



DEBURR

REMOVAL TOOL



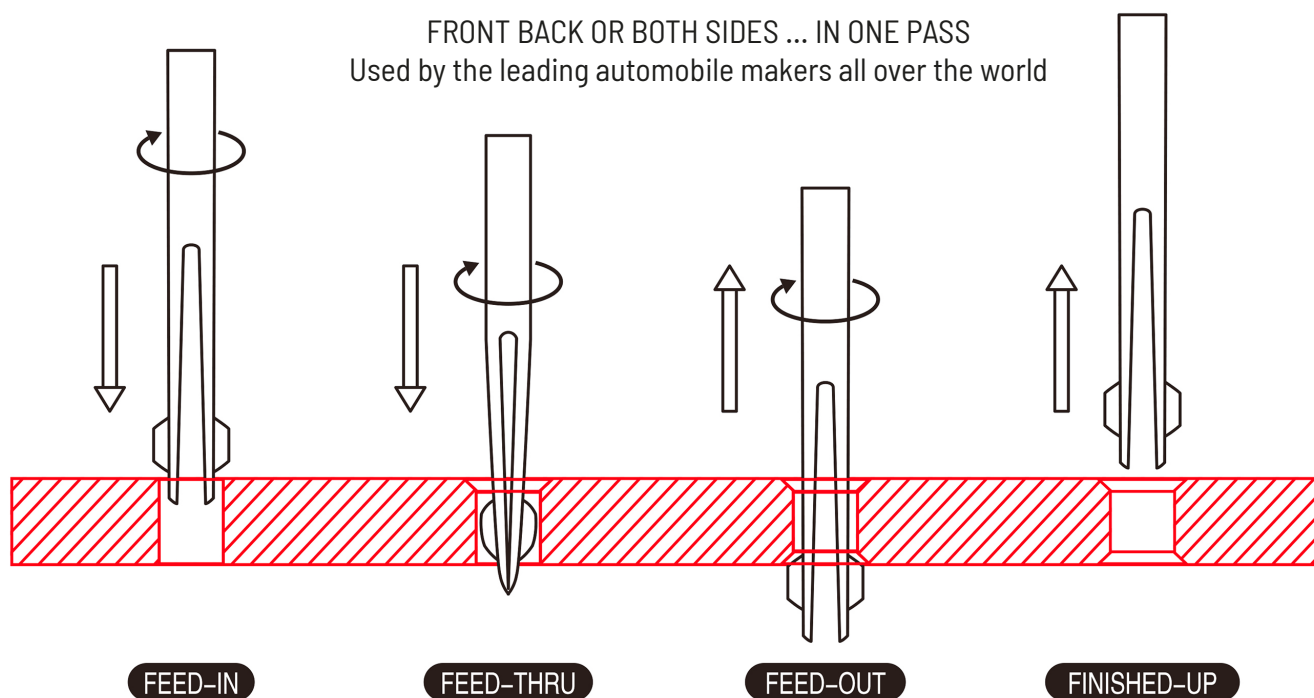
**WITH REPLACEABLE
BLADES**



**ONE-PIECE
CONSTRUCTION**



FRONT BACK OR BOTH SIDES ... IN ONE PASS
Used by the leading automobile makers all over the world



Burr Removal Tool

.0315" (0.001") ~.78" (20mm)

- DA (double acting)
- BA (back cutting only)

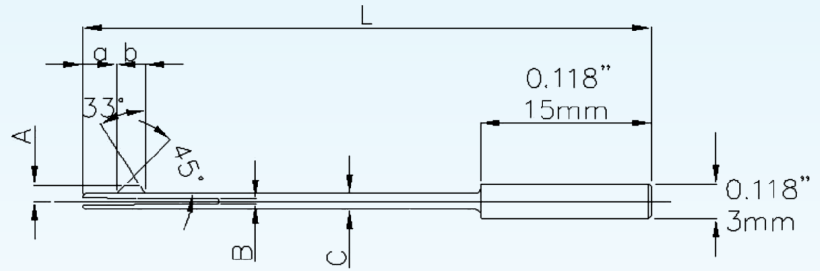
BR-0.8 ~ BR-6

(+0mm, -0.1mm)

