Carbide burs and bi-metal hole saws

PFERD

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Carbide burs and bi-metal hole saws
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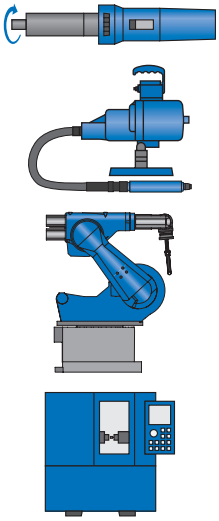
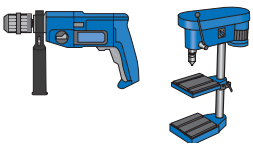
Milling



Carbide burs

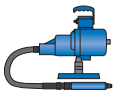
Bur sets, extended shank burs, and HICOAT® coated burs can be found on the pages for the respective bur cuts.

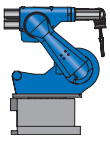
Cutting out holes

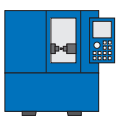


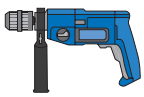
Bi-metal hole saws

 Straight grinder

 Flexible shaft

 Robot

 CNC machines

 Power drill

 Drill press

Visit pferd.com for more information.

PFERD carbide burs and bi-metal hole saws are developed, manufactured and tested in accordance with the strictest quality requirements. Research and development, our in-house and plant construction, and the continuous testing to quality and safety standards in our internal laboratories all guarantee high PFERD quality.

PFERD quality management is certified according to ISO 9001.

Technical customer support

PFERD offers individual targeted support to solve unique application problems. Our experienced sales representatives and technical applications specialists are available to assist you.

Contact your local sales representative or visit us at pferd.com to learn more.

Packaging

PFERD carbide burs and bi-metal hole saws are packaged to provides optimum protection. All burs are supplied individually packed in a sturdy plastic box. Bi-metal hole saws are supplied in a practical card box. Packaging can also be easily displayed on **PFERD**TOOL-CENTER units. The packaging labels feature easy identification of product features and part number.

PFERDTOOL-CENTER

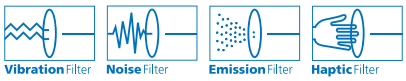
The **PFERD**TOOL-CENTER is a premium display system that can be custom-designed to meet your specific product and presentation requirements, including lockable cases specially designed for displaying carbide burs. For more information from a PFERD expert, contact us today at pferd.com.

PFERDVALUE® – Your added value with PFERD

Results from the PFERD test laboratories as well as from the product tests by independent testing institutes prove: PFERD products offer measurable added value.

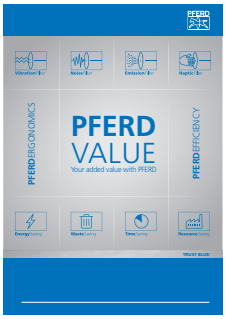
Discover **PFERD**ERGONOMICS® and **PFERD**EFFICIENCY®:

As part of **PFERD**ERGONOMICS®, PFERD offers ergonomically optimized products and power tools that contribute to greater safety and working comfort, and thus to health protection.



As part of **PFERD**EFFICIENCY®, PFERD offers innovative, high-performance solutions with outstanding added value.

For more information please refer to our brochure "**PFERD**VALUE® – Your added value with PFERD".



