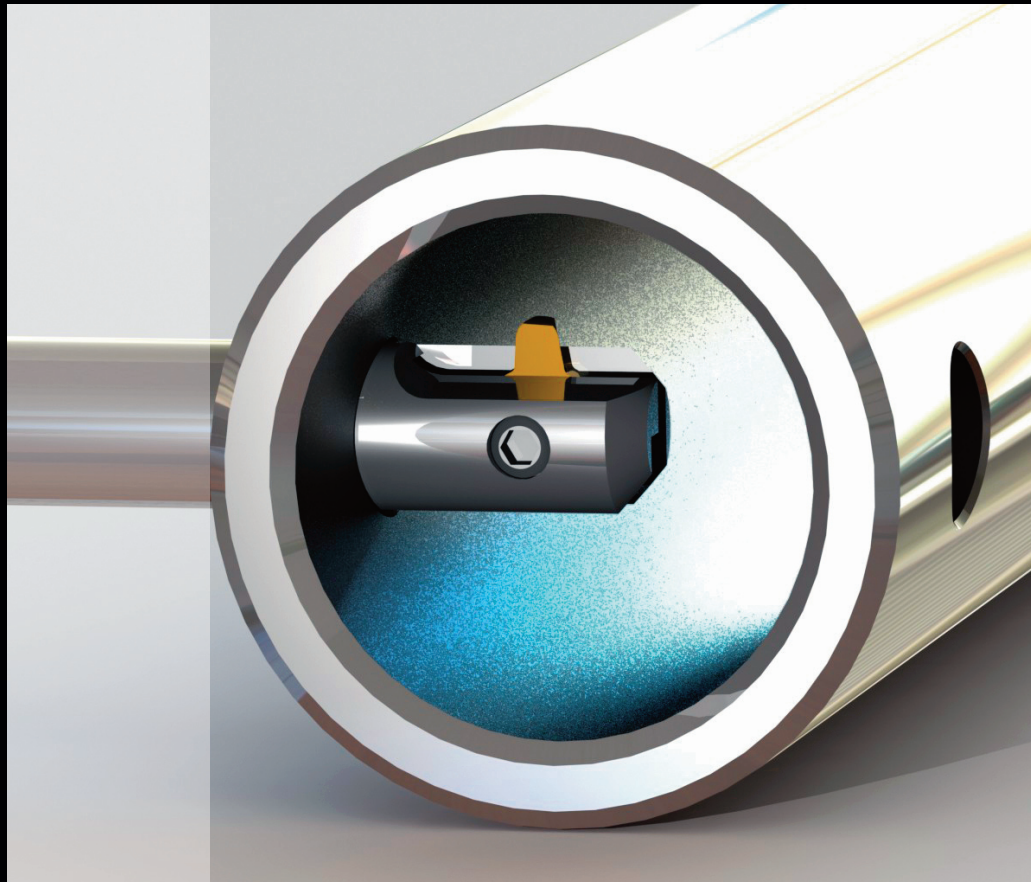


COGSDILL TOOL PRODUCTS, INC.

