



CUTTING DATA FOR ROTARY BURRS

Material		Machining	No.	Vc [m/min]		
Steel and cast steel materials	unhardened, not pre-toughened steel < 1.200 N/mm ² (<35 HRC)	roughing	V 72223	350 - 500		
			V 72224	350 - 500		
			V 72243	350 - 500		
			V 72244	350 - 500		
		finishing	V 72226	500 - 600		
			V 72246	500 - 600		
	hardened, quenched and tempered steel resistant to rust and acid > 1,200 N/mm ² (>35 HRC)	tool steel, tempering steel, alloyed steel, cast steel, austenitic and ferritic steel	roughing	V 72223	200 - 300	
				V 72224	200 - 300	
			finishing	V 72243	200 - 300	
				V 72244	200 - 300	
Cast iron materials	grey cast iron, ductile iron	roughing	V 72223	400 - 500		
			V 72224	400 - 500		
			V 72243	400 - 500		
			V 72244	400 - 500		
		finishing	V 72226	500 - 600		
			V 72246	500 - 600		
			V 72274	500 - 600		
			V 72276	500 - 600		
Non-ferrous metals	soft, non-ferrous metals	Aluminium alloys, brass, zinc, copper	roughing	V 72259	600 - 900	
	hard, non-ferrous metals			titanium, titanium alloys, bronze, nickel alloys	finishing	V 72226
			V 72246			350 - 450
	V 72274		350 - 450			
V 72276	350 - 450					
Plastics	fibre-reinforced plastics and thermo-plastics, hard rubber	roughing	V 72223	450 - 650		
			V 72224	450 - 650		
			V 72243	450 - 650		
			V 72244	450 - 650		
			V 72259	500 - 900		



RECOMMENDATIONS FOR WORKING WITH ROTARY BURRS

RECOMMENDATIONS FOR USE:

- » Use highest possible speed
- » Fix as short as possible

EXCEPTIONS:

- » Full engagement of the countersink: speed <math>< 3000 \text{ min}^{-1}</math>
- » Fixed tool (stationary use): speed <math>< 3000 \text{ min}^{-1}</math> is possible

