

Tungsten carbide burrs NEW PFERD COMBICUT

General information

The NEW PFERD COMBICUT tungsten carbide burrs with MX NCC cut have been specially developed for universal use. They are characterized by good stock removal performance in use on a wide variety of materials. The broad product range provides economic solutions for almost every application.

Advantages:

- Application centred product range with commonly used shapes and dimensions.
- Good stock removal performance and tool life.
- Economic machining of the most diverse materials.

Materials that can be worked:

- Steel, cast steel
- Stainless steel (INOX)
- Non-ferrous metals
- Cast iron
- Plastics and other materials

Materials that can be worked:

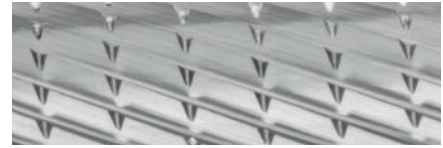
- Levelling
- Deburring
- Machining contours
- Machining edges (chamfering, rounding)

Recommendations for use:

- Use at the highest possible rotational speeds. Please refer to our rotational speed and cutting speed recommendations.
- The burr contact surface to the workpiece can be up to a maximum of 30 % of the entire circumference.

Matching tool drives:

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



Safety notes:

-  = 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!

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 Establish the cutting speed range.

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

- 3 Select the required burr diameter.

- 4 The cutting speed range and burr diameter determine the recommended rotational speed range.

1 Material group			Application	Cut	2 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	General use	MX NCC	450–600 m/min
	Hardened, heat-treated steels over 1,200 N/mm ² (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel			250–350 m/min
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	General use	MX NCC	250–350 m/min
Non-ferrous metals	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminium alloys (high Si content)	General use	MX NCC	250–350 m/min
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)			250–450 m/min
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)	General use	MX NCC	450–600 m/min
Plastics and other materials	Fibre-reinforced plastics (GRP/CRP), thermoplastics, hard rubber, wood		General use	MX NCC	450–900 m/min

Example:

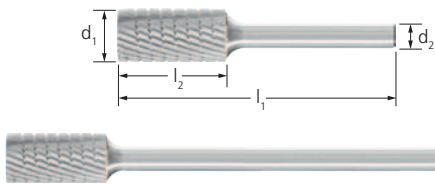
TC burr,
MX NCC cut,
burr dia. 12 mm.
Machining steels up to 1,200 N/mm².
Cutting speed: 450–600 m/min

Rotational speed range:
12,000–16,000 RPM

3 Burr dia. [mm]	4 Cutting speeds [m/min]				
	250	350	450	600	900
	Rotational speeds [RPM]				
2	40,000	56,000	72,000	95,000	143,000
3	27,000	37,000	48,000	64,000	95,000
4	20,000	28,000	36,000	48,000	72,000
6	13,000	19,000	24,000	32,000	48,000
8	10,000	14,000	18,000	24,000	36,000
10	8,000	11,000	14,000	19,000	29,000
12	7,000	9,000	12,000	16,000	24,000
16	5,000	7,000	9,000	12,000	18,000

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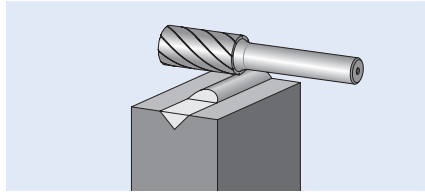
MX NCC cut for universal use



Cylindrical shape ZYA without end cut

Cylindrical burr according to DIN 8032.



SL = shank length (long steel shank)

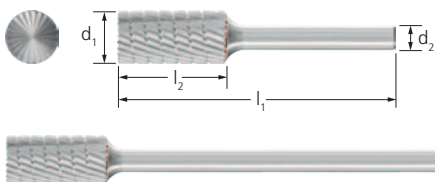


Safety notes:



Please observe the reduced rotational speeds for long-shank burrs. They can be found on page 3.

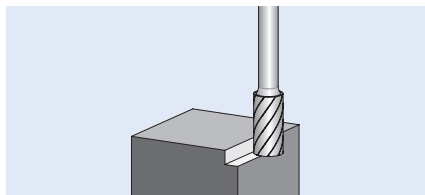
d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	Cut		Description
				MX NCC  EAN 4007220		
Shank dia. 3 mm						
3	13	3	40	935781	1	ZYA 0313/3 MX NCC
6	13	3	43	935798	1	ZYA 0613/3 MX NCC
Shank dia. 6 mm						
6	16	6	55	609149	1	ZYA 0616/6 MX NCC
8	20	6	60	935804	1	ZYA 0820/6 MX NCC
10	20	6	60	609156	1	ZYA 1020/6 MX NCC
12	25	6	65	609170	1	ZYA 1225/6 MX NCC
16	25	6	65	609187	1	ZYA 1625/6 MX NCC
Long shank dia. of 6 mm, SL 150 mm						
10	20	6	170	157749	1	ZYA 1020/6 MX NCC SL 150
12	25	6	175	157732	1	ZYA 1225/6 MX NCC SL 150



Cylindrical shape ZYAS with end cut

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



SL = shank length (long steel shank)



