

**NORTON**

SAINT-GOBAIN

Reshaping  
your  
world.

# NORTON CARBIDE BURRS DOUBLE CUT STYLE



  
SAINT-GOBAIN

# TUNGSTEN CARBIDE BURRS

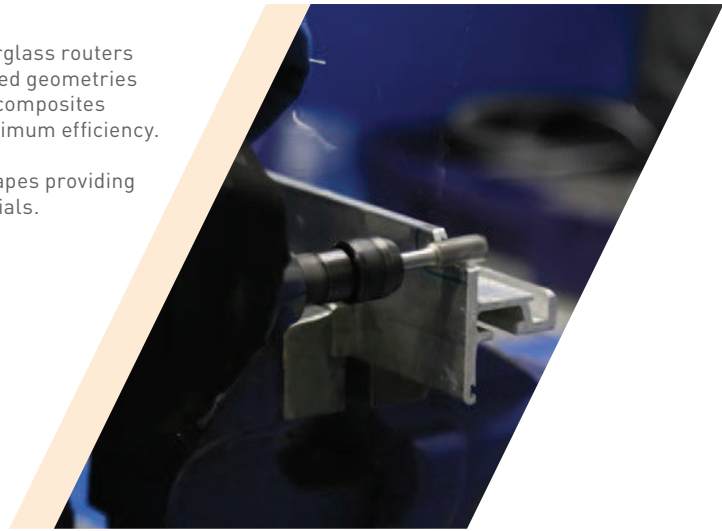
State of the art, "Inox" & "Steel" cut styles, new round edge burrs and fiberglass routers brings innovation to the Norton Carbide burr offering. The specially designed geometries suit the growing market demands for stainless steel, steel, cast steel and composites applications offering fast stock removal and long service life, providing optimum efficiency.

This extended line of carbide burrs covers a variety of teeth and cutting shapes providing optimum adaptation to the key characteristics of various application materials.

Carbide burrs can be used on with hand-held tools or CNC machines. Each carbide burr is packed individually in a plastic case.

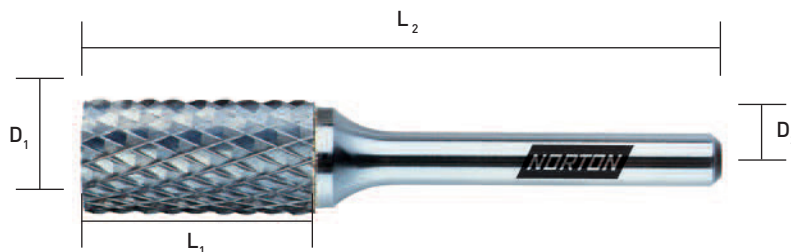
## APPLICATIONS & MARKETS

- Weld removal
- Chamfering
- Weld preparation
- Deburring
- Aerospace
- Automotive
- Shipbuilding
- Foundry
- Aviation