BR-0.8~BR-1.4 a=1mm (0.039") b=1.5mm (0.059")

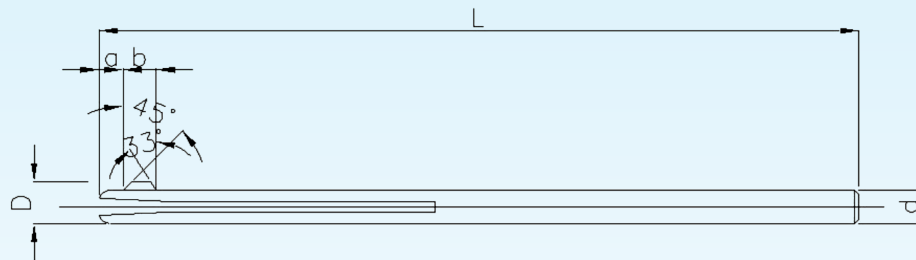
BR-1.5~BR-4 a=2mm (0.079") b=2.5mm (0.098")

BR-5~BR-6 a=2mm (0.079") b=3.0mm (0.118")



TOOL NUMBER	RANGE OF HOLE SIZES		ARBOR DIAMETER(C)		OVERALL LENGTH (L)		DIMENSION (A)		DIMENSION (B)	
	IN	NM	IN	NM	IN	NM	IN	NM	IN	NM
BR-0.8	.0315-.0354	0.8-0.9	0.027	0.7	1.77	45	0.027	0.7	0.012	0.3
BR-0.9	.0354-.0394	0.9-1.0	0.031	0.8	1.77	45	0.031	0.8	0.012	0.3
BR-1.0	.0394-.0433	1.0-1.1	0.035	0.9	1.77	45	0.035	0.9	0.012	0.3
BR-1.1	.0433-.0472	1.1-1.2	0.039	1	1.77	45	0.039	1	0.012	0.3
BR-1.2	.0472-.0512	1.2-1.3	0.043	1.1	1.77	45	0.043	1.1	0.012	0.3
BR-1.3	.0512-.0551	1.3-1.4	0.047	1.2	1.77	45	0.047	1.2	0.012	0.3
BR-1.4	.0551-.0591	1.4-1.5	0.051	1.3	1.77	45	0.051	1.3	0.012	0.3
BR-1.5	.0591-.0630	1.5-1.6	0.055	1.4	1.97	50	0.055	1.4	0.019	0.5
BR-1.6	.0630-.0670	1.6-1.7	0.059	1.5	1.97	50	0.059	1.5	0.019	0.5
BR-1.7	.0670-.0709	1.7-1.8	0.063	1.6	1.97	50	0.063	1.6	0.019	0.5
BR-1.8	.0709-.0748	1.8-1.9	0.067	1.7	2.36	60	0.067	1.7	0.019	0.5
BR-1.9	.0748-.0788	1.9-2.0	0.071	1.8	2.36	60	0.071	1.8	0.019	0.5
BR-2.0	.0788-.0866	2.0-2.2	0.075	1.9	2.36	60	0.075	1.9	0.019	0.5
BR-2.2	.0866-.0945	2.2-2.4	0.083	2.1	3.15	80	0.083	2.1	0.039	1
BR-5	.0945-.1023	2.4-2.6	0.091	2.3	3.15	80	0.091	2.3	0.039	1
BR-6	.1023-.1203	2.6-2.8	0.098	2.5	3.15	80	0.098	2.5	0.039	1

