

### Cut MICRO



Tungsten carbide burrs with MICRO cut are specifically designed for finishing. They are well suited for manual and machine applications and are characterized by good stock removal and a high surface quality.

The MICRO cut can be used for work on almost all materials up to a hardness of 68 HRC. Tungsten carbide burrs with MICRO cut can be used in areas in which mounted points are usually used, but where a high stock removal is also required. They work with less noise and low vibrations.

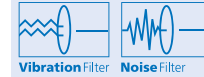
### Application examples:

- Finishing
- Very fine cleaning work
- Corrections in tool and mould construction
- Sharpening of cutting tools

### Advantages:

- High surface quality
- Unlike with mounted points, there is no change in geometry due to wear and tear
- Work on almost all materials up to 68 HRC

PFERDERGONOMICS® recommends burrs with MICRO cut as an innovative tool solution for comfortable working with significantly reduced vibration and lower noise.



### Recommended rotational speed range

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, please proceed as follows:

- 3 Select the required burr diameter
- 4 The cutting speed range and the burr diameter determine the recommended rotational speed range



1 Material group		Application	Cut	2 Cutting speed
Steel, cast steel	Non-hardened, non-heat-treated steels up to 1,200 N/mm <sup>2</sup> (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel	MICRO	600–750 m/min
	Hardened, heat-treated steels over 1,200 N/mm <sup>2</sup> (> 38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel		450–600 m/min
Stainless steel (INOX)	Rust- and acid-resistant steels	Austenitic and ferritic stainless steels	MICRO	450–600 m/min
Non-ferrous metals	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminium alloys (high Si content)	MICRO	450–600 m/min
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)		
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)	MICRO	600–750 m/min

### Example:

TC burr,  
Cut MICRO,  
Burr dia. 10 mm.  
Fine stock removal on non-hardened, non-heat-treated steels  
Cutting speed: 600–750 m/min  
**Rotational speed: 19,000–24,000 RPM**

3 Burr dia. [mm]	4 Cutting speed [m/min]		
	450	600	750
	Rotational speed [RPM]		
2	72,000	95,000	120,000
3	48,000	64,000	80,000
4	36,000	48,000	60,000
6	24,000	32,000	40,000
8	18,000	24,000	30,000
10	14,000	19,000	24,000
12	12,000	16,000	20,000



### PFERDVIDEO

You will receive more information here or at [www.pferd.com](http://www.pferd.com)

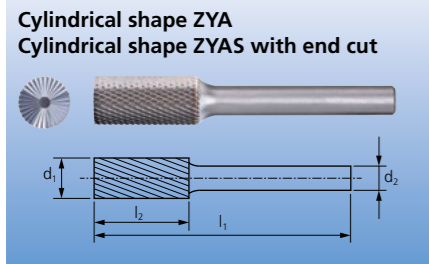
# Tungsten carbide burrs

TC burrs for finishing



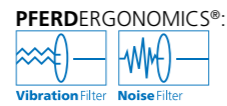
# Tungsten carbide burrs

TC burrs for finishing



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

**Ordering example:**  
EAN 4007220895511  
ZYA 0210/3 MICRO



Description	Cut	Shank dia. d <sub>2</sub> [mm]	Burr dia. x length d <sub>1</sub> x l <sub>2</sub> [mm]	Overall length l <sub>1</sub> [mm]	1
	MICRO				
	EAN 4007220				

**Shank dia. 3 mm without end cut**

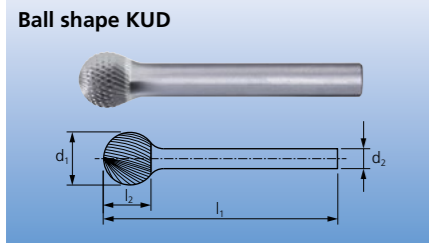
ZYA 0210/3	895511	3	2 x 10	40	1
ZYA 0313/3	895535	3	3 x 13	43	1
ZYA 0413/3	895542	3	4 x 13	43	1
ZYA 0613/3	953068	3	6 x 13	43	1

**Shank dia. 6 mm without end cut**

ZYA 0616/6	895559	6	6 x 16	55	1
ZYA 0820/6	895573	6	8 x 20	60	1
ZYA 1020/6	895603	6	10 x 20	60	1
ZYA 1225/6	953051	6	12 x 25	65	1

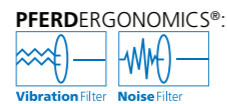
**Shank dia. 6 mm with end cut**

ZYAS 0616/6	895566	6	6 x 16	55	1
ZYAS 0820/6	895580	6	8 x 20	60	1
ZYAS 1020/6	895610	6	10 x 20	60	1
ZYAS 1225/6	953105	6	12 x 25	65	1



Ball-shaped burr according to DIN 8032.