SED

■ **Smooth Edge
Deburring TOOL**

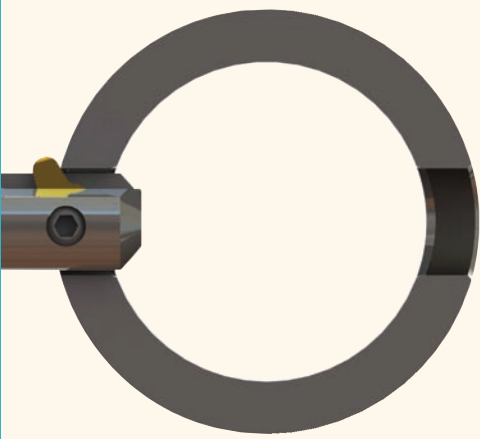
Smooth Edge Deburring



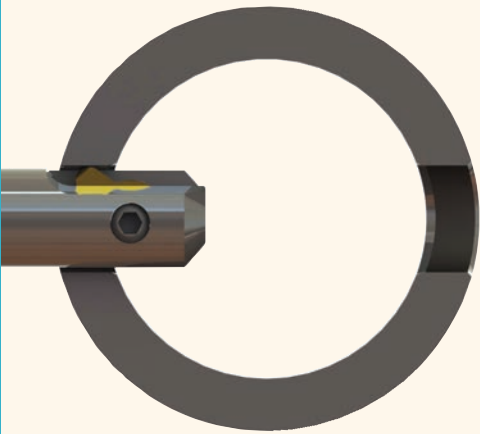
**DEBURRS
HOLES IN:**

• FLAT SURFACES • ANGLED SURFACES • ELLIPTICAL SURFACES

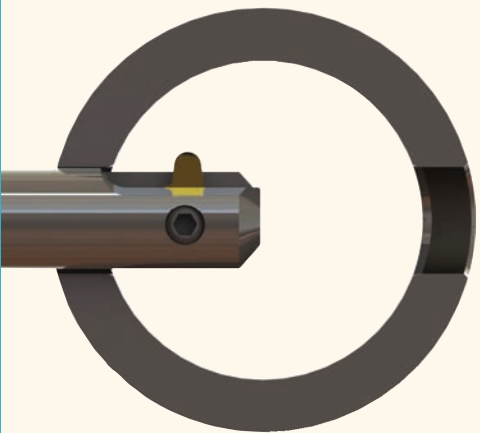
HOW IT WORKS: A ONE-PASS solution to your hole-deburring needs



- 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.

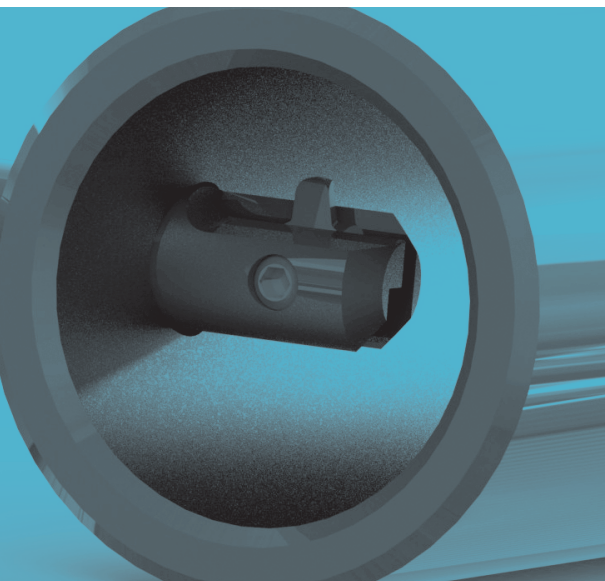
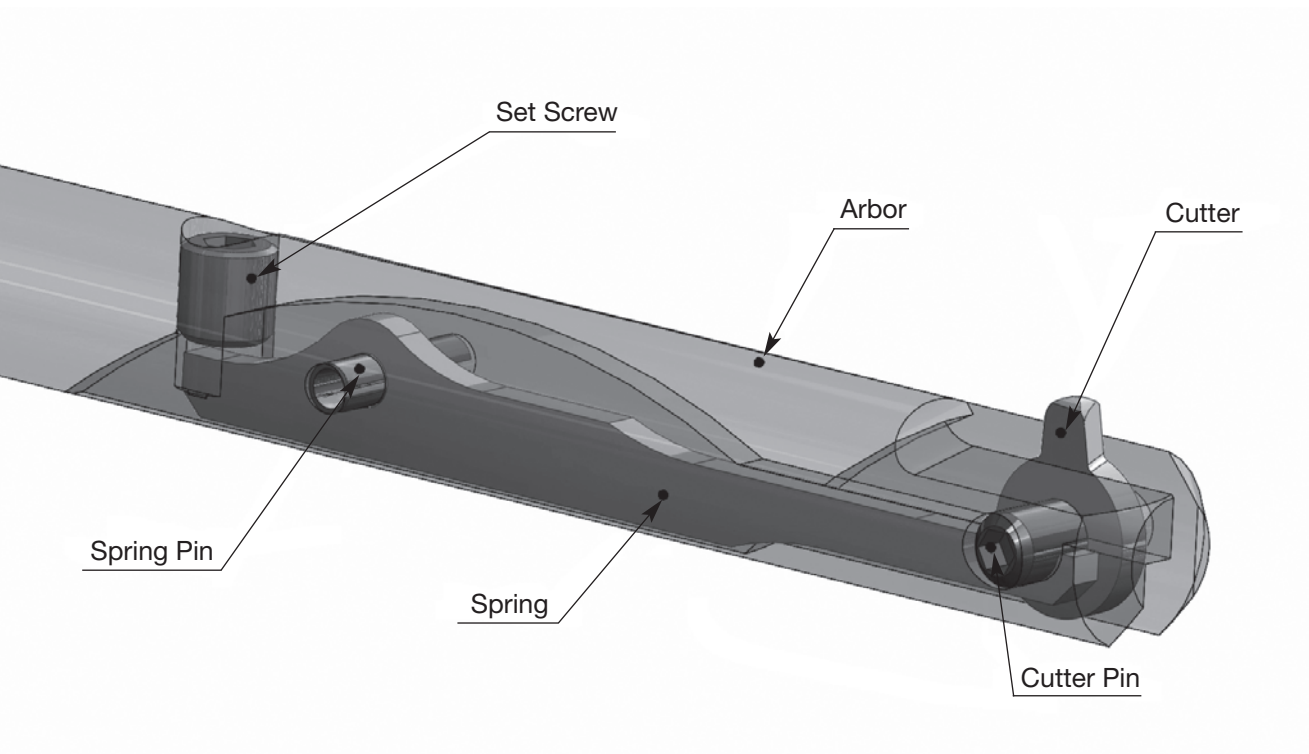
SED tools are available in both *inch* and *metric* programs (see tool specifications). All tools have metric hardware and come with hex wrenches for adjustment and blade replacement. Both are available from stock at standard prices.



