

TC copy burrs

for tool and mould construction



TRUST BLUE

- Especially suitable for the repair of cutting and punching blades in tool and mould construction
 - The uncut area provides optimum contour guidance and protects the workpiece against damage
 - PFERD custom-made products upon request
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TC copy burrs by PFERD are the perfect tools for levelling elevations, such as weld seams. Thanks to the uncut area, the weld seam can be adjusted to the level of the surrounding surface without this being damaged. Copy milling burrs are used in particular in the repair of cutting and punching blades in tool and mould construction.

Advantages:

- Long tool life and high surface quality.
- The uncut area provides optimum contour guidance and protects the workpiece against damage.
- Reduction in processing time.

Materials that can be worked:

- Steel and cast steel
- Tool steels, hardened, heat-treated steels over 1,200 N/mm²

Applications:

- Levelling
- Work on weld seams

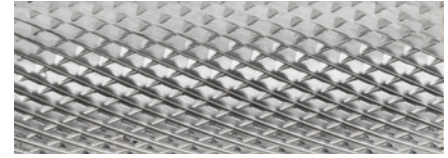
Recommendations for use:

- For accurate contour guidance, copy burrs can be used with guide aids.
- Please observe the rotational speed recommendations.

Matching tool drives:

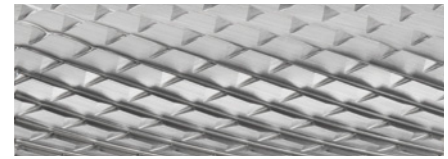
- Straight grinders
- Flexible shaft drive

MICRO cut



TC copy burrs with MICRO cut were designed especially for fine stock removal and they produce an excellent surface quality. Almost all materials up to a hardness of 68 HRC can be machined.

Cut 4



TC copy burrs with cut 4 are designed for coarse stock removal.

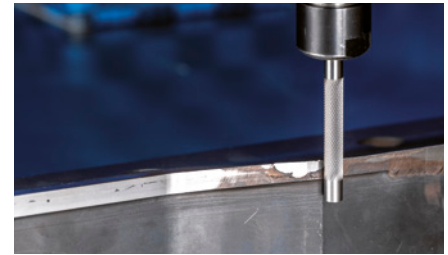
Recommended rotational speed range [RPM]

To determine the recommended cutting speed range [m/min], please proceed as follows:

- 1 Select the material group to be machined.
- 2 Determine the type of application.
- 3 Select the cut.
- 4 Establish the cutting speed range.

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

- 5 Select the required burr diameter.
- 6 The cutting speed range and the burr diameter determine the recommended rotational speed range.



1 Material group		2 Application	3 Cut	4 Cutting speed	
Steel, cast steel	Steels up to 1,200 N/mm ² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal	450–600 m/min	
			Fine stock removal	MICRO	600–750 m/min
	Hardened, heat-treated steels over 1,200 N/mm ² (> 38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel	Coarse stock removal	4	250–350 m/min
			Fine stock removal	MICRO	450–600 m/min

Example:

TC copy burr, MICRO cut, burr dia. 8 mm.

Fine stock removal on steels up to 1,200 N/mm².

Cutting speed: 600–750 m/min

Rotational speed range:

24,000–30,000 RPM

5 Burr dia. [mm]	6 Cutting speeds [m/min]				
	250	350	450	600	750
	Rotational speed [RPM]				
3	27,000	37,000	48,000	64,000	80,000
6	13,000	19,000	24,000	32,000	40,000
8	10,000	14,000	18,000	24,000	30,000

TC copy burrs

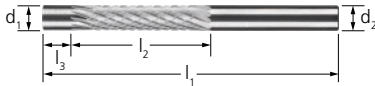
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Cylindrical shape ZYA without end cut

Cylindrical burr.

Ordering notes:

- Please complete the description with the desired cut.



d ₁ [mm]	l ₂ [mm]	l ₃ [mm]	d ₂ [mm]	l ₁ [mm]	Cut			Description
					MICRO 	4 		
EAN 4007220								

Shank dia. 3 mm

3	25	7	3	65	244838	244845	1	ZYA 0325/3 ... 7MM KFS
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Shank dia. 6 mm

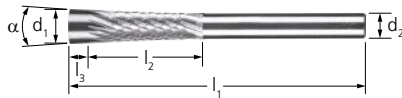
6	30	7	6	70	244982	244890	1	ZYA 0630/6 ... 7MM KFS
8	30	7	6	77	244906	244913	1	ZYA 0830/6 ... 7MM KFS




Inverted cones WKN without end cut

Inverted cone-shaped burr, tapered towards the shank. Inverted cones WKN are especially well-suited for processing punching tools that are used for processing aluminium.

Ordering notes:

- Please complete the description with the desired cut.



d ₁ [mm]	l ₂ [mm]	l ₃ [mm]	d ₂ [mm]	l ₁ [mm]	α	Cut			Description
						MICRO 	4 		
EAN 4007220									

Shank dia. 6 mm

8	26	7	6	73	4°	244937	244920	1	WKN 0826/6 ... 7MM KFS
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Products made to order

As a tool manufacturer with over 200 years of experience, PFERD can call on comprehensive expertise in the manufacture of tool solutions. The findings from our internal research and development, as well as from day-to-day practice on site with our customers, contribute to the development of each individual PFERD tool. Our production plant in Marienheide, Germany, works with state-of-the-art technology and there are many ways in which we can respond to individual needs.

Further TC copy burr cuts and dimensions are available as made-to-order products. For the production of these types of burrs, the uncut and cut lengths must be defined. Please note: The transition area may be up to 8 mm long!

Please contact us for further information. Your PFERD sales representative will be happy to provide you with further assistance.