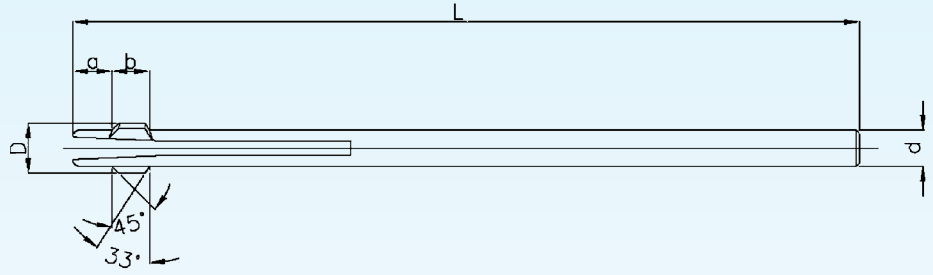
BR-7 - BR-13 (+0mm, -0.25mm)



TOOL NUMBER	RANGE OF HOLE SIZES		ARBOR DIAMETER(C)		OVERALL LENGTH (L)		DIMENSION (A)		DIMENSION (B)		DIMENSION (D)	
	IN	NM	IN	NM	IN	NM	IN	NM	IN	NM	IN	NM
BR-7	.110-.125	2.80-3.18	0.108	2.75	4.00	101.6	0.125	3.18	0.175	4.45	0.157	4.00
BR-8	.125-.140	3.18-3.55	0.124	3.15	4.00	101.6	0.125	3.18	0.175	4.45	0.171	4.34
BR-9	.140-.156	3.55-3.96	0.141	3.58	4.00	101.6	0.125	3.18	0.175	4.45	0.187	4.75
BR-10	.156-.172	3.96-4.36	0.155	3.94	4.00	101.6	0.125	3.18	0.175	4.45	0.218	5.54
BR-11	.172-.187	4.36-4.74	0.171	4.34	4.00	101.6	0.125	3.18	0.175	4.45	0.234	5.94
BR-12	.187-.203	4.74-5.15	0.186	4.72	4.00	101.6	0.125	3.18	0.245	6.22	0.25	6.35
BR-13	.203-.219	4.15-4.56	0.202	5.13	4.00	101.6	0.125	3.18	0.245	6.22	0.67	6.78

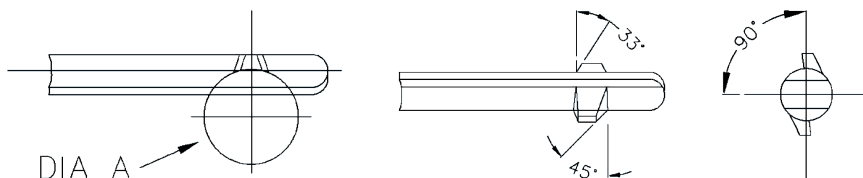
Burr Removal Tool

BR-14 - BR-50
(+0mm, -0.25mm)