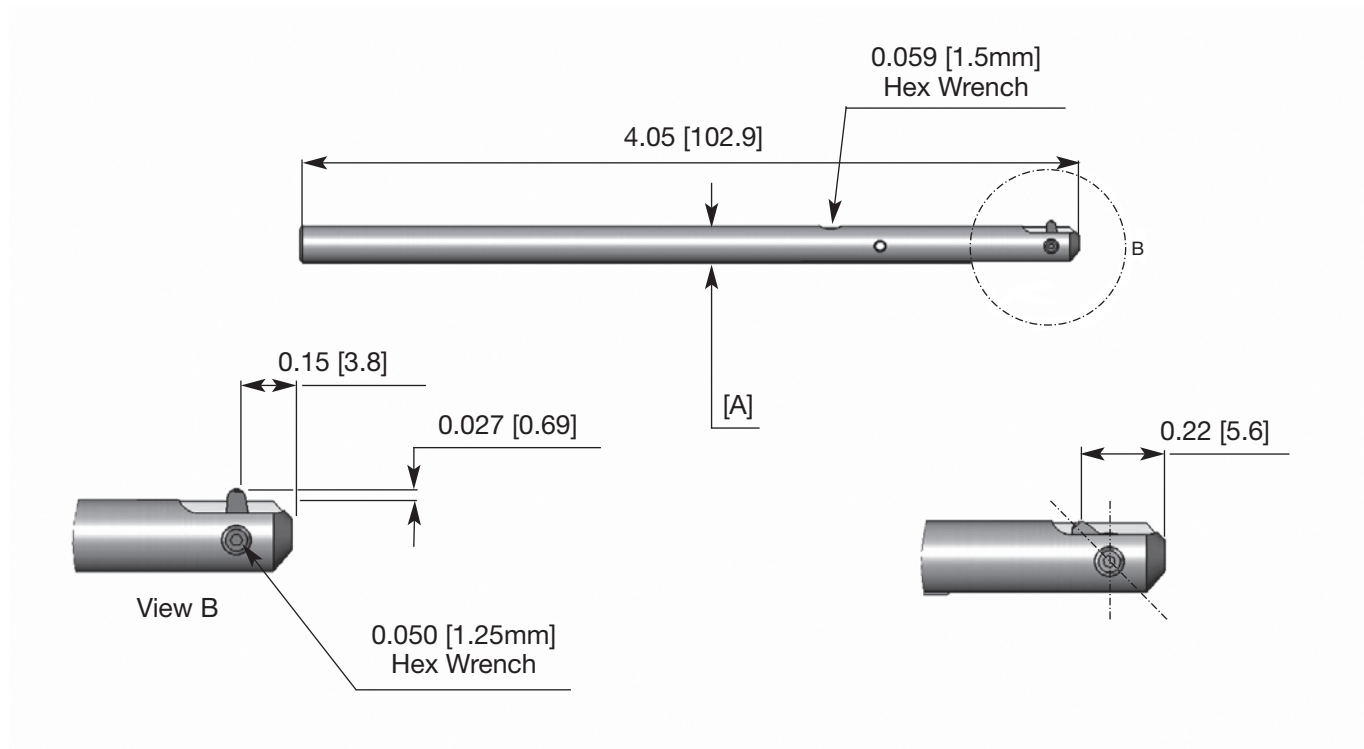
SED tools feature an inexpensive replaceable cutting blade which adjusts to control the amount of edge break.