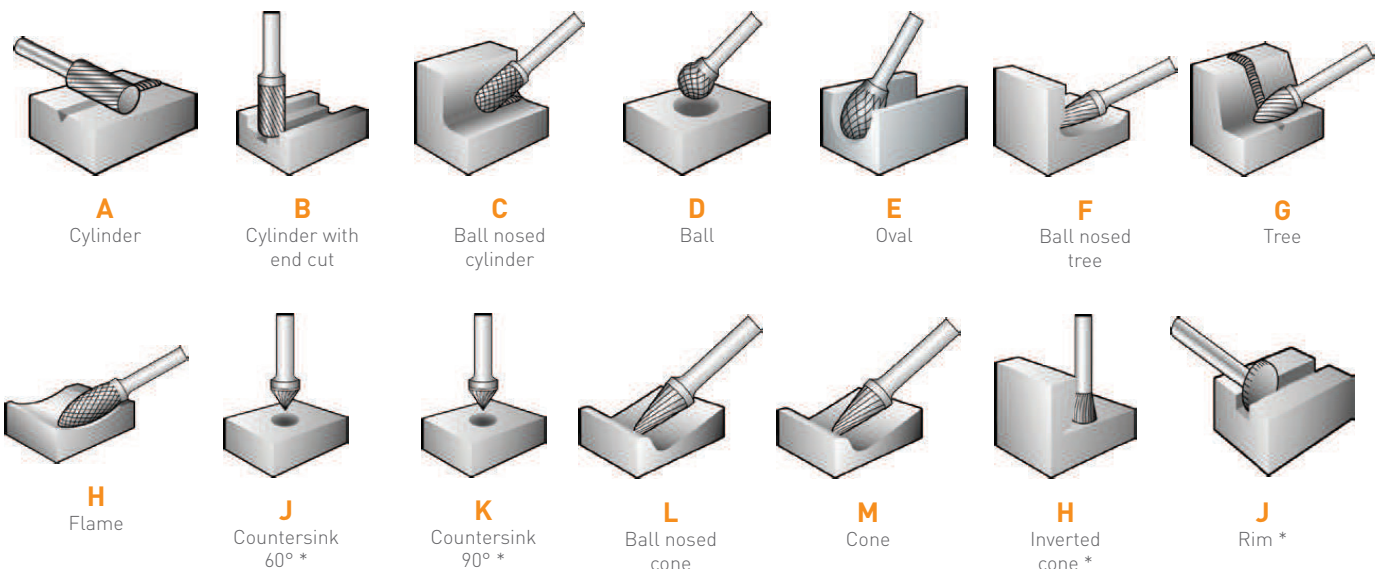


## UNDERSTANDING THE PRODUCT BURR DIMENSIONS & DESCRIPTION



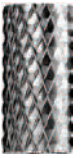
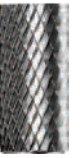


A	16,0	x	25,0	6x65	DTECH
Shape	Head diameter		Head length	Shank diameter & overall burr length (OL)	Cut style
	D <sub>1</sub>		L <sub>1</sub>	D <sub>2</sub> + L <sub>2</sub>	



## APPLICATION BY SHAPE



## APPLICATION BY CUT STYLE

						
Cut Style	INOX	STEEL	DTECH Double Cut Extra	<b>D Double Cut</b>	ALU Aluminium Special	Fiberglass routers
Qualities	Developed cutting geometry - generating high stock removal on stainless steel and on Ferritic, Austenitic & Martensitic based materials, ensuring production savings and reduced downtime, reducing heat buildup at the cutting edge and work piece.	Specially designed geometry to suit growing market demands for steel and cast steel applications, producing large chips with increased stock removal.	Better stock removal. Stronger tooth formation (decreased tooth wedge angle) longer tool life and reduced chipping.	Universal cutting style, fast material removal, smooth finish and granular chip break.	For deburring of aluminium alloys & plastic wide tooth chip flow.	Best for Carbon or Glass fibre reinforced materials. Best for roughing and contouring composite.

Stainless Steel	+++++		+++			
Hardened Steel		+++++	+++			
Cast Iron			+++++	+++		
Titanium				+++++		
Nickel				+++++		
Copper/ copper alloys				+++++		
Aluminium					+++++	
Plastics / wood					+++++	
Carbon or glass fibers						+++++

Material by cut style



## RECOMMENDED OPERATING SPEEDS (RPM)

MATERIAL TYPE	∅	∅	∅	∅	∅
	3mm	6mm	10mm	12mm	16mm
Steel	60000-90000	45000-90000	30000-40000	22500-30000	18000-24000
Tempered steel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Stainless steel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Casting	45000-90000	22500-60000	15000-40000	11000-30000	9000-24000
Titanium	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Nickel	60000-90000	30000-45000	19000-30000	15000-22500	12000-18000
Copper & copper alloys	45000-90000	22500-60000	15000-40000	11000-30000	9000-24000
Aluminium	30000-90000	15000-70000	10000-50000	7000-38000	6000-30000
Plastics	30000-90000	15000-70000	10000-50000	7000-38000	6000-30000
Carbon or glass fibers	64000-117000	32000-59000	19000-35000	16000-30000	12000-22000

Recommended speeds are for standard shank length of 45mm, maximum overhang 10mm.  
Maximum recommended speed for extra long burrs is 15.000 RPM.