TOOL NUMBER	RANGE OF HOLE SIZES		ARBOR DIAMETER(d)		OVERALL LENGTH (L)		DIMENSION (a)		DIMENSION (b)		DIMENSION (D)	
	IN	NM	IN	NM	IN	NM	IN	NM	IN	NM	IN	NM
BR-14	.219-.234	5.56-5.94	0.218	5.54	4.00	101.6	0.26	6.48	0.25	6.22	0.31	7.92
BR-15	.234-.250	5.94-6.35	0.233	5.92	4.00	101.6	0.26	6.48	0.25	6.22	0.33	8.33
BR-16	.250-.266	6.35-6.75	0.249	6.32	4.00	101.6	0.26	6.48	0.25	6.22	0.34	8.71
BR-17	.266-.281	6.75-7.13	0.265	6.73	4.00	101.6	0.26	6.48	0.25	6.22	0.36	9.12
BR-18	.281-.297	7.13-7.54	0.280	7.11	4.00	101.6	0.26	6.48	0.25	6.22	0.38	9.53
BR-19	.297-.313	7.54-7.95	0.296	7.52	4.00	101.6	0.29	7.24	0.25	6.22	0.39	9.91
BR-20	.313-.328	7.95-8.33	0.312	7.92	4.00	101.6	0.29	7.24	0.26	6.48	0.41	10.31
BR-21	.328-.343	8.33-8.71	0.327	8.31	4.00	101.6	0.29	7.24	0.26	6.48	0.42	10.72
BR-22	.343-.359	8.71-9.11	0.342	8.69	4.00	101.6	0.29	7.24	0.26	6.48	0.44	11.10
BR-23	.359-.375	9.11-9.52	0.358	9.09	4.00	101.6	0.29	7.24	0.26	6.48	0.45	11.51
BR-24	.375-.390	9.52-9.90	0.374	9.50	4.43	112.7	0.32	8.00	0.25	6.22	0.50	12.70
BR-25	.390-.406	9.90-10.31	0.389	9.88	4.43	112.7	0.32	8.00	0.25	6.22	0.52	13.08
BR-26	.406-.422	10.31-10.72	0.405	10.29	4.43	112.7	0.32	8.00	0.25	6.22	0.53	13.49
BR-27	.421-.438	10.69-11.13	0.420	10.67	4.43	112.7	0.32	8.00	0.25	6.22	0.55	13.89
BR-28	.437-.453	11.10-11.51	0.436	11.07	5.50	139.7	0.35	8.76	0.28	6.99	0.59	15.06
BR-29	.453-.468	11.51-11.88	0.452	11.48	5.50	139.7	0.35	8.76	0.28	6.99	0.61	15.47
BR-30	.468-.484	11.88-12.29	0.467	11.86	5.50	139.7	0.35	8.76	0.28	6.99	0.63	15.86
BR-31	.484-.500	12.29-12.70	0.483	12.27	5.50	139.7	0.35	8.76	0.28	6.99	0.64	16.26
BR-32	.500-.515	12.70-13.08	0.499	12.67	7.00	177.8	0.39	9.78	0.31	7.75	0.69	17.45
BR-33	.515-.531	13.08-13.48	0.514	13.05	7.00	177.8	0.39	9.78	0.31	7.75	0.70	17.86
BR-34	.531-.547	13.48-13.89	0.530	13.46	7.00	177.8	0.39	9.78	0.31	7.75	0.72	18.24
BR-35	.546-.563	13.87-14.30	0.545	13.84	7.00	177.8	0.39	9.78	0.31	7.75	0.73	18.64
BR-36	.563-.578	14.30-14.68	0.562	14.27	7.50	190.5	0.42	10.54	0.41	10.29	0.75	19.05
BR-37	.578-.594	14.68-15.09	0.577	14.65	7.50	190.5	0.42	10.54	0.41	10.29	0.77	19.43
BR-38	.594-.609	15.09-15.47	0.593	15.06	7.50	190.5	0.42	10.54	0.44	11.05	0.78	19.84
BR-39	.609-.625	15.47-15.87	0.608	15.44	7.50	190.5	0.42	10.54	0.44	11.05	0.80	20.22
BR-40	.625-.641	15.87-16.28	0.624	15.84	8.37	212.6	0.45	11.30	0.44	11.05	0.87	22.20
BR-41	.640-.656	16.26-16.66	0.639	16.23	8.37	212.6	0.45	11.30	0.44	11.05	0.98	22.63
BR-42	.656-.672	16.66-17.07	0.655	16.64	8.37	212.6	0.45	11.30	0.44	11.05	0.91	23.01
BR-43	.672-.688	17.06-17.47	0.671	17.04	8.37	212.6	0.45	11.30	0.44	11.05	0.92	23.39
BR-44	.687-.703	17.45-17.85	0.686	17.42	8.50	215.9	0.48	12.07	0.44	11.05	0.94	23.80
BR-45	.703-.719	17.85-18.26	0.702	17.83	8.50	215.9	0.48	12.07	0.44	11.05	0.95	24.18
BR-46	.718-.734	18.26-18.64	0.717	18.21	8.50	215.9	0.48	12.07	0.44	11.05	0.97	24.56
BR-47	.734-.750	18.64-19.05	0.733	18.62	8.50	215.9	0.48	12.07	0.44	11.05	0.98	24.97
BR-48	.750-.766	19.05-19.45	0.749	19.02	8.62	218.9	0.51	12.83	0.44	11.05	1.00	25.40
BR-49	.766-.781	19.45-19.83	0.765	19.43	8.62	218.9	0.51	12.83	0.44	11.05	1.02	25.81
BR-50	.781-.797	19.83-20.24	0.780	19.81	8.62	218.9	0.51	12.83	0.44	11.05	1.03	26.19