Carbide burs and bi-metal hole saws
Quick product selection guide

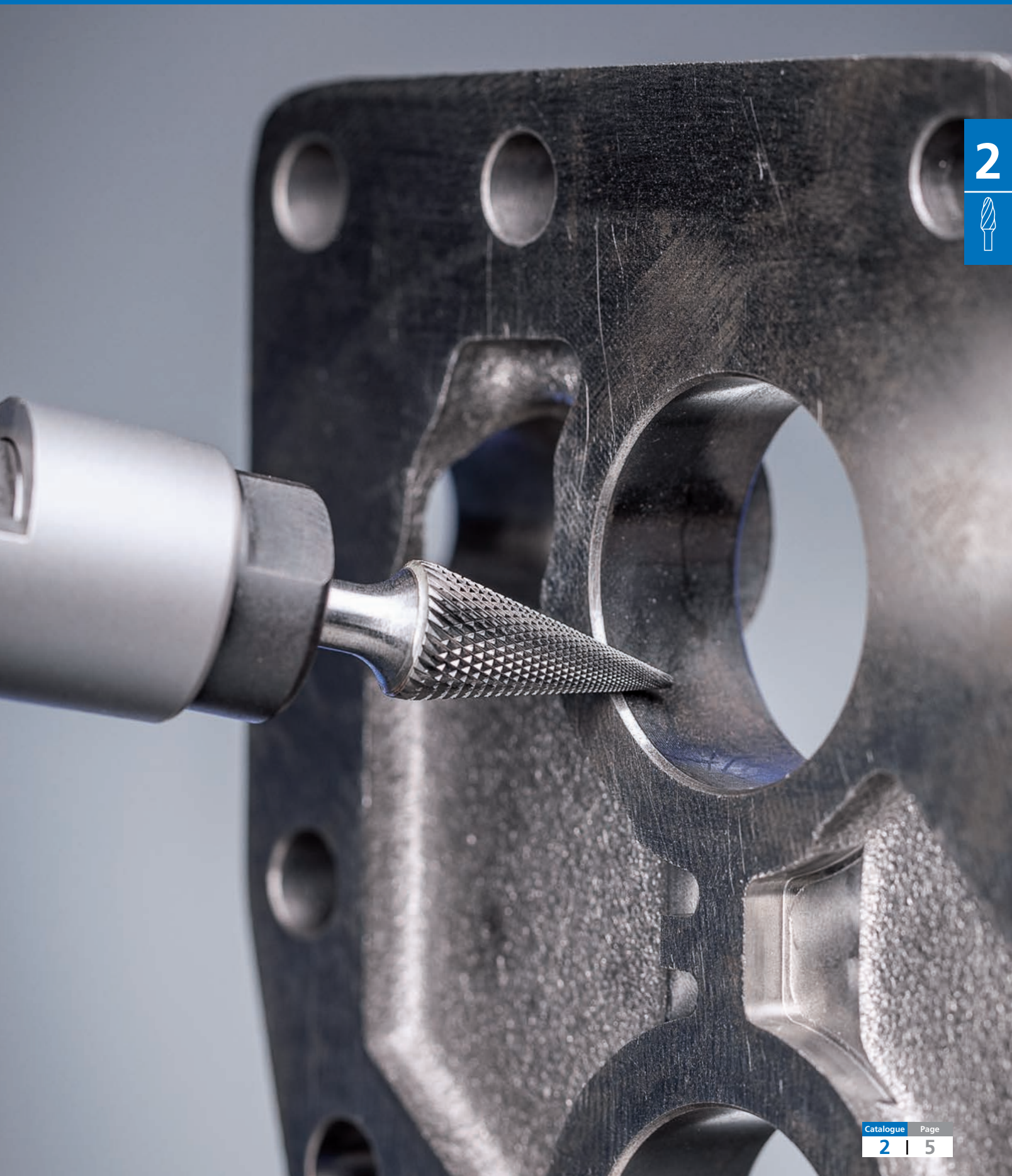
Application	Material group			Application	High-performance line	P.	Performance line	P.	Universal line	P.
Deburring, chamfering, milling out for the preparation of build-up welding, machining weld seams, machining contours, cleaning cast material	Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal	STEEL cut	38	OMNI cut	29	Double cut	14
				Fine stock removal	MICRO cut	65	-	-	Single cut	
		Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel	Coarse stock removal	STEEL cut	38	OMNI cut	29	Double cut	
				Fine stock removal	MICRO cut	65	-	-	Single cut	
	Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse stock removal	INOX cut	43	OMNI cut	29	Diamond cut	14
				Fine stock removal	MICRO cut	65	-	-	-	
	Non-ferrous metals	Soft non-ferrous metals	Aluminum alloys	Coarse stock removal	ALU cut	48	-	-	Single cut	14
				Fine stock removal						
			Brass, copper, zinc	Coarse stock removal	ALU cut	48	OMNI cut	29	Single cut	
				Fine stock removal			-	-		
		Hard non-ferrous metals	Bronze, titanium/ titanium alloys, hard aluminum alloys (high Si content)	Coarse stock removal	ALU cut	48	OMNI cut	29	Diamond cut	
					INOX cut	43				
				Fine stock removal	MICRO cut	65	-	-	Single cut	
		High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)	Coarse stock removal	On request	-	-	-	Diamond cut	
				Fine stock removal	MICRO cut	65	-	-	Single cut	
	Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse stock removal	CAST cut	55	OMNI cut	29	Double cut	14
				Fine stock removal	MICRO cut	65	-	-	Single cut	
Trimming, contour milling, cutting out holes	Plastics, other materials	Thermoplastics, fibre-reinforced plastics (GRP/CRP) with a fibre content > 40 %		Coarse stock removal	ALU cut	48	-	-	-	-

Special applications

Application	High-performance/performance line	Page	Universal line	Page
Work on edges	Carbide burs for work on edges	69	-	-
Applications resulting in broken teeth	Carbide burs – TOUGH cut	59	-	-
Cutting out round holes	-	-	Bi-metal hole saws	73

PFERD

Carbide burs



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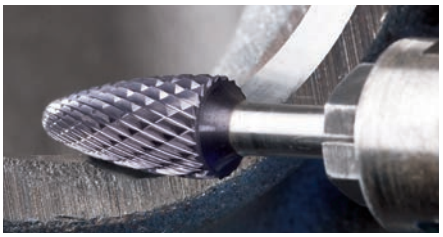
Extended shank burs

Tungsten carbide extended shank burs are particularly well suited to working in hard-to-reach areas. PFERD offers long-shank versions for the respective product groups.

Long-shank versions are available with the Double, OMNI, STEEL and TOUGH cuts. All extended shanks can be individually shortened, and additional versions can be custom-made on request.

Please observe the safety regulations for extended shanl burs on page 11.



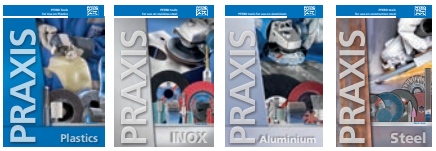
HICOAT® coatings

PFERD offers carbide burs with HICOAT® coatings to tackle particularly demanding applications. The anti-wear coatings enable effective chip removal due to the improved anti-adhesion characteristics and increase in the product's service life. Two different coatings are available. The HICOAT® coating HC-FEP is specifically designed for iron and steel materials. The HICOAT® coating HC-NFE is mainly used for long-chipping and lubricating aluminum alloys and non-ferrous metals.

Automated applications

PFERD milling tools can be used on automated machines such as robots and CNC machines. The optimum bur for your application depends on the process requirements.

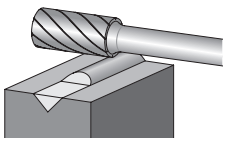
Our sales representatives and technical applications specialists will be happy to assist you in selecting the most suitable bur.