Safety notes:



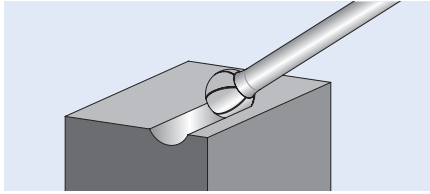
Please observe the reduced rotational speeds for long-shank burrs. They can be found on page 3.

d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	Cut		Description
				MX NCC  EAN 4007220		
Shank dia. 3 mm						
2	10	3	40	609231	1	ZYAS 0210/3 MX NCC
3	13	3	40	609262	1	ZYAS 0313/3 MX NCC
6	13	3	43	609378	1	ZYAS 0613/3 MX NCC
Shank dia. 6 mm						
6	16	6	55	609118	1	ZYAS 0616/6 MX NCC
8	20	6	60	935712	1	ZYAS 0820/6 MX NCC
10	20	6	60	625729	1	ZYAS 1020/6 MX NCC
12	25	6	65	609132	1	ZYAS 1225/6 MX NCC
16	25	6	65	935774	1	ZYAS 1625/6 MX NCC
Long shank dia. of 6 mm, SL 150 mm						
10	20	6	170	157787	1	ZYAS 1020/6 MX NCC SL 150
12	25	6	175	157763	1	ZYAS 1225/6 MX NCC SL 150

Ball shape KUD

Ball-shaped burr according to DIN 8032.

SL = shank length (long steel shank)





Safety notes:



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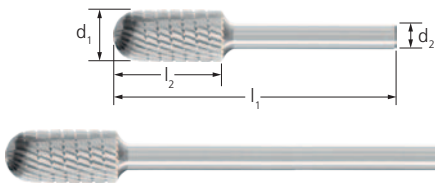


d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	Cut		Description
				MX NCC 		
				EAN 4007220		
Shank dia. 3 mm						
3	2	3	40	609538	1	KUD 0302/3 MX NCC
4	3	3	34	609552	1	KUD 0403/3 MX NCC
6	5	3	35	609576	1	KUD 0605/3 MX NCC
Shank dia. 6 mm						
6	5	6	55	609286	1	KUD 0605/6 MX NCC
8	7	6	47	935811	1	KUD 0807/6 MX NCC
10	9	6	49	609293	1	KUD 1009/6 MX NCC
12	10	6	51	609316	1	KUD 1210/6 MX NCC
16	14	6	54	609323	1	KUD 1614/6 MX NCC
Long shank dia. of 6 mm, SL 150 mm						
10	9	6	159	157824	1	KUD 1009/6 MX NCC SL 150
12	10	6	160	157800	1	KUD 1210/6 MX NCC SL 150



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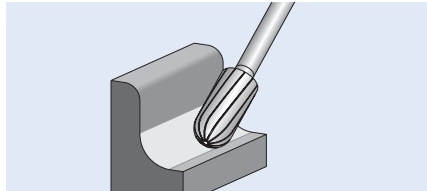
MX NCC cut for universal use



Cylindrical shape with radius end WRC

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



SL = shank length (long steel shank)



Safety notes:



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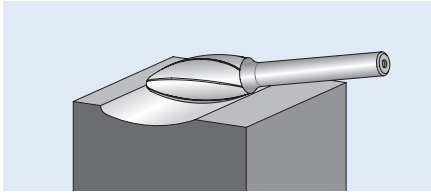
d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	Cut		Description
				MX NCC  EAN 4007220		
Shank dia. 3 mm						
2	10	3	40	609415	1	WRC 0210/3 MX NCC
3	13	3	40	609446	1	WRC 0313/3 MX NCC
6	13	3	43	609477	1	WRC 0613/3 MX NCC
Shank dia. 6 mm						
6	16	6	55	609224	1	WRC 0616/6 MX NCC
8	20	6	60	625736	1	WRC 0820/6 MX NCC
10	20	6	60	609248	1	WRC 1020/6 MX NCC
12	25	6	65	609255	1	WRC 1225/6 MX NCC
16	25	6	65	609279	1	WRC 1625/6 MX NCC
Long shank dia. of 6 mm, SL 150 mm						
10	20	6	170	157848	1	WRC 1020/6 MX NCC SL 150
12	25	6	175	157831	1	WRC 1225/6 MX NCC SL 150



Flame shape B

Flame-shaped burr according to ISO 7755/8.