### RECOMENDATIONS FOR USE

- It may be necessary to adjust the rates shown to achieve optimum performance
- Running below the optimum speed will encourage chipping
- Harder materials or sticky metals such as, titanium, require slower speeds
- Running above optimum speed will cause tooth wear
- Smaller burrs require faster speeds
- Allowing the tool to become too hot may cause the braze to melt and detach the head of the shank
- Apply constant movement and light pressure when in use
- Do not sink the burr for more than one third of its periphery











**FEATURES AND BENEFITS:**

- “D” Double CUT style, universal cutting style for fast material removal, smooth finish and granular chip break.
- Sharp cutting edges for improved productivity & longer product life.
- Available on a wide variety of shapes and sizes.



PRODUCT SHAPE	DIM D <sup>1</sup> xL <sup>1</sup> xD <sup>2</sup> xL <sup>2</sup> (mm)
<b>A</b> CYLINDER 	3x13x3x38
	6x19x6x50
	8x19x6x65
	10x19x6x65
	10x25x6x162
	12x25x6x70
	16x25x6x70
<b>B</b> CYLINDER WITH END CUT 	3x13x3x38
	6x19x6x50
	8x19x6x65
	8x19x6x175
	10x19x6x65
	12x25x6x70
<b>C</b> BALL NOSED CYLINDER 	3x13x3x38
	6x13x6x162
	6x16x6x80
	6x19x6x50
	8x19x6x65
	10x19x6x65
	12x19x6x65
	12x25x6x70
<b>D</b> BALL 	6x5x6x150
	6x5,4x6x50
	8x7,2x6x52
	10x9x6x53
	12x10,8x6x55
<b>E</b> OVAL 	6x10x6x50
	10x16x6x60
	12x22x6x67
<b>F</b> BALL NOSED TREE 	6x16x6x50
	6x18x6x150
	8x20x6x150
	10x19x6x65
	12x25x6x70
	12x25x8x70
16x25x6x70	

\* Made-to-order

PRODUCT SHAPE	DIM D <sup>1</sup> xL <sup>1</sup> xD <sup>2</sup> xL <sup>2</sup> (mm)
<b>G</b> TREE 	3x12x3x38
	6x16x6x50
	10x19x6x65
	12x25x6x70
	16x25x6x70
<b>H</b> FLAME 	8x19x6x65
	12x32x6x77
<b>L</b> BALL NOSED CONE 	6x16x6x50
	8x19x6x69
	10x27x6x75
	12x30x6x75
<b>M</b> CONE 	6x19x6x50
	6x25x6x50
	10x16x6x65
	12x22x6x70

KIT	SHAPE	DIM D <sup>1</sup> xL <sup>1</sup> xD <sup>2</sup> xL <sup>2</sup> (mm)
MINI BURRS KIT x10 CUT D NORTON	A	3x13x3x38
	B	3x13x3x38
	M	3x11x3x38
	C	3x13x3x38
	L	3x8x3x38
	H	3x8x3x38
	E	3x6x3x38
	G	3x13x3x38
BURRS KIT x5 CUT D NORTON	D	3x2,7x3x39
	F	3x13x3x38
	A	10x19x6x65
	C	12x25x6x70
	F	12x25x6x70
BRASS, BRONZE, COPPER	G	10x19x6x65
	L	12x30x6x75
	C	12x25x6x70
	D	10x9x6x53
	F	12x25x6x70
	L	12x30x6x75

**Dimensions Key:** DIM = Dimensions, D<sup>1</sup> = Head Diameter, L<sup>1</sup> = Head Length, D<sup>2</sup> = Shank Diameter, L<sup>2</sup> = Shank Length



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