Regrinding Guidelines: To extend the life of the tool, the cutting edges may be regrinding up to four times. Inspect for grit and foreign matter during and after each operation. Clean as needed.

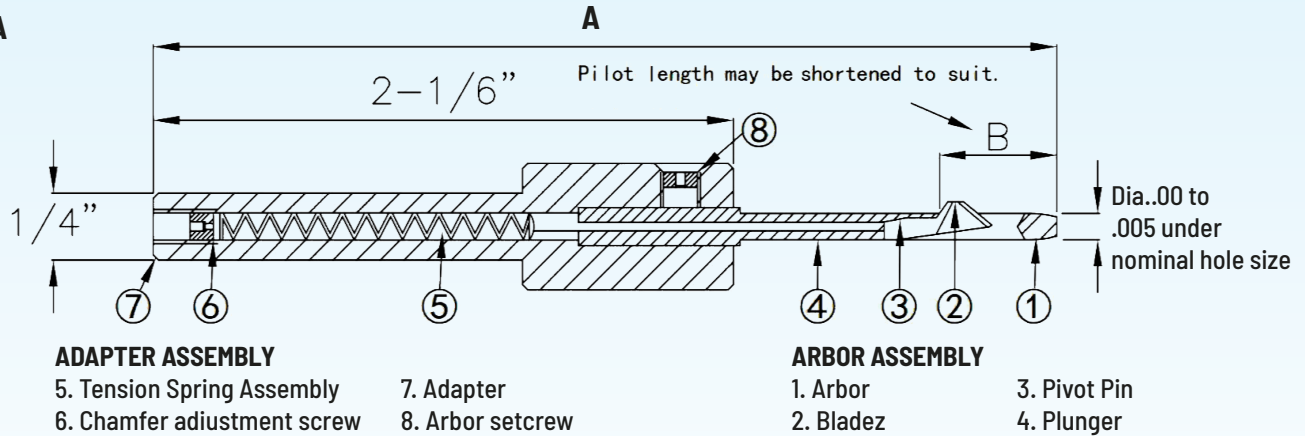


Hand grind face .010 - .015 in. (0.25 - 0.38mm)
With an abrasive wheel the diameter as shown in The chart ("A" DIA)

TOOL SIZE	GRINDING WHEEL DIA A	
	IN	NM
BR-0.8 - BR-6	0.3937	10
BR-7-BR-11	0.629	16
BR-12-BR-27	0.748	19
BR-28 - BR-35	0.866	22
BR-36 - BR-50	1.259	32