PFERDPRAXIS **brochures**

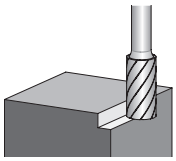
Our **PFERD**PRAXIS brochures contain a wealth of useful information on material properties as well as tips and tricks for using PFERD products on specific materials or for specific applications.

Cylindrical shape



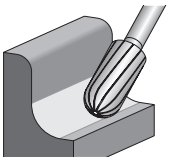
Shape A

Cylindrical shape with end cut



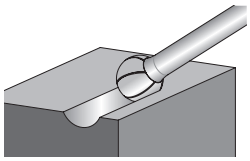
Shape B

Cylindrical shape with radius end



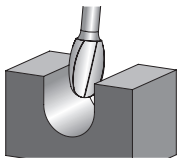
Shape C

Ball shape



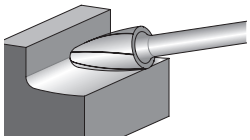
Shape D

Oval shape



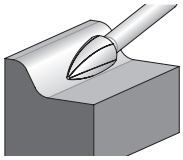
Shape E

Tree shape with radius end



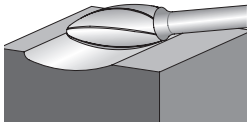
Shape F

Pointed tree shape



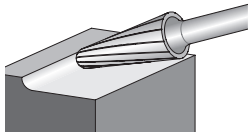
Shape G

Flame shape



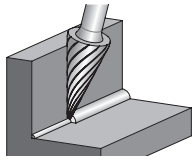
Shape H

Cone shape with radius end



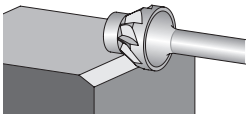
Shape L

Cone pointed shape



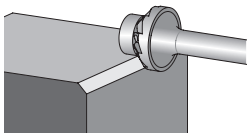
Shape M

EDGE 30°



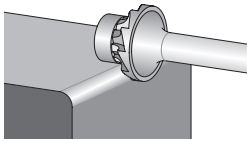
Shape EDGE 30°

EDGE 45°



Shape EDGE 45°

EDGE R-1/8”



Shape EDGE R-1/8”

Carbide burs
PFERD cuts and their application

PFERD cuts for universal applications

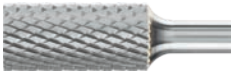
Single cut

- Machining of steel, cast iron, stainless steel (INOX), nickel-based alloys and titanium alloys.
- High stock removal.
- Good surface finish.

Double cut

- Similar to single cut, but with cross cut.
- Machining of steel, cast iron, stainless steel (INOX), nickel-based alloys and titanium alloys.
- High stock removal.

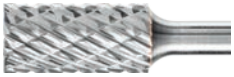
Diamond cut



- Machining of stainless steel (INOX), steel and high-temperature-resistant materials such as nickel-based and cobalt-based alloys.
- High stock removal with short chips.
- Good surface finish.

PFERD cuts for performance applications

OMNI cut



- High stock removal rate on key materials such as steel, cast steel, stainless steel (INOX), non-ferrous metals and cast iron.
- Similar to the double cut but with a significantly higher stock removal rate.

PFERD cuts for high-performance applications

STEEL cut

- Extremely high stock removal rate on steel and cast steel.
- Smooth milling.
- Reduced vibration and less noise.

INOX cut

- Extremely high stock removal rate on all austenitic, rust and acid-resistant steels, stainless steel (INOX) and soft titanium alloys.
- Significantly reduced vibration and less noise.

ALU cut

- High stock removal rate on aluminum and aluminum alloys, non-ferrous metals and plastics.
- Smooth milling.

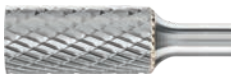
CAST cut

- Extremely high stock removal rate on cast iron.
- Smooth milling.
- Reduced vibration and less noise.

EDGE cut

- Creates exact edge shapes – with either 30° or 45° chamfering or a defined radius of 1/8".
- Safe and comfortable to guide.

TOUGH cut



- High stock removal rate on cast iron, steel up to 580 HV (54 HRC).
- Extremely resistant to impacts.
- Suitable for use with high surface contact angles > 1/3 and under impact loads.

MICRO cut

- Good stock removal on almost all materials up to 940 HV (68 HRC).
- High surface quality.
- Reduced vibration and less noise.

HICOAT® coatings

- PFERD carbide burs are also available with HICOAT® coatings.
- Improved anti-adhesion characteristics.
- Effective chip discharge.
- Lower thermal loads.
- Increased service life.
- Also suitable for use at higher peripheral speeds when compared with uncoated burs.

If you cannot find the solution for your particular application in our extensive catalogue range, we can produce carbide burs to meet your requirements in premium PFERD quality specifically for your application upon request.

Contact your local sales representatives who will be happy to assist you.

As a tool manufacturer with over 200 years of experience, PFERD can call on comprehensive expertise in the manufacture of metalworking 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 product. 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.

1. We analyze your application.

We will discuss and analyze your application on-site and develop the most economic solution for your specific application.

Contact us for details and to set up an appointment.

2. We develop the solution.

This is based on your needs, application requirements and other criteria. From inspection of raw materials, to the inspection of the final product itself – PFERD always works to the highest quality standards.

The quality of PFERD products is certified according to ISO 9001.

3. Your product is ready for use!

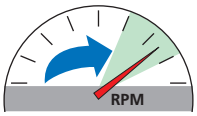
Our flexible production and global logistics network ensure your custom product is delivered on-time and within your budget.

See the quality, performance and economic value of PFERD products for yourself!