Smooth Edge Deburring Tool

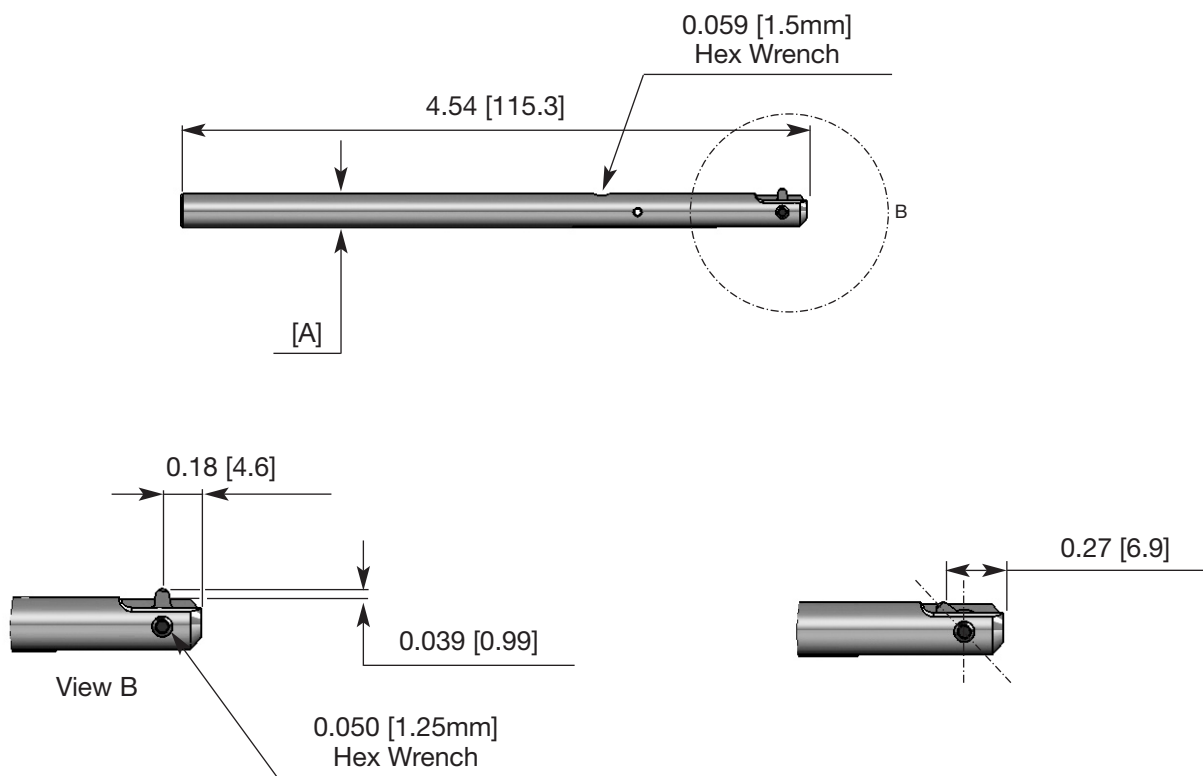
SEDT basic tool design features



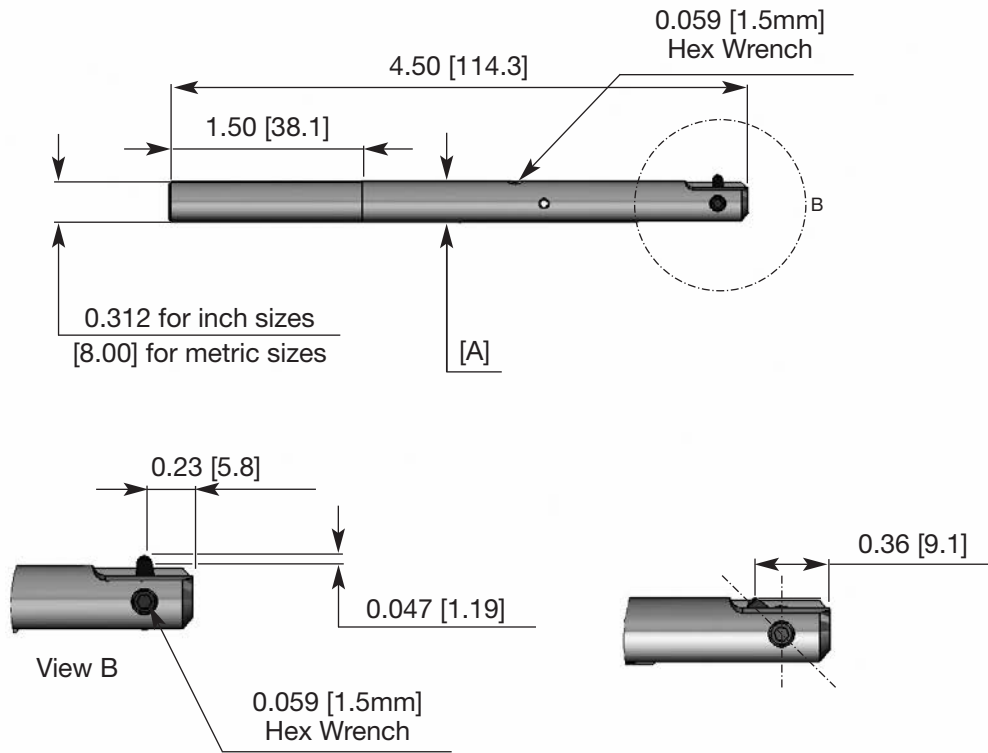
- Deburrs holes in flat surfaces, angled surfaces, and elliptical surfaces.
- Size range 13/64 to 1/2 inch in 1/64 increments and 5.0 to 12.5 mm in 0.5 mm increments.
- Replaceable carbide blade with TiN coating as standard.
- 4 cutters cover the entire range.
- Adjustable cutting load without having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



