

Tungsten carbide burrs with CAST cut
Maximum stock removal on cast iron



**YOU KNOW HOW.
WE KNOW WOW!**



TRUST BLUE

- Up to 100 % higher stock removal rate in comparison to conventional cross cut burrs
- Significantly increased aggressiveness, large chips and very good chip removal through the innovative tooth geometry
- Comfortable working with reduced vibration and lower noise

Tungsten carbide burrs with CAST cut for use on cast iron

With the CAST cut, PFERD has developed innovative burrs especially for work on cast iron. They are characterized by an extremely high stock removal rate on cast iron and impress through smooth milling with significantly reduced vibration and less noise.

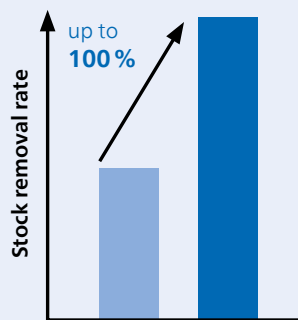
Advantages:

- Up to 100 % higher stock removal rate when used on cast iron due to the innovative tooth geometry, when compared with conventional cross-cut burrs.
- Significantly increased aggressiveness, large chips and very good chip removal.
- Comfortable working with reduced vibration and less noise.

Materials that can be worked:

- Grey cast iron
- Nodular cast iron
- Annealed cast iron

Performance values for applications on cast iron



- Conventional burrs with cross cut
- Tungsten carbide burrs, CAST cut

Applications:

- Milling out
- Levelling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Recommendations for use:

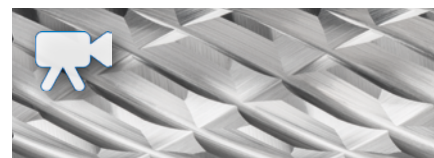
- If possible, use the tools on powerful drives with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burrs, work with higher rotational/cutting speeds. Power recommendation for tool drives: from 300 watts.
- Please observe the rotational speed recommendations.

Matching tool drives:

- Flexible shaft drive
- Straight grinder
- Robot
- Machine tools

Safety notes:

- The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.



= Wear eye protection!



= Wear hearing protection!



Wearing protective gloves is recommended. Handle the tool drive with both hands.



Observe the recommended rotational speed, especially when using burrs with long shanks!

PFERDVALUE:

PFERDERGONOMICS recommends burrs with CAST cut as an innovative tool solution for comfortable working with significantly reduced vibration and less noise.



Vibration Filter



Noise Filter



Haptic Filter

PFERDEFFICIENCY recommends burrs with CAST cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.



Energy Saving



Waste Saving



Time Saving



Resource Saving

Recommended rotational speed range [RPM]

To determine the recommended rotational speed range [RPM], please proceed as follows:

- 1 Refer to the table for the cutting speed.
- 2 Select the required burr diameter.
- 3 The cutting speed range and the burr diameter determine the recommended rotational speed range.

| Material group | | Application | Cut | 1 Cutting speed |
|----------------|---------------------------------|--|------|-----------------|
| Cast iron | Grey cast iron, white cast iron | Cast iron with flake graphite EN-GJL (GG), with nodular graphite/nodular cast iron EN-GJS (GGG), white annealed cast iron EN-GJMW (GTW), black cast iron EN-GJMB (GTS) | CAST | 450–750 m/min |

Example:

TC burr,
CAST cut,
burr dia. of 12 mm.
Coarse stock removal on cast iron.
Cutting speed: 450–750 m/min
**Rotational speed range:
12,000–20,000 RPM**

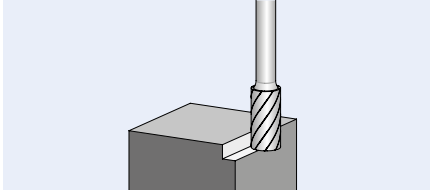
| 2 Burr dia. [mm] | 3 Cutting speeds [m/min] | |
|-------------------------|--------------------------|--------|
| | 450 | 750 |
| Rotational speeds [RPM] | | |
| 6 | 24,000 | 40,000 |
| 10 | 14,000 | 24,000 |
| 12 | 12,000 | 20,000 |