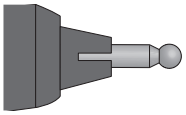
Carbide burs
Recommendations for use and instances of misuse

Recommendations for use:

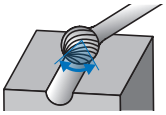
An optimum rotational speed and power output for the power tool (air-powered or electric grinders, flexible shaft drive) is required for cost-effective use of carbide burs.



- If possible, mount burs on high-powered drives with elastically mounted spindles to avoid vibration.
- For cost-effective use of burs with a shank diameter > 1/4", a power tool output of 300–500 watts is required when used at a higher rotational speed and peripheral speed.
- Use the highest rotational speed possible within the recommended rotational speed and peripheral speed ranges.
- For applications with low stock removal (deburring, chamfering, minor work on surfaces), the rotational speed can be increased by up to 100% (this excludes extended shank burs).

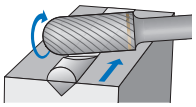


- Use only rigid clamping systems and power tools as impacts on the burs and bur chatter lead to premature wear.



1/3 of the total surface

- The bur surface in contact with the workpiece must not exceed 1/3 of the total bur surface. Failure to comply with this recommendation will result in rough milling behaviour and possibly in broken teeth. If this cannot be avoided, we recommend using the TOUGH cut.



In direction of rotation
= fine finish

- In general, burs are used counterrotationally or with a swinging motion. To achieve finer finishes, pass the bur rapidly over the workpiece in the direction of rotation.

Safety notes:

= Wear eye protection!

= Wear hearing protection!

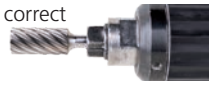
= Wearing protective gloves is recommended. Handle the power tool with both hands.

= Observe the recommended rotational speed, especially when using extended shank burs!

= Read the Safety Data Sheets (SDS) before using any materials!

Avoiding misuse

Figure	Consequences of misuse	Solution
	The bur becomes clogged during use.	Use the correct cut for the material being machined. Use tools with a HICOAT® coating or use grinding oil.
	Pronounced discolouration can be seen in the transition between the toothed section and the shank.*	Observe the recommended rotational speeds and/or reduce the contact pressure and surface contact angle.
	The head detaches from the shank.	
	There are flying sparks.	Reduce the rotational speed and contact pressure and make sure that the surface contact angle is no more than 1/3 of the bur surface.
	Bur head shows severe chipping or splintering.	Avoid impact loads when using the bur.

Figure	Consequences of misuse	Solution
	The shank breaks.	Only use rigid power tools and undamaged clamping systems, and replace them if necessary.
incorrect  correct 	The clamping length is incorrect.	Do not chose a bur clamping depth that is too short. **In general,** the minimum clamping depth is 2/3 of the shank length (does not apply to extended shank burs).
	The shank bends on Extended shank burs.	Observe the recommended rotational speeds and safety notes for extended shank burs.
	Signs of wear such as rough running and strong vibrations occur, as well as increased flying sparks.	Do not use burs beyond the end of their service life. Use a new bur instead.

* On burs designed for high-performance applications, blue discolouration is extremely difficult to avoid on account of the very high stock removal rate. However, this does not constitute a safety risk.

Extended shank burs are ideal for cost-effectively machining small, hard-to-reach areas on components. Long-shank versions are available with the Double, OMNI, STEEL and TOUGH cut burs.

Extended shank burs can be shortened if required.
SL = shank length (long steel shank)

Safety notes:

Not suitable for robotic or stationary applications. **Risk of bending**. Use only rigid clamping systems/power tools.

= Observe the prescribed rotational speed!

Safety note – maximum rotational speed [RPM] for extended shank burs

When working with extended shank burs, it is critical that the bur is in contact with the workpiece (or inserted in the bore or slot to be machined) before the power tool is turned on. As a rule, the bur must remain in contact with the workpiece for as long as the machine is running. Failure to observe this procedure may result in shank failure (bending) and hence an increased risk of accidents. If continuous contact between the bur and the workpiece is not guaranteed, the ❸ maximum idling speeds stated in the table must not be exceeded.

For safety reasons, the maximum application speeds ❷ **with contact with the workpiece** require a reduction in the recommended speed of carbide burs with standard shanks. The reduced speeds are stated in the table below.

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

❶ Select the required bur diameter.
❷ For the maximum application speed [RPM] with contact with the workpiece, please refer to the right-hand side of the table.

Example
Carbide bur, L6, double cut,
bur diameter: 1/2".
Coarse stock removal on steels
up to 370 HV.
Recommended reduced speed with workpiece contact: 7,000 RPM

❶ Bur dia. [Inches]	❸ Maximum rotational free speed [RPM] (No contact to the workpiece)	❷ Recommended reduced rotational application speed [RPM] (With contact to the workpiece)
	Shank length [Inches]	
	L6 (6")	L6 (6")
1/4	8,000	15,000
5/16	6,000	11,000
3/8	4,000	9,000
1/2	3,000	7,000

Extensions for spindles

In some applications, spindle extensions are an economic alternative to customized extended shank burs. For more information please see page 12.

Burs (shank dia. 1/8, 1/4 and 3/8 inch) can be extended with spindle extensions. They allow access to hard-to-reach areas. The drive spindle extension is mounted in the collet of the power tool (air-powered or electric), or in the handpiece of the flexible shaft drive. In some applications, spindle extensions are an economical alternative to customized extended shank burs.