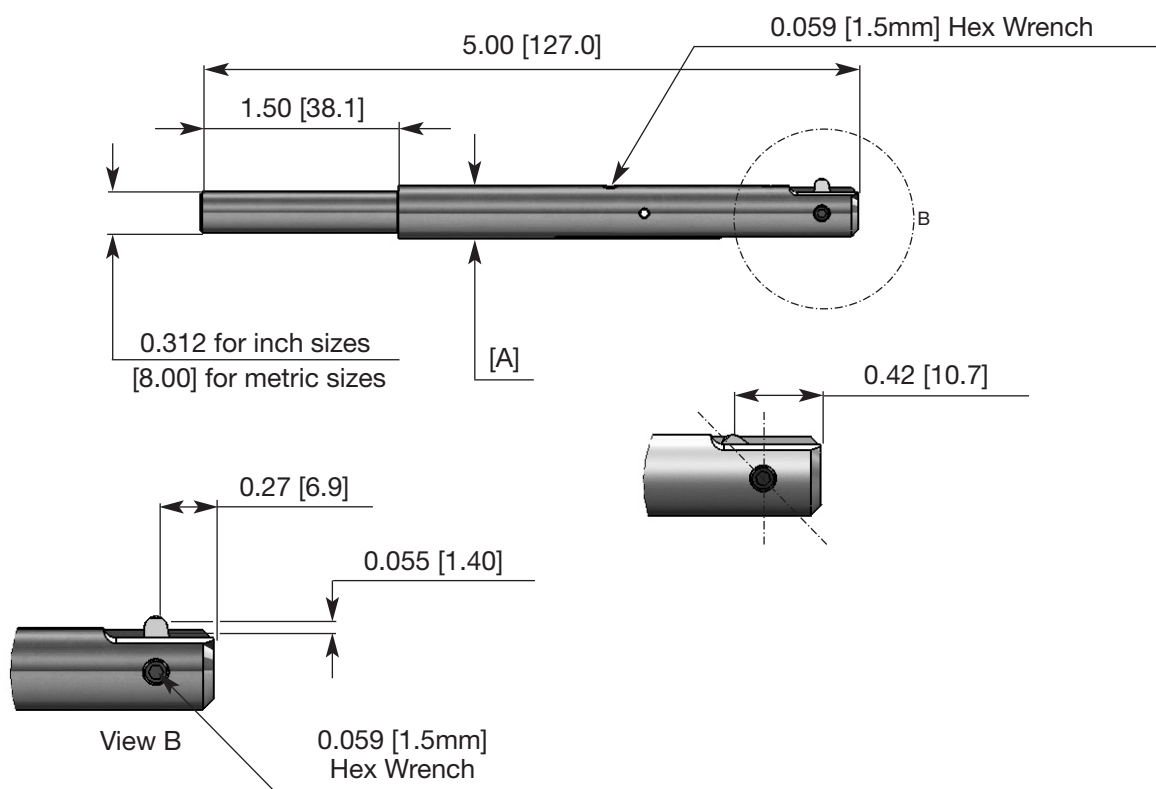
| SERIES | HOLE SIZE | DECIMAL EQUIV. | COMPLETE TOOL ASSEMBLY | ARBOR DIA. [A] | ARBOR ASSEMBLY | CUTTER | CUTTER PIN | CUTTER PIN DIA. | ADJUSTING SCREW | ADJUSTING HEX WRENCH | ASSEMBLY HEX WRENCH |
|--------|-----------|----------------|------------------------|----------------|----------------|----------|-------------|-----------------|---------------------|----------------------|---------------------|
| 30 | 5.0 MM | 0.197 | SEDТ-5.0M | 0.194 | SEDТ-A5.0-ARB | SEDТ-C30 | SEDТ-CPIN30 | 0.090 | M3 X 3MM LG DOG PT. | 0.059" [1.5 MM] | 0.050" [1.25 MM] |
| | 13/64 | 0.203 | SEDТ-02030 | 0.199 | SEDТ-A203-ARB | | | | | | |
| | 5.5 MM | 0.217 | SEDТ-5.5M | 0.214 | SEDТ-A5.5-ARB | | | | | | |
| | 7/32 | 0.219 | SEDТ-02190 | | SEDТ-A219-ARB | | | | | | |
| | 15/64 | 0.234 | SEDТ-02340 | 0.231 | SEDТ-A234-ARB | | | | | | |
| | 6.0 MM | 0.236 | SEDТ-6.0M | | SEDТ-A6.0-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 |
|--------|-----------|----------------|------------------------|----------------|----------------|---------|------------|-----------------|---------------------|----------------------|---------------------|
| 40 | 1/4 | 0.250 | SED | 0.246 | SED-A250-ARB | SED-C40 | SED-CPIN40 | 0.092 | M3 X 3MM LG DOG PT. | 0.059" [1.5 MM] | 0.050" [1.25 MM] |
| | 6.5 MM | 0.256 | SED-6.5M | 0.252 | SED-A6.5-ARB | | | | | | |
| | 17/64 | 0.266 | SED-02660 | 0.262 | SED-A266-ARB | | | | | | |
| | 7.0 MM | 0.275 | SED-7.0M | 0.271 | SED-A7.0-ARB | | | | | | |
| | 9/32 | 0.281 | SED-02810 | 0.277 | SED-A281-ARB | | | | | | |
| | 7.5 MM | 0.295 | SED-7.5M | 0.290 | SED-A7.5-ARB | | | | | | |
| | 19/64 | 0.297 | SED-02970 | | SED-A297-ARB | | | | | | |
| | 5/16 | 0.313 | SED-03130 | 0.306 | SED-A313-ARB | | | | | | |
| | 8.0 MM | 0.315 | SED-8.0M | | SED-A8.0-ARB | | | | | | |