Tungsten carbide burrs with CAST cut

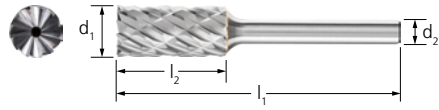
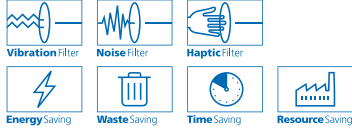
for use on cast iron



Cylindrical shape ZYAS with end cut

Cylindrical burr according to DIN 8032 with circumferential and end cut.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | |

Shank dia. 6 mm

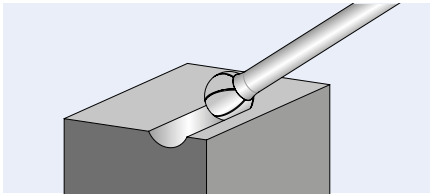
| | | | | | | | |
|----|----|---|----|--------|---------------|---|------------------|
| 6 | 16 | 6 | 55 | 952658 | 24,000–40,000 | 1 | ZYAS 0616/6 CAST |
| 10 | 20 | 6 | 60 | 952665 | 14,000–24,000 | 1 | ZYAS 1020/6 CAST |
| 12 | 25 | 6 | 65 | 952672 | 12,000–20,000 | 1 | ZYAS 1225/6 CAST |

Shank dia. 8 mm

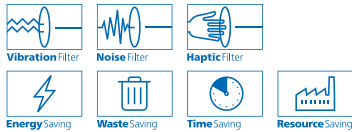
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|----|----|---|----|--------|---------------|---|------------------|
| 12 | 25 | 8 | 65 | 067925 | 12,000–20,000 | 1 | ZYAS 1225/8 CAST |
|----|----|---|----|--------|---------------|---|------------------|

Ball shape KUD

Ball-shaped burr according to DIN 8032.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | |

Shank dia. 6 mm

| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 10 | 9 | 6 | 49 | 952504 | 14,000–24,000 | 1 | KUD 1009/6 CAST |
| 12 | 10 | 6 | 51 | 952511 | 12,000–20,000 | 1 | KUD 1210/6 CAST |

Shank dia. 8 mm

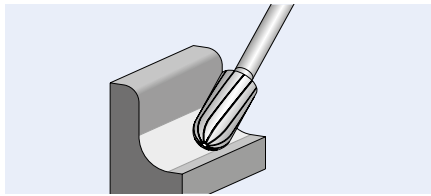
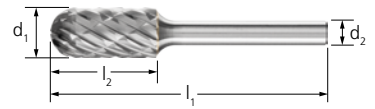
| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 12 | 10 | 8 | 51 | 068038 | 12,000–20,000 | 1 | KUD 1210/8 CAST |
|----|----|---|----|--------|---------------|---|-----------------|



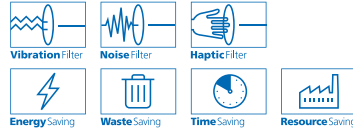
Tungsten carbide burrs with CAST cut for use on cast iron



Cylindrical shape with radius end WRC

Cylindrical burr with radius end according to DIN 8032. Combination of cylindrical and ball-shaped geometries.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | |

Shank dia. 6 mm

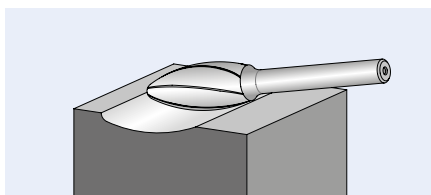
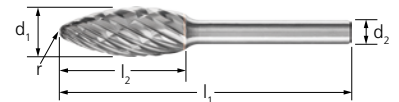
| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 6 | 16 | 6 | 55 | 952610 | 24,000–40,000 | 1 | WRC 0616/6 CAST |
| 10 | 20 | 6 | 60 | 952627 | 14,000–24,000 | 1 | WRC 1020/6 CAST |
| 12 | 25 | 6 | 65 | 952634 | 12,000–20,000 | 1 | WRC 1225/6 CAST |