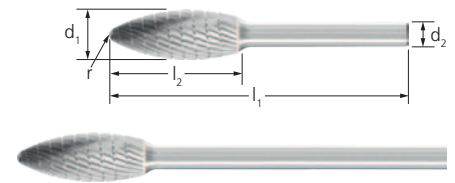
SL = shank length (long steel shank)





Safety notes:



Please observe the reduced rotational speeds for long-shank burrs. They can be found on page 3.



d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	r [mm]	Cut		Description
					MX NCC 		
					EAN 4007220		

Shank dia. 6 mm

12	30	6	70	2.1	609194	1	B 1230/6 MX NCC
16	35	6	75	2.6	609217	1	B 1635/6 MX NCC

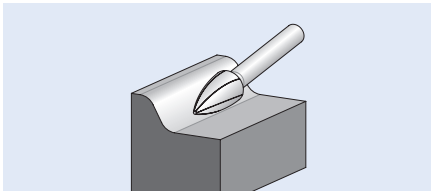
Long shank dia. of 6 mm, SL 150 mm

12	30	6	180	2.1	157879	1	B 1230/6 MX NCC SL 150
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Pointed tree shape SPG

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

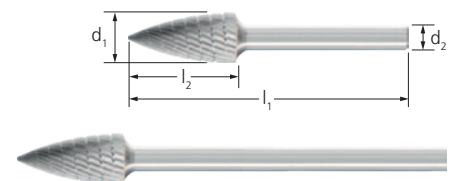
SL = shank length (long steel shank)





Safety notes:



Please observe the reduced rotational speeds for long-shank burrs. They can be found on page 3.



d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	Cut		Description
				MX NCC 		
				EAN 4007220		

Shank dia. 3 mm

3	13	3	40	609668	1	SPG 0313/3 MX NCC
6	13	3	43	609682	1	SPG 0613/3 MX NCC

Shank dia. 6 mm

6	18	6	55	609422	1	SPG 0618/6 MX NCC
8	20	6	60	935859	1	SPG 0820/6 MX NCC
10	20	6	60	609439	1	SPG 1020/6 MX NCC
12	25	6	65	609453	1	SPG 1225/6 MX NCC
16	25	6	65	609484	1	SPG 1625/6 MX NCC

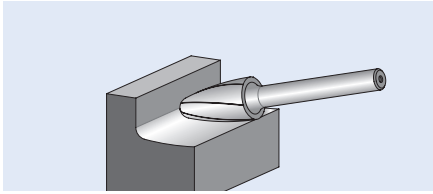
Long shank dia. of 6 mm, SL 150 mm

10	20	6	170	157893	1	SPG 1020/6 MX NCC SL 150
12	25	6	175	157886	1	SPG 1225/6 MX NCC SL 150

Tree shape with radius end RBF

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

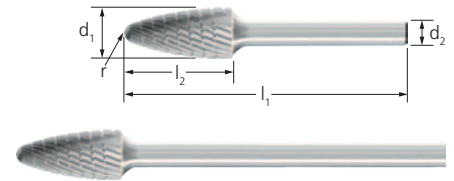
SL = shank length (long steel shank)





Safety notes:



Please observe the reduced rotational speeds for long-shank burrs. They can be found on page 3.



d ₁ [mm]	l ₂ [mm]	d ₂ [mm]	l ₁ [mm]	r [mm]	Cut		Description
					MX NCC 		
					EAN 4007220		

Shank dia. 3 mm

3	7	3	40	0.75	609620	1	RBF 0307/3 MX NCC
6	13	3	43	1.5	609644	1	RBF 0613/3 MX NCC

Shank dia. 6 mm

6	18	6	55	1.5	609361	1	RBF 0618/6 MX NCC
8	20	6	60	1.2	935835	1	RBF 0820/6 MX NCC
10	20	6	60	2.5	609385	1	RBF 1020/6 MX NCC
12	25	6	65	2.5	609392	1	RBF 1225/6 MX NCC
16	25	6	65	4.9	609408	1	RBF 1625/6 MX NCC

Long shank dia. of 6 mm, SL 150 mm

10	20	6	170	2.5	157954	1	RBF 1020/6 MX NCC SL 150
12	25	6	175	2.5	157947	1	RBF 1225/6 MX NCC SL 150





Set 6/5-12 MX NCC

Set 6/5-12 MX NCC contains the five most common shapes with burr diameter 12 mm with universal cut MX NCC. The sturdy plastic box with screw cap protects the tools from dirt and damage.

Contents:

- 5 tungsten carbide burrs,
shank dia. 6 mm, MX NCC cut
1 piece each:
- ZYA 1225/6 MX NCC
 - KUD 1210/6 MX NCC
 - WRC 1225/6 MX NCC
 - SPG 1225/6 MX NCC
 - RBF 1225/6 MX NCC



Cut		Description
MX NCC		
 EAN 4007220		

Shank dia. 6 mm

935699	1	6/5-12 MX NCC
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Set 6/10-01 MX NCC


Set 6/10-01 MX NCC contains the ten most common burrs with universal cut MX NCC. The sturdy plastic box with screw cap protects the tools from dirt and damage.

Contents:

- 10 tungsten carbide burrs,
shank dia. 6 mm, MX NCC cut
1 piece each:
- ZYA 0616/6 MX NCC
 - ZYA 1225/6 MX NCC
 - KUD 1009/6 MX NCC
 - KUD 1210/6 MX NCC
 - WRC 0616/6 MX NCC
 - WRC 1225/6 MX NCC

- SPG 0618/6 MX NCC
- SPG 1225/6 MX NCC
- RBF 0618/6 MX NCC
- RBF 1225/6 MX NCC



Cut		Description
MX NCC		
 EAN 4007220		

Shank dia. 6 mm

614990	1	6/10-01 MX NCC
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