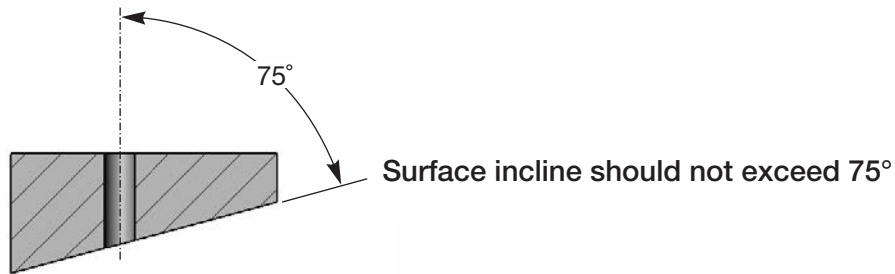


| SERIES | HOLE SIZE | DECIMAL EQUIV. | COMPLETE TOOL ASSEMBLY | ARBOR DIA. [A] | ARBOR ASSEMBLY | CUTTER | CUTTER PIN | CUTTER PIN DIA. | ADJUSTING SCREW | ADJUSTING HEX WRENCH | ASSEMBLY HEX WRENCH |
|--------|-----------|----------------|------------------------|----------------|----------------|---------|------------|-----------------|---------------------|----------------------|---------------------|
| 50 | 21/64 | 0.328 | SED-03280 | 0.321 | SED-A328-ARB | SED-C50 | SED-CPIN50 | 0.123 | M3 X 3MM LG DOG PT. | 0.059" [1.5 MM] | 0.059" [1.5 MM] |
| | 8.5 MM | 0.334 | SED-8.5M | 0.328 | SED-A8.5-ARB | | | | | | |
| | 11/32 | 0.344 | SED-03440 | 0.337 | SED-A344-ARB | | | | | | |
| | 9.0 MM | 0.354 | SED-9.0M | 0.351 | SED-A9.0-ARB | | | | | | |
| | 23/64 | 0.359 | SED-03590 | 0.355 | SED-A359-ARB | | | | | | |
| | 9.5 MM | 0.374 | SED-9.5M | 0.370 | SED-A9.5-ARB | | | | | | |
| | 3/8 | 0.375 | SED-03750 | | SED-A375-ARB | | | | | | |
| | 25/64 | 0.391 | SED-03910 | 0.388 | SED-A391-ARB | | | | | | |
| | 10 MM | 0.394 | SED-10.0M | | SED-A10.0-ARB | | | | | | |

