

TECHNICAL INFORMATION AND PRODUCT INFORMATION

LUKAS tungsten carbide burrs

QUALITY

LUKAS carbide burrs are manufactured using high-quality solid carbides on modern CNC automatic grinding machines in order to guarantee precision and repeatability of angle, profile and twist. We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

APPLICATION

Selecting the right cut and speed is key for achieving the best results when working with a variety of materials. Please refer to the tables for cut and cutting speed on **page 15**.

POWER TOOLS

Electrical or pneumatic tools, with bearings and collets that are in good condition and run true, are key to getting perfect results. Vibration and chatter will cause premature wear and tooth breakage. Excessive working pressure will increase wear but not increase performance.

SHANKS

For safety reasons, always choose the largest shank diameter available from the table. All burr shanks from LUKAS have a shank diameter tolerance of h9 to ensure safe and smooth assembly. Other shank lengths and diameters are available upon request. See **pages 38–40** for a selection of burrs with extra-long shank.

ROBOT APPLICATION

LUKAS solid carbide burrs are precision tools that have proven themselves in deburring work with industrial robots. We can also develop the perfect tool to suit your application.

SPECIAL TOOLS

We manufacture solid carbide burrs to your drawings and specifications to help you solve difficult stock removal problems.

PACKAGING

We use plastic packaging. Please refer to the product tables for the respective packaging units.

RECOMMENDATIONS FOR USE

Select the cut according to the material to be machined. The rule of thumb is: **the harder the material, the finer the cut.**

Selecting the right speed is key when it comes to achieving perfect working results and long tool life. The following pages contain information that can help you determine the right speed for your process.

Use the highest speeds possible within the ranges listed. **Speeds that are too low cause vibration, chipping and premature wear!** Reduce the speed of the burrs only when working with large contact angles or materials with low heat conductivity. **Never allow blue discolouration to appear on the shank and head.** For safety reasons, the use of longer shanks requires lower speeds.

Always ensure the settings of your power tool are properly adjusted for the job and material at hand. Avoid a reduction in speed caused by insufficient drive power, especially when using pneumatic machines. Only use collets that run true. Run-out and vibration will result in chipping and premature wear. For the same reasons, make sure that the machine bearings are in perfect condition. To avoid vibrations and shank breakage, select the shortest shank overhang possible.