Shank dia. 8 mm

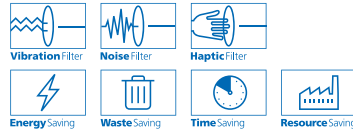
| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 12 | 25 | 8 | 65 | 067932 | 12,000–20,000 | 1 | WRC 1225/8 CAST |
|----|----|---|----|--------|---------------|---|-----------------|



Flame shape B

Flame-shaped burr according to ISO 7755/8.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | r [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|-------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | | |

Shank dia. 6 mm

| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|---------------|
| 12 | 30 | 6 | 70 | 2.1 | 952450 | 12,000–20,000 | 1 | B 1230/6 CAST |
|----|----|---|----|-----|--------|---------------|---|---------------|

Shank dia. 8 mm

| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|---------------|
| 12 | 30 | 8 | 70 | 2.1 | 068021 | 12,000–20,000 | 1 | B 1230/8 CAST |
|----|----|---|----|-----|--------|---------------|---|---------------|

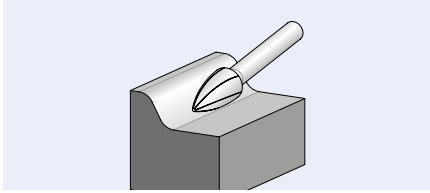


Tungsten carbide burrs with CAST cut

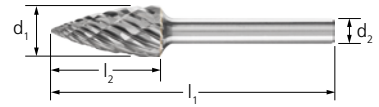
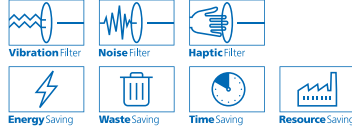
for use on cast iron



Pointed tree shape SPG

Pointed tree-shaped burr according to DIN 8032, flattened tip.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | |

Shank dia. 6 mm

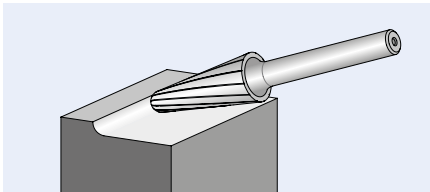
| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 6 | 18 | 6 | 55 | 952580 | 24,000–40,000 | 1 | SPG 0618/6 CAST |
| 10 | 20 | 6 | 60 | 952597 | 14,000–24,000 | 1 | SPG 1020/6 CAST |
| 12 | 25 | 6 | 70 | 952603 | 12,000–20,000 | 1 | SPG 1225/6 CAST |

Shank dia. 8 mm

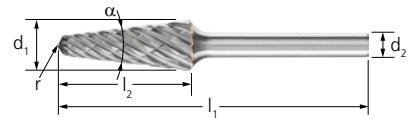
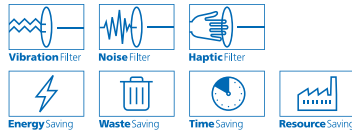
| | | | | | | | |
|----|----|---|----|--------|---------------|---|-----------------|
| 12 | 25 | 8 | 70 | 067956 | 12,000–20,000 | 1 | SPG 1225/8 CAST |
|----|----|---|----|--------|---------------|---|-----------------|



Conical shape with radius end KEL

Conical burr with radius end according to DIN 8032.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | α | r [mm] | Cut CAST  | RPM |  | Description |
|--------------------|---------------|---------------|---------------|----------|-------------|--|-----|---|-------------|
| EAN 4007220 | | | | | | | | | |

Shank dia. 6 mm

| | | | | | | | | | |
|----|----|---|----|-----|-----|--------|---------------|---|-----------------|
| 12 | 30 | 6 | 70 | 14° | 2.6 | 952474 | 12,000–20,000 | 1 | KEL 1230/6 CAST |
|----|----|---|----|-----|-----|--------|---------------|---|-----------------|

Shank dia. 8 mm

| | | | | | | | | | |
|----|----|---|----|-----|-----|--------|---------------|---|-----------------|
| 12 | 30 | 8 | 70 | 14° | 2.6 | 068014 | 12,000–20,000 | 1 | KEL 1230/8 CAST |
|----|----|---|----|-----|-----|--------|---------------|---|-----------------|