**Ordering example:**  
EAN 4007220895399  
KUD 021,5/3 MICRO



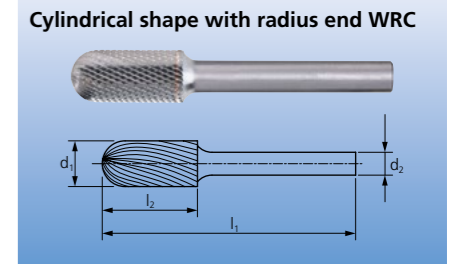
Description	Cut	Shank dia. d <sub>2</sub> [mm]	Burr dia. x length d <sub>1</sub> x l <sub>2</sub> [mm]	Overall length l <sub>1</sub> [mm]	1
	MICRO				
	EAN 4007220				

**Shank dia. 3 mm**

KUD 021,5/3	895399	3	2 x 1.5	33	1
KUD 0302/3	895405	3	3 x 2	33	1
KUD 0403/3	895412	3	4 x 3	34	1
KUD 0605/3	953129	3	6 x 5	35	1

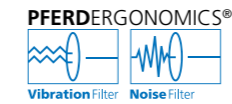
**Shank dia. 6 mm**

KUD 0605/6	895436	6	6 x 5	35	1
KUD 0807/6	895474	6	8 x 7	47	1
KUD 1009/6	895481	6	10 x 9	49	1
KUD 1210/6	953112	6	12 x 10	51	1



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

**Ordering example:**  
EAN 4007220869000  
WRC 0313/3 MICRO



Description	Cut	Shank dia. d <sub>2</sub> [mm]	Burr dia. x length d <sub>1</sub> x l <sub>2</sub> [mm]	Overall length l <sub>1</sub> [mm]	1
	MICRO				
	EAN 4007220				

**Shank dia. 3 mm**

WRC 0210/3	953167	3	2 x 10	43	1
WRC 0313/3	869000	3	3 x 13	43	1
WRC 0613/3	953150	3	6 x 13	43	1

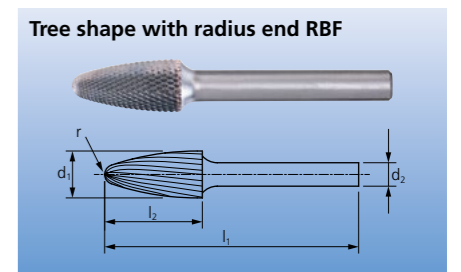
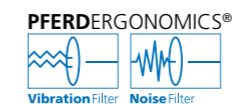
**Shank dia. 6 mm**

WRC 0616/6	869017	6	6 x 16	55	1
WRC 0820/6	869024	6	8 x 20	60	1
WRC 1020/6	869031	6	10 x 20	60	1
WRC 1225/6	953136	6	12 x 25	65	1



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

**Ordering example:**  
EAN 4007220835524  
RBF 0307/3 MICRO



Description	Cut	Shank dia. d <sub>2</sub> [mm]	Burr dia. x length d <sub>1</sub> x l <sub>2</sub> [mm]	Overall length l <sub>1</sub> [mm]	Radius r [mm]	1
	MICRO					
	EAN 4007220					

**Shank dia. 3 mm**

RBF 0307/3	835524	3	3 x 7	37	0.75	1
RBF 0313/3	955352	3	3 x 13	43	0.75	1
RBF 0613/3	955338	3	6 x 13	43	1.5	1

**Shank dia. 6 mm**

RBF 0618/6	835494	6	6 x 18	55	1.5	1
RBF 0820/6	835500	6	8 x 20	60	1.2	1
RBF 1020/6	835517	6	10 x 20	60	2.5	1
RBF 1225/6	953143	6	12 x 25	65	2.5	1



# Tungsten carbide burrs

## TC burrs for finishing



### Set 1502 HM



**Set 1502 HM** contains ten tungsten carbide burrs for finishing in the most common shapes and dimensions. The sturdy plastic box protects the tools from dirt and damage.

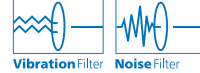
#### Contents:

10 tungsten carbide burrs,  
shank diameter 3 mm, cut MICRO

1 piece each:

ZYA 0210/3 MICRO	WRC 0613/3 MICRO
ZYA 0313/3 MICRO	KUD 0302/3 MICRO
ZYA 0613/3 MICRO	KUD 0605/3 MICRO
WRC 0210/3 MICRO	RBF 0307/3 MICRO
WRC 0313/3 MICRO	RBF 0613/3 MICRO

#### PFERDERGONOMICS®:



Description	Cut	Shank dia. [mm]	
	MICRO  EAN 4007220		
<b>Shank dia. 3 mm</b>			
Set 1502 HM	896181	3	1