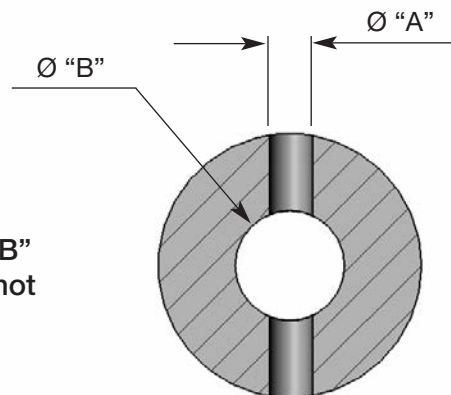


| SERIES | HOLE SIZE | DECIMAL EQUIV. | COMPLETE TOOL ASSEMBLY | ARBOR DIA. [A] | ARBOR ASSEMBLY | CUTTER | CUTTER PIN | CUTTER PIN DIA. | ADJUSTING SCREW | ADJUSTING HEX WRENCH | ASSEMBLY HEX WRENCH |
|--------|-----------|----------------|------------------------|----------------|----------------|---------|------------|-----------------|---------------------|----------------------|---------------------|
| 60 | 13/32 | 0.406 | SED-04060 | 0.399 | SED-A406-ARB | SED-C60 | SED-CPIN60 | 0.123 | M3 X 3MM LG DOG PT. | 0.059" [1.5 MM] | 0.059" [1.5 MM] |
| | 10.5 MM | 0.413 | SED-10.5M | 0.409 | SED-A10.5-ARB | | | | | | |
| | 27/64 | 0.422 | SED-04220 | 0.418 | SED-A422-ARB | | | | | | |
| | 11.0 MM | 0.433 | SED-11.0M | 0.429 | SED-A11.0-ARB | | | | | | |
| | 7/16 | 0.438 | SED-04380 | 0.434 | SED-A438-ARB | | | | | | |
| | 11.5 MM | 0.452 | SED-11.5M | 0.447 | SED-A11.5-ARB | | | | | | |
| | 29/64 | 0.453 | SED-04530 | | SED-A453-ARB | | | | | | |
| | 15/32 | 0.469 | SED-04690 | 0.466 | SED-A469-ARB | | | | | | |
| | 12.0 MM | 0.472 | SED-12.0M | | SED-A12.0-ARB | | | | | | |
| | 31/64 | 0.484 | SED-04840 | 0.480 | SED-A484-ARB | | | | | | |
| | 12.5 MM | 0.492 | SED-12.5M | 0.488 | SED-A12.5-ARB | | | | | | |
| | 1/2 | 0.500 | SED-05000 | 0.496 | SED-A500-ARB | | | | | | |

| 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 |



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



Cutter removal

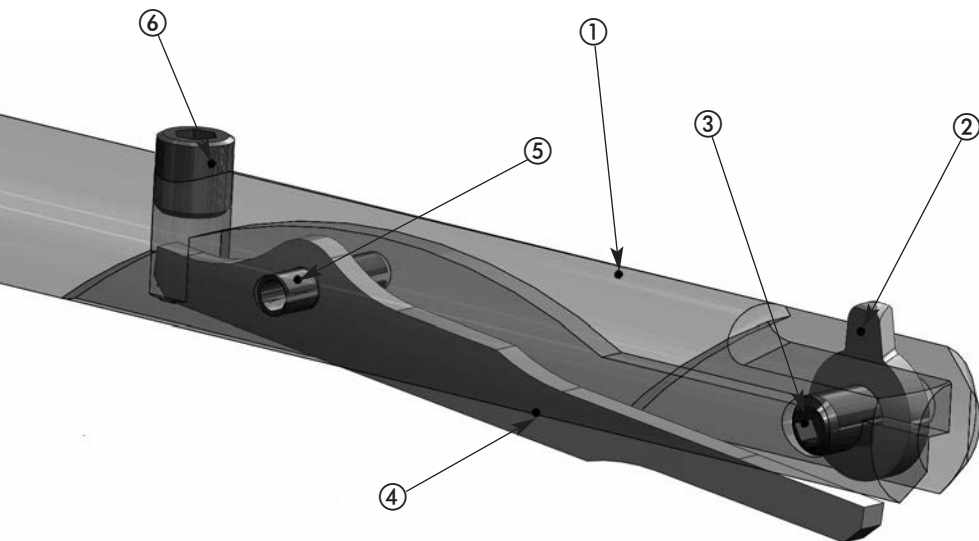
- Loosen Adjusting Set Screw (Detail 6) so that the Spring (Detail 4) can be rotated down pivoting on Spring Pin (Detail 5).
- Using Cutter Pin (Detail 3) hex wrench, push Cutter Pin (Detail 3) out of the Arbor (Detail 1) in the direction from bottom of Cutter to top of Cutter.
- Cutter (Detail 2) and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

Cutter assembly

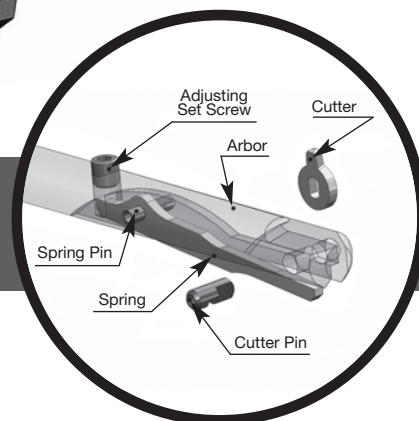
- Spring (Detail 4) should be loose and slightly below Arbor (Detail 1) outside diameter.
- Using the Cutter Pin (Detail 3) hex wrench as an assembly aid, insert Cutter into Arbor (Detail 1) slot noting that the cutting edge should be opposite the Spring. Note that the bottom of the cutter is not coated 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.