Safety notes:

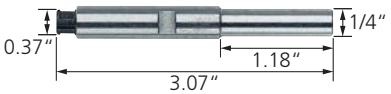
- For safety reasons, it is not possible to use spindle extensions in combination with extended-shank burs.
- For additional safety notes, please refer to catalogue section 9.

= Read the safety notes!

More detailed information and ordering information for spindle extensions can be found in catalogue section 9.

SPV 50-1/8 S1/4
for shank diameter of 1/8"

EDP 95820



SPV 75-1/4 SPG 6
for shank diameter of SPG 6

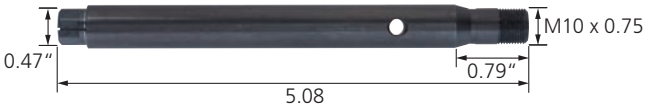
EDP 95821

SPV 75-1/4 S3/8
for shank diameter of 3/8

EDP 95822

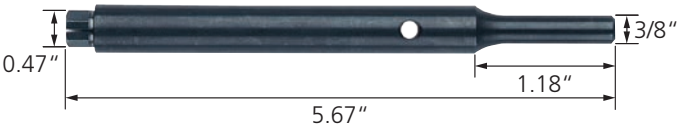
SPV 100-1/4 SPG 6
for shank diameter of SPG 6

EDP 95823



SPV 100-1/4 S3/8
for shank diameter of 3/8"

EDP 95824

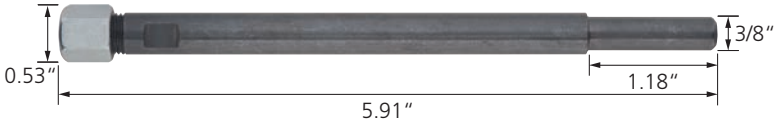


SPV 150-1/8 S1/4
for shank diameter of 1/4"

EDP 95825

SPV 150-1/4 S3/8
for shank diameter of 3/8"

EDP 95826



PFERD

Carbide burs, universal line

2

Carbide burs, universal line
For fine and coarse stock removal

Universal line burs are suitable for fine and coarse stock removal on the key materials used in industrial manufacturing. They provide a good stock removal rate and are not specific to a particular material.

Advantages:

- Good stock removal rate through optimum matching of tungsten carbide, geometry, cut and available coating.
- Long service life.
- Reduced wear on the power tool due to impact-free work without chatter marks, due to the high concentricity.
- High surface quality.

Workpiece materials:

- Steel, cast steel
- Stainless steel (INOX)
- Non-ferrous metals
- Cast iron

Applications:

- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Recommendations for use:

- If possible, use the burs on powerful tools with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burs, work with higher rotational/peripheral speeds.
  Power recommendation for power tools:
  - Shank diameter of 1/8": 75 to 300 watts
  - Shank diameter of 1/4": from 300 watts
- Please observe the rotational speed recommendations.

Compatible with:

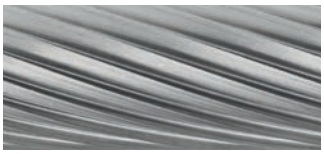
- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

PFERDVALUE®:

PFERDEFFICIENCY® recommends burs with HICOAT® coating for long fatigue-free and resource-saving work with perfect results in a very short period of time.

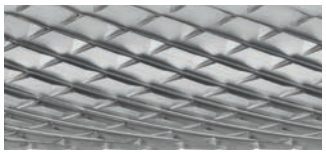
Waste Saving **Time** Saving

Single cut



- Machining of cast iron, steel, stainless steel (INOX), nickel-based alloys and titanium alloys.
- High stock removal.
- Good surface.

Diamond cut



- Machining of stainless steel (INOX), steel and high-temperature-resistant materials such as nickel-based and cobalt-based alloys.
- High stock removal with short chips.
- Good surface.

Double cut

- Similar to Single cut, but with cross cut.
- Machining of cast iron, steel, stainless steel (INOX), nickel-based alloys and titanium alloys.
- High stock removal.

HICOAT® coating HC-FEP for iron and steel materials

- High hardness and wear resistance.
- Effective chip removal through improved anti-adhesion characteristics.
- Very high resistance against thermal load.
- Increased service life.
- Also suitable for use at higher peripheral speeds when compared with uncoated burs.

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Determine the type of application.
❸ Select the cut.
❹ Establish the peripheral speed range.

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

❺ Select the required bur diameter.
❻ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

❶ Material group			❷ Application	❸ Cut	❹ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal	Double cut	2,000 - 3,000 SFPM
				HICOAT® HC-FEP	1,500 - 2,500 SFPM
			Fine stock removal	Single cut	1,500 - 2,000 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel	Coarse stock removal	Single cut	850 - 1,150 SFPM
				Double cut	
				Diamond cut	
				HICOAT® HC-FEP	850 - 1,500 SFPM
			Fine stock removal	Single cut	1,150 - 1,500 SFPM
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse stock removal	Single cut	1,150 - 1,500 SFPM
				Double cut	850 - 1,150 SFPM
				Diamond cut	
			Fine stock removal	Single cut	1,150 - 1,500 SFPM
Non-ferrous metals	Soft non-ferrous metals	Aluminum alloys, brass, copper, zinc	Coarse stock removal	Single cut	2,000 - 3,000 SFPM
			Fine stock removal	Single cut	1,150 - 1,500 SFPM
	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminum alloys (high Si content)	Coarse stock removal	Single cut	850 - 1,150 SFPM
				Diamond cut	
			Fine stock removal	Single cut	1,150 - 1,500 SFPM
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)	Coarse stock removal	Double cut	850 - 1,500 SFPM
				Diamond cut	
			Fine stock removal	Single cut	1,150 - 2,000 SFPM
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse stock removal	Double cut	1,500 - 2,000 SFPM
			Fine stock removal	Single cut	

