CFC TOOLS
CUTTING TOOLS

TUNGSTEN CARBIDE BURR RPM SELECTION INSTRUCTION

Recommended rotational speed

1. Select material type
2. Determine cutting speed
3. Select burr diameter
4. Match cutting speed with RPM in RPM table

MATERIAL TYPE			CUTTING SPEED
STEEL, CAST STEEL	Steels up to 1,200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case hardened steels, cast steel, alloyed steels	450–750 m/min
	Hardened, heat-treated steels over 1,200 N/mm² (> 38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel	250–450 m/min
Stainless steel (INOX)	Rust and acid-resistant steels	Stainless steels	450–600 m/min
Non ferrous metals	Soft non-ferrous metals	Brass, copper, zinc	450–750 m/min
	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminium alloys	450–600 m/min
Cast iron	Grey cast iron, white cast iron	Cast iron, white annealed cast iron, black cast iron	450–900 m/min

RPM TABLE BURR DIA. (MM)	CUTTING SPEED (M/MIN)				
	250	450	600	750	900
	RPM				
6	13,000	24,000	32,000	40,000	48,000
8	10,000	18,000	24,000	30,000	36,000
10	8,000	14,000	19,000	24,000	29,000
12	7,000	12,000	16,000	20,000	24,000
16	5,000	9,000	12,000	15,000	18,000

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