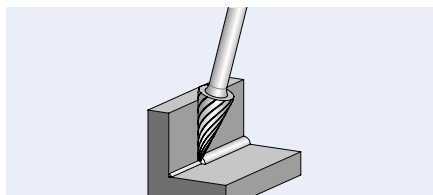


Tungsten carbide burrs with CAST cut

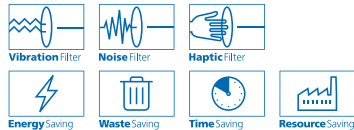
for use on cast iron



Conical pointed shape SKM

Conical pointed burr according to DIN 8032, flattened tip.



PFERDVALUE:



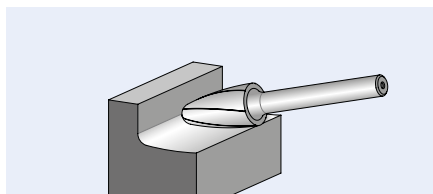
| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | α | Cut CAST  EAN 4007220 | RPM |  | Description |
|---------------|---------------|---------------|---------------|----------|---|-----|---|-------------|
|---------------|---------------|---------------|---------------|----------|---|-----|---|-------------|

Shank dia. 6 mm

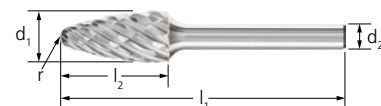
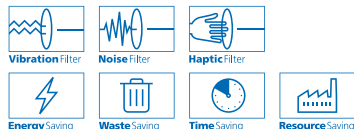
| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|-----------------|
| 12 | 25 | 6 | 65 | 26° | 952481 | 12,000–20,000 | 1 | SKM 1225/6 CAST |
|----|----|---|----|-----|--------|---------------|---|-----------------|


Tree shape with radius end RBF

Tree-shaped burr with radius end according to DIN 8032.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | r [mm] | Cut CAST  EAN 4007220 | RPM |  | Description |
|---------------|---------------|---------------|---------------|-------------|---|-----|---|-------------|
|---------------|---------------|---------------|---------------|-------------|---|-----|---|-------------|

Shank dia. 6 mm

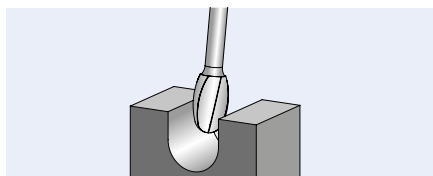
| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|-----------------|
| 6 | 18 | 6 | 55 | 1.5 | 952528 | 24,000–40,000 | 1 | RBF 0618/6 CAST |
| 10 | 20 | 6 | 60 | 2.5 | 952559 | 14,000–24,000 | 1 | RBF 1020/6 CAST |
| 12 | 25 | 6 | 65 | 2.5 | 952566 | 12,000–20,000 | 1 | RBF 1225/6 CAST |

Shank dia. 8 mm

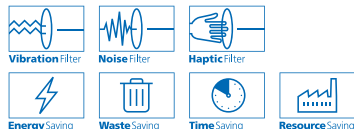
| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|-----------------|
| 12 | 25 | 8 | 65 | 2.5 | 067949 | 12,000–20,000 | 1 | RBF 1225/8 CAST |
|----|----|---|----|-----|--------|---------------|---|-----------------|



Oval shape TRE

Oval burr according to DIN 8032.



PFERDVALUE:



| d_1 [mm] | l_2 [mm] | d_2 [mm] | l_1 [mm] | r [mm] | Cut CAST  EAN 4007220 | RPM |  | Description |
|---------------|---------------|---------------|---------------|-------------|---|-----|---|-------------|
|---------------|---------------|---------------|---------------|-------------|---|-----|---|-------------|

Shank dia. 6 mm

| | | | | | | | | |
|----|----|---|----|-----|--------|---------------|---|-----------------|
| 12 | 20 | 6 | 60 | 5.0 | 952467 | 12,000–20,000 | 1 | TRE 1220/6 CAST |
|----|----|---|----|-----|--------|---------------|---|-----------------|