



SUPERFLEX

Tungsten carbide burrs

A Company of the Tyrolit Group
www.grindtech.com





Tunsten Carbide Burrs

Our Carbide burr heads are meticulously crafted with precision using premium grade raw tungsten carbide material. This ensures exceptional durability and optimal performance.

The shanks are expertly made from a patented nickel stainless material and securely joined to the burr heads through sandwich welding. This innovative construction technique guarantees a seamless and reliable bond. Available in Double Cut, they improve tool control and reduce operator fatigue as this specific cut blunts swarf on application.





Shape	Head Diameter (mm)	Head Length (mm)	Shank Diameter (mm)
Ball nose cylinder	08	20	06

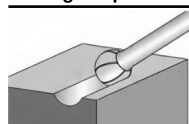
Recommendations for the operator

- As long as the burr runs at the recommended speed, the standard tooth pitch will suit almost any application.
- Always ensure the collet is the correct size and in good condition, allowing the tungsten carbide burr to run true for optimal performance.
- When machining, the burr's diameter should not be bigger than a third of the cavity being machined.
When working on very hard materials, maintain constant movement and apply light pressure to prevent impact damage to the burr.
- Should the tungsten carbide burr become clogged when working on softer metals, run it over a spare piece of soft cast iron to help clear the flutes and restore cutting performance.

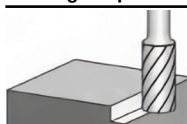


Different shapes

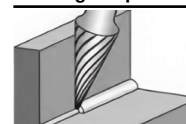
Ball

Cutting Shape	Reference
	CB 030303
	CB 030306
	CB 060606
	CB 080806
	CB 101006
	CB 121206
	CB 161606

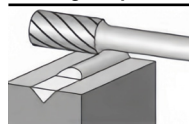
Cylindrical End Cut

Cutting Shape	Reference
	CE 031203
	CE 061606
	CE 082006
	CE 102006
	CE 122506

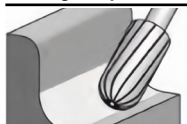
Cone

Cutting Shape	Reference
	CO 031203
	CO 061606
	CO 082006
	CO 102006
	CO 122506

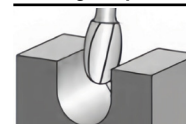
Cylindrical

Cutting Shape	Reference
	CP 031203
	CP 062006
	CP 082006
	CP 102006
	CP 122506

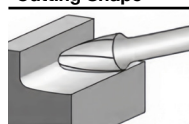
Ball nose cylinder

Cutting Shape	Reference
	CR 020603
	CR 061203
	CR 062006
	CR 082006
	CR 102006
	CR 122506

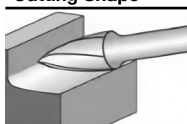
Oval

Cutting Shape	Reference
	OV 030603
	OV 061006
	OV 081306
	OV 101606
	OV 122006

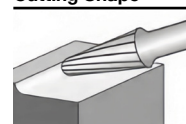
Round tree

Cutting Shape	Reference
	TR 031203
	TR 062006
	TR 082006
	TR 102006
	TR 122506

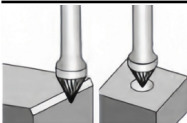
Pointed tree

Cutting Shape	Reference
	TP 031203
	TP 062006
	TP 082006
	TP 102006
	TP 122506

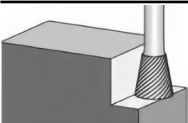
Ball nose cone

Cutting Shape	Reference
	T 031203
	T 061606
	T 082206
	T 103006
	T 123006

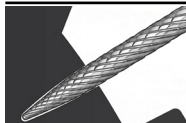
Countersink

Cutting Shape	Reference
	CO 120606 - 90°
	CO 160806 - 90°
	CO 121006 - 60°
	CO 161306 - 60°

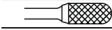
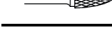
Inverted cone - end

Cutting Shape	Reference
	IC 060603
	IC 101006
	IC 121206

Tyre burrs

Cutting Shape	Reference
	CO 065206
	CO 085208
	CO 106595
	CO 137895

Long shank burrs

Cutting Shape	Reference
	CR 061206
	CR 062006
	CR 082006
	CR 102006
	CR 122506
	CP 061606
	TP 061606
	TP 102006

*Popular sizes shown; other sizes available on request

Safety Pictograms



Observe the instructions



Wear protective clothing



Wear gloves

Recommended cutting speeds

Double cut style burrs

Steel and steel castings		
	Non- hardend, non-heat treated steels up to 35 HRC	450 - 600 m/min
		250 - 350 m/min
	Hardend, heat treated steels over 35 HRC	250 - 350 m/min
	Stainless steels	
Hardened non-ferrous metals (Bronze, Titanium, Hard Aluminium)		
	Coarse machining (High stock removal)	250 - 350 m/min
	Fine machining (Deburring etc)	350 - 450 m/min
	Nickel based alloys	300 - 450 m/min
	Cast iron	450 - 600 m/min

Alu cut style burrs

Soft non-ferrous metals (Brass, Copper, Zinc, Aluminium Alloys)		
	Coarse machining (High stock removal)	600 - 900 m/min
	Fine machining (Deburring etc)	800 - 900 m/min
Plastics (Fibre reinforced plastics, Thermoplastics, Hard Rubber)		
	Coarse machining (High stock removal)	500 - 900 m/min
	Fine machining (Deburring etc)	500 - 900 m/min

Conversion Chart

Meters per minute (m/min) to revolutions per minute (RPM)

All dimensions in millimeters.

ORDERING DATA: Specification – Cutting Style

Burr dia.	2	3	4	6	8	10	12	16	20
m/min	RPM								
250	39773	26515	19886	13258	9943	7955	6629	4972	3977
300	47727	31818	23864	15909	11932	9545	7955	5966	4773
350	55682	37121	27841	18561	13920	11136	9280	6960	5568
450	71591	47727	35795	23864	17898	14318	11932	8949	7159
500	79545	53030	39773	26515	19886	15909	13258	9943	7955
600	95455	63636	47727	31818	23864	19097	15909	11932	9545
900	143182	95455	71591	47727	35795	28636	23864	17898	14318

GRINDING TECHNIQUES (PTY) LTD

28 Van Eck Street, Chamdor, Krugersdorp, Gauteng, South Africa

PO Box 51, Krugersdorp, 1740, South Africa

Tel +27 11 271 6400 | info@grindtech.com