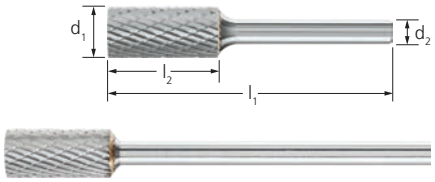
Example:
Carbide bur,
double cut,
bur diameter 1/2"
Coarse stock removal on steels
up to 370 HV.
Peripheral speed: 2,000–3,000 SFPM
Rotational speed range:
16,000–24,000 RPM

Safety note:

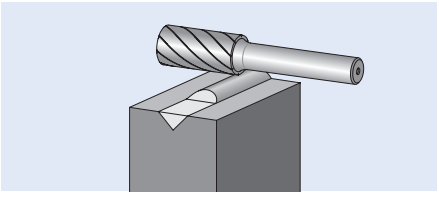
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

❺ Bur dia. [Inches]	❻ Peripheral speed [SFPM]					
	850	1,150	1,500	2,000	2,500	3,000
	Rotational speed [RPM]					
3/32	35,000	56,000	72,000	95,000	119,000	120,000
1/8	27,000	37,000	48,000	64,000	80,000	95,000
3/16	16,000	22,000	29,000	38,000	48,000	57.000
1/4	13,000	19,000	24,000	32,000	40,000	48,000
5/16	10,000	14,000	18,000	24,000	30,000	36,000
3/8	8,000	11,000	14,000	19,000	24,000	29,000
7/16	7,500	10,000	13,000	17,500	22,000	26,500
1/2	7,000	9,000	12,000	16,000	20,000	24,000
5/8	5,000	7,000	9,000	12,000	15,000	18,000
3/4	4,000	6,000	7,000	10,000	13,000	14,000
1	3,000	4,000	6,000	8,000	10,000	11,000

Carbide burs, universal line
For fine and coarse stock removal



Cylindrical bur with plain end (uncut) – Shape A



Safety notes:

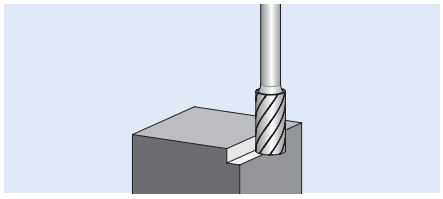
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

PFERDVALUE®**:**
With HICOAT® coating:

Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number				
				Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]								
3/32	1/2	SA-42	1-1/2	-	23112	-	-	1
1/8	1/2	SA-43	1-1/2	23121	23122	-	-	1
1/4	1/2	SA-51	1-11/16	23131	23132	-	-	1
Shank dia. 1/4" [d_2]								
1/8	1/2	SA-11	1-15/16	24001	24002	-	-	1
3/16	5/8	SA-14	1-15/16	-	24022	-	-	1
1/4	5/8	SA-1	1-15/16	24031	24032	27040	24033	1
5/16	3/4	SA-2	2-1/2	24051	24052	-	24053	1
3/8	3/4	SA-3	2-1/2	24061	24062	27042	24063	1
7/16	1	SA-4	2-3/4	24091	24092	-	-	1
1/2	1	SA-5	2-3/4	24101	24102	27052	24103	1
5/8	1	SA-6	2-3/4	-	24112	-	-	1
3/4	1/2	SA-15	2-1/4	-	24132	-	-	1
	3/4	SA-16	2-1/2	-	24142	-	-	1
	1	SA-7	2-3/4	-	24122	-	-	1
1	1	SA-9	2-3/4	-	24162	-	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
1/4	5/8	SA-1L6	6-9/16	-	25802	-	-	1
3/8	3/4	SA-3L6	6-5/8	-	25812	-	-	1
1/2	1	SA-5L6	6-7/8	-	25822	-	-	1

Cylindrical bur with end cut – Shape B

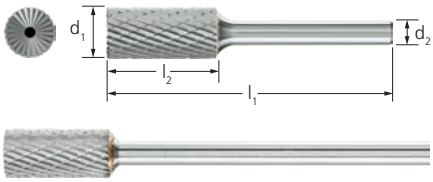


Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

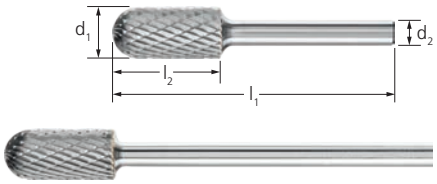
PFERDVALUE®**:**
With HICOAT® coating:

Waste Saving Time Saving

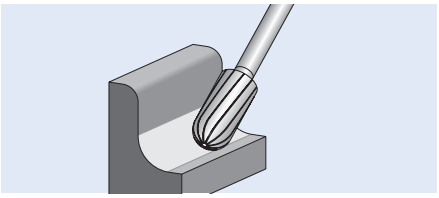


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number				
				Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]								
1/4	1/2	SB-51	1-11/16	23171	-	-	-	1
Shank dia. 1/4" [d_2]								
3/16	5/8	SB-14	1-15/16	-	24202	-	-	1
1/4	5/8	SB-1	1-15/16	24211	24212	-	24213	1
5/16	3/4	SB-2	2-1/2	-	24232	-	24233	1
3/8	3/4	SB-3	2-1/2	24241	24242	27082	-	1
7/16	1	SB-4	2-3/4	24271	24272	-	24273	1
1/2	1	SB-5	2-3/4	24281	24282	-	24283	1
5/8	1	SB-6	2-3/4	-	24292	-	-	1
3/4	1/2	SB-15	2-1/4	-	24312	-	-	1
	3/4	SB-16	2-1/2	-	24322	-	-	1
	1	SB-7	2-3/4	-	24302	-	-	1
1	1	SB-9	2-3/4	-	24342	-	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
3/8	3/4	SB-3L6	6-5/8	-	25842	-	-	1
1/2	1	SB-5L6	6-7/8	-	25852	-	-	1

