

Operating Instructions

Burr-Off®

Tool adjustment & operating recommendations

Fast and easy adjustment

The amount of edge break will vary with the hardness of the material. Loosen the screw on the sliding tension-adjustment mechanism and move it up or down the length of the slot for more or less stock removal.

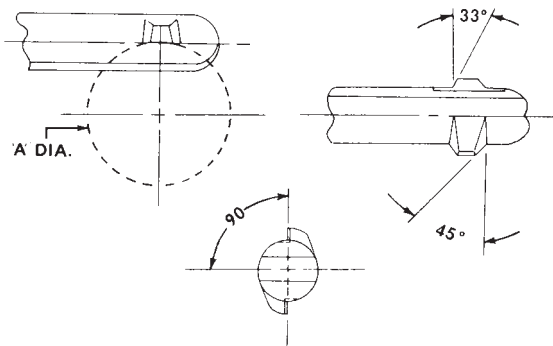
Speeds and feeds

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

Tool maintenance and edge resharpener

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

The cutting edges may be re-ground 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-8 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



COGSDILL TOOL

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