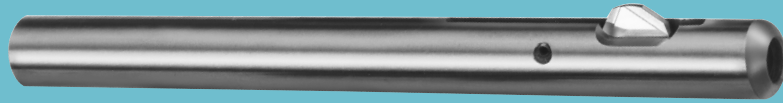


SHOWN WITH CUTTER AND CUTTER PIN REMOVED



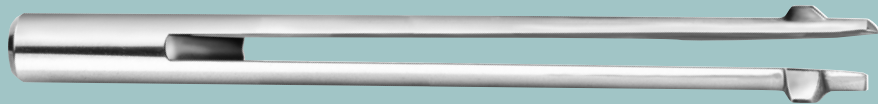
Other deburring & chamfering products

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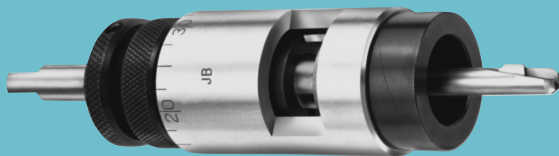
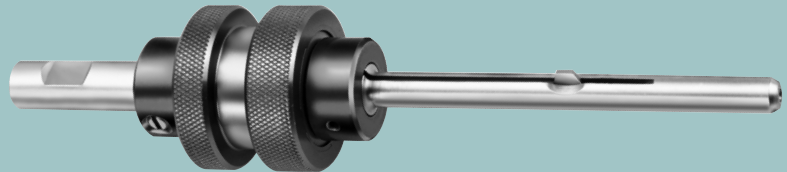
BURRAWAY

BURR-OFF



ELLIPTI-BUR

NOBUR TOOL

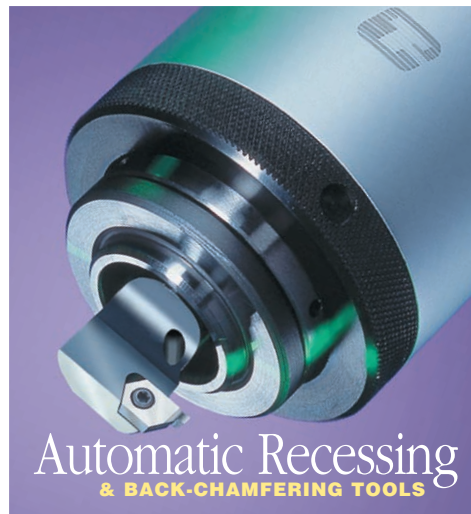
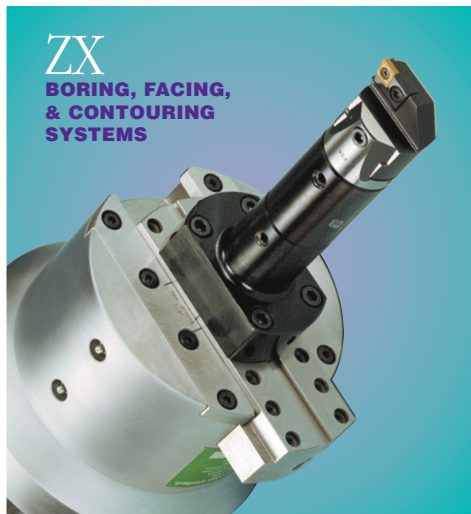
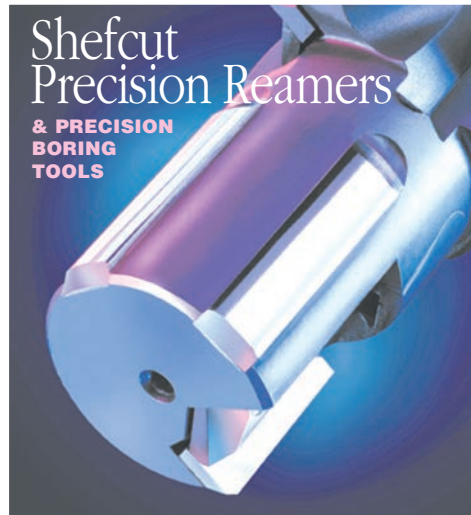
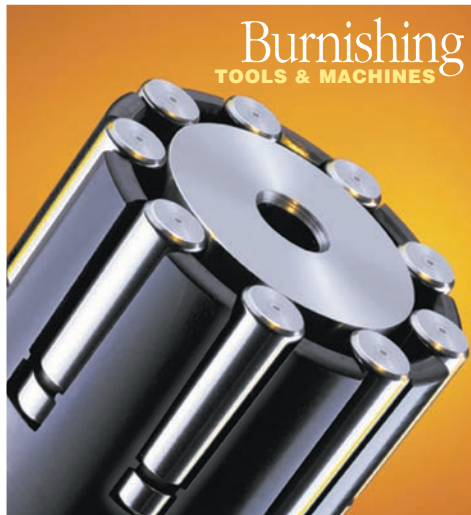


NOBUR JB

FLIPCUT



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