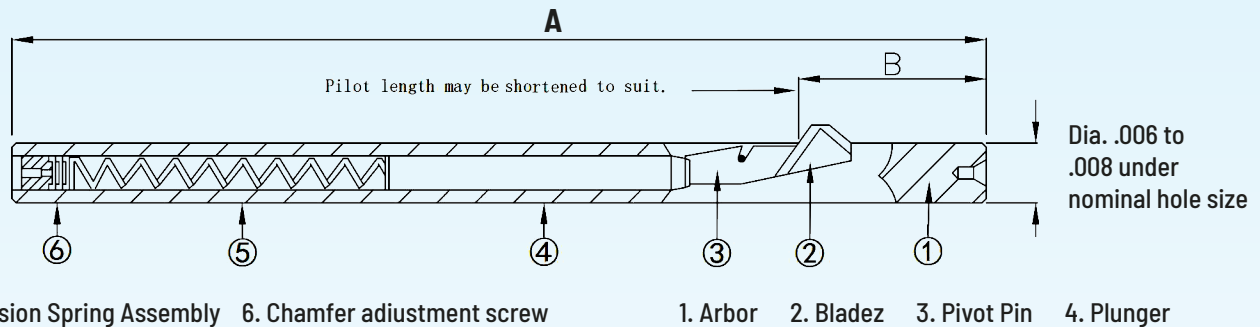
Standard Specifications

Type A



HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size	HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size	HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size
5/64	.0781	2.0	3-3/8	0.45	3/32	1/8	.1250	3.2	3-3/8	0.45	1/8	11/64	.1719	4.3	3-3/8	0.45	5/32
3/32	.0938	2.3					.1378	3.5					.1772	*4.5			
	.0984	2.5			1/8	9/64	.1406	3.6			5/32	3/16	.1875	*4.7	4-1/8	0.72	4-1/8
7/64	.1094	2.8				5/32	.1562	3.9					.1968	5.0			
	.1181	3.0					.1575	4.0				13/64	.2031	5.2			

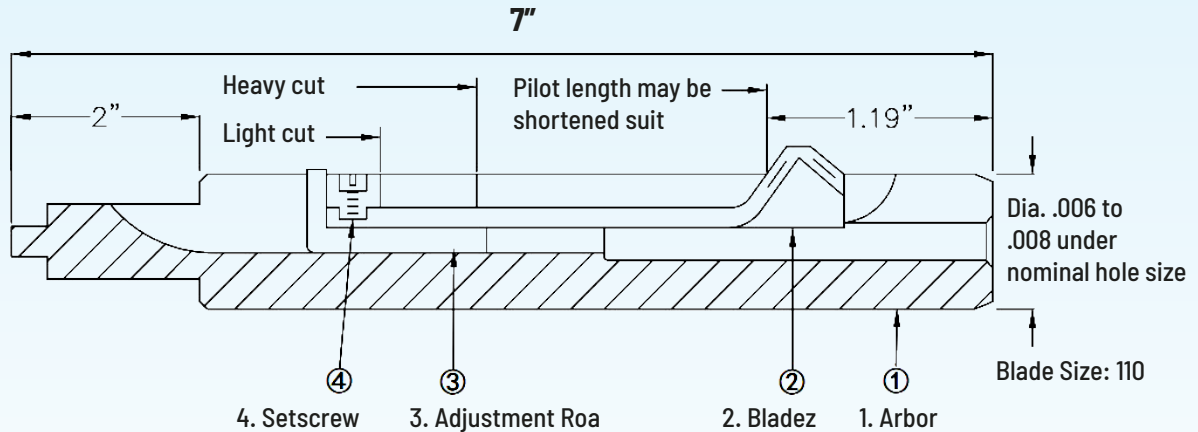
Type B



HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size	HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size	HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size
7/32	.2165	5.5		0.87	1	13/32	.4062	10.31	5	1.00	3	39/64	.6094	15.5	6.44	1.31	4
15/64	.2188	5.56				27/64	.4134	10.5				5/8	.6250	15.9			
	.2344	5.94					.4219	10.7					.6299	16.0			
	.2362	6.0					.4331	11.0				41/64	.6406	16.3			
1/4	.2500	6.35	4.5			7/16	.4375	11.1	5.5	1.03	3-1/2	21/32	.6496	16.5			
	.2559	6.5				29/64	.4528	11.5					.6563	16.7			
17/64	.2656	6.75					.4531	11.51				43/64	.6693	17.0			
	.2756	7.0				15/32	.4688	11.8				11/16	.6719	17.1			
9/32	.2812	7.14		0.96	2		.4724	12.0					.6875	17.5			
	.2953	7.5				31/64	.4844	12.3					.7087	18.0			
19/64	.2969	7.54					.4921	12.5					.7283	18.5			
	.3125	7.95				1/2	.5000	12.7					.7480	19.0			
5/16	.3150	8.0	5	1	3		.5118	13.0	6.44	1.31	4	3/4	.7500	19.1			5
	.3281	8.33				33/64	.5156	13.1					.7874	20.0			
	.3346	8.5					.5315	13.5					.8268	21.0			
11/32	.3438	8.74				35/64	.5469	13.9					.8661	22.0			
	.3543	9.0					.5512	14.0				7/8	.8750	22.2			
23/64	.3594	9.12				9/16	.5625	14.3					.9055	23.0			
	.3740	9.5					.5709	14.5					.9449	24.0			
3/8	.3750	9.53				37/64	.5781	14.7					.9843	25.0			
25/64	.3906	9.93					.5906	15.0				1	1.0000	25.4			
	.3937	10.0				19/32	.5938	15.1									

Standard Specifications

Type C



HOLE Size	DEC Equiv	NM	HOLE Size	DEC Equiv	NM	HOLE Size	DEC Equiv	NM	HOLE Size	DEC Equiv	NM	HOLE Size	DEC Equiv	NM	Dim. A	Dim. B	Blade Size
	.7082	18.0		.9449	24.0		1.1417	29.0		1.3386	34.0		1.5748	40.0		1.8110	45.0
	.7480	19.0		.9843	25.0		1.1811	30.0	1-3/8	1.3748	34.92		1.6142	41.0		1.8504	47.0
3/4	.7500	19.05	1	1.0000	25.4	1-3/16	1.1874	30.16		1.3780	35.0	1-5/8	1.6248	41.27		1.8898	48.0
	.7874	20.0		1.0262	26.0		1.2206	31.0		1.4173	36.0		1.6535	42.0		1.9291	49.0
	.8268	21.0	1-1/16	1.0622	26.98	1-1/4	1.2500	31.75		1.4567	37.0		1.6929	43.0		1.9635	50.0
	.8661	22.0		1.0630	27.0		1.2598	32.0		1.4961	38.0		1.7323	44.0	2	2.0000	50.8
7/8	.8750	22.22		1.1024	28.0		1.2992	33.0	1-1/2	1.5000	38.0	1-3/4	1.7500	44.45			
	.8750	23.0	1-1/8	1.1248	28.57	1-5/16	1.3122	33.33		1.5354	39.0		1.7717	45.0			

Applications

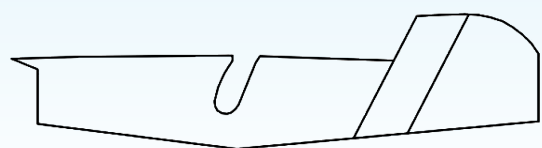
Can be used on any machine such as SINGLE or MULTI-SPINDLE DRILLING MACHINES, LATHE, NC MACHINE TOOLS. MACHING CENTER. SPECIAL MACHINE as well as HAND TOOLS. Applying speed and feed are the same as with drilling by twist drill. Simply adjust the setscrew in the shank end for the desired chamfer based on the hardness of the material and the RPM's being used. No special skill required.

Blade Type

"TUNGSTEN CARBIDE blades available in 5/32 to 4 sizes by special order."



DA double action



BA back action

Do not compress spring to is solid condition.The blade will not retract spring cushion.

Regrinding

A diagram illustrating the geometry of a single-point turning operation. The workpiece is a cylindrical part with a varying diameter. The cutting tool is shown in cross-section, with the following angles labeled:

- rake angle** : The angle between the top face of the tool and a line perpendicular to the cutting direction.
- clearance angle** : The angle between the flank face of the tool and the tangent to the workpiece surface at the cutting point. It is specified as $6 \sim 8^\circ$.
- 5.7°** : The angle between the top face of the tool and the tangent to the workpiece surface at the cutting point.
- 38°** : The angle between the flank face of the tool and the tangent to the workpiece surface at the cutting point.

type A& B

A collection of various precision-machined metal components, including a large brass valve, a silver valve train, a silver wheel and brake disc, a silver crankshaft, a silver axle, and a silver suspension arm.



CONTACT US

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 Global Working Tools
México,



You can count on us to support you with the optimization and cost reduction on your machining processes