Carbide burs, universal line
For fine and coarse stock removal



Cylindrical bur with radius end – Shape C



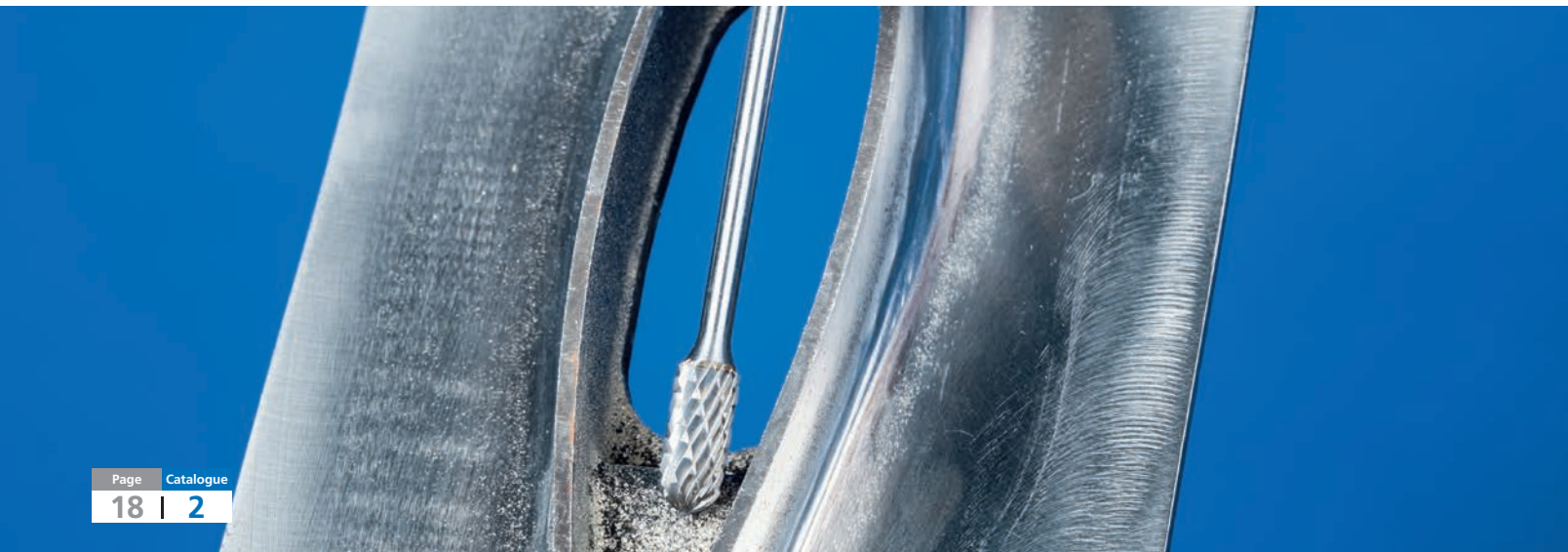
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

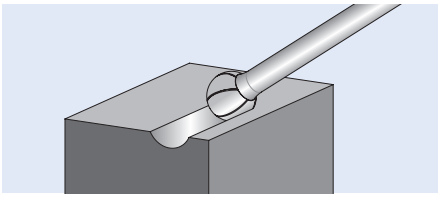
PFERDVALUE®:
With HICOAT® coating:

Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number				
				Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]								
3/32	1/2	SC-41	1-1/3	-	23182	-	-	1
1/8	1/2	SC-42	1-1/2	23191	23192	-	-	1
1/4	1/2	SC-51	1-11/16	23201	23202	-	-	1
Shank dia. 1/4" [d_2]								
1/8	1/2	SC-11	1-15/16	-	24352	-	-	1
	5/8	SC-12	1-15/16	-	24362	-	-	1
3/16	5/8	SC-14	1-15/16	-	24382	-	-	1
1/4	5/8	SC-1	1-15/16	24391	24392	-	24393	1
5/16	3/4	SC-2	2-1/2	-	24412	-	-	1
3/8	3/4	SC-3	2-1/2	24421	24422	27167	24423	1
7/16	1	SC-4	2-3/4	-	24452	-	-	1
1/2	1	SC-5	2-3/4	24461	24462	27177	24463	1
5/8	1	SC-6	2-3/4	-	24472	-	24473	1
3/4	1	SC-7	2-3/4	-	24482	-	24483	1
1	1	SC-9	2-3/4	-	24512	-	24513	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
1/4	5/8	SC-1L6	6-9/16	-	25862	-	-	1
3/8	3/4	SC-3L6	6-5/8	-	25872	-	-	1
1/2	1	SC-5L6	6-7/8	-	25882	-	-	1



Ball bur – Shape D

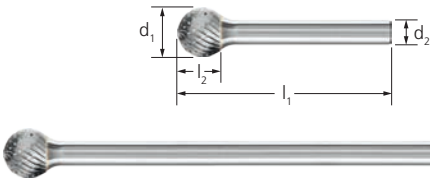


Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

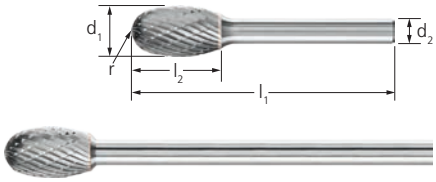
PFERDVALUE®:
With HICOAT® coating:

Waste Saving Time Saving

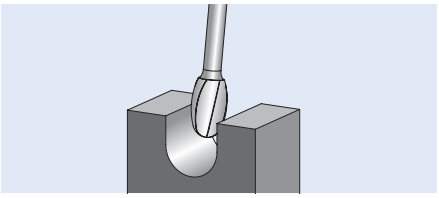


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number				
				Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]								
3/32	3/32	SD-41	1-1/2	23231	23232	-	-	1
1/8	3/32	SD-42	1-1/2	23241	23242	-	-	1
3/16	1/8	SD-53	1-38	23261	23262	-	-	1
1/4	3/16	SD-51	1-3/8	23251	23252	-	-	1
Shank dia. 1/4" [d_2]								
1/8	3/32	SD-11	1-15/16	-	24522	-	-	1
3/16	1/8	SD-14	1-15/16	24531	24532	-	-	1
1/4	3/16	SD-1	1-15/16	24541	24542	-	24543	1
5/16	1/4	SD-2	2-1/16	24551	24552	-	-	1
3/8	5/16	SD-3	2-1/16	24561	24562	27217	24563	1
7/16	3/8	SD-4	2-1/8	-	24572	-	-	1
1/2	7/16	SD-5	2-3/16	24581	24582	27227	-	1
5/8	9/16	SD-6	2-5/16	-	24592	-	24593	1
3/4	11/16	SD-7	2-13/16	-	24602	-	-	1
1	15/16	SD-9	2-1/16	24611	24612	-	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
1/4	3/16	SD-1L6	6-1/8	-	25922	-	-	1
3/8	5/16	SD-3L6	6-1/4	-	25932	-	-	1
1/2	7/16	SD-5L6	6-5/16	-	25942	-	-	1

Carbide burs, universal line
For fine and coarse stock removal



Oval bur – Shape E

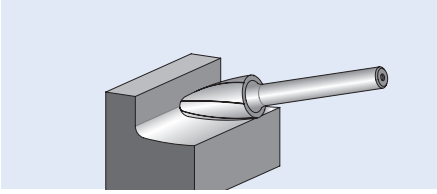


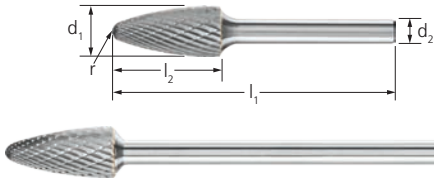
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number			
					Single	Double	Diamond	
Shank dia. 1/8" [d_2]								
1/8	7/32	SE-41	1-1/2	.047	-	23272	-	1
1/4	3/8	SE-51	1-9/16	.110	23281	23282	-	1
Shank dia. 1/4" [d_2]								
1/4	3/8	SE-1	1-15/16	.110	24631	24632	24633	1
3/8	5/8	SE-3	2-3/8	.157	24641	24642	24643	1
1/2	7/8	SE-5	2-5/8	.196	24651	24652	24653	1
5/8	1	SE-6	2-3/4	.256	-	24662	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
1/4	3/8	SE-1L6	6-3/8	.110	-	25982	-	1
3/8	5/8	SE-3L6	6-1/2	.157	-	25992	-	1
1/2	7/8	SE-5L6	6-3/4	.196	-	26002	-	1

Tree bur with radius end – Shape F





Safety notes:

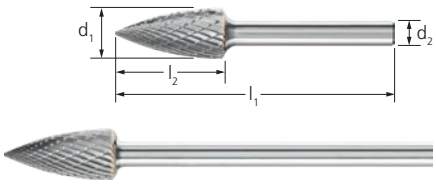
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

PFERDVALUE®**:**
With HICOAT® coating:

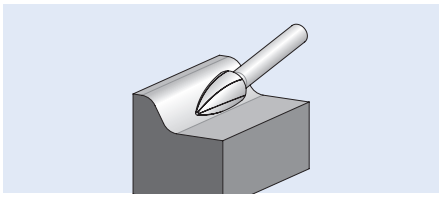
Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number				
					Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]									
1/8	1/4	SF-41	1-1/2	.029	23301	23302	-	-	1
	1/2	SF-42	1-1/2	.029	23311	23312	-	-	1
1/4	1/2	SF-51	1-11/16	.059	23321	23322	-	-	1
Shank dia. 1/4" [d_2]									
1/4	5/8	SF-1	1-15/16	.059	24691	24692	-	24693	1
3/8	3/4	SF-3	2-1/2	.098	24701	24702	27282	24703	1
7/16	1	SF-4	2-3/4	.012	-	24712	-	-	1
1/2	3/4	SF-13	2-1/2	.098	-	24732	-	24733	1
1/2	1	SF-5	2-3/4	.018	24721	24722	27292	24723	1
5/8	1	SF-6	2-3/4	.141	-	24742	-	-	1
3/4	1	SF-7	2-3/4	.196	-	24752	-	24753	1
	1-1/4	SF-14	3	.196	-	24762	-	24763	1
	1-1/2	SF-15	3-1/4	.196	-	24772	-	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)									
1/4	5/8	SF-1L6	6-9/16	.059	-	26042	-	-	1
3/8	3/4	SF-3L6	6-3/4	.098	-	26052	-	-	1
1/2	1	SF-5L6	6-7/8	.098	-	26062	-	-	1

Carbide burs, universal line
For fine and coarse stock removal



Tree bur with pointed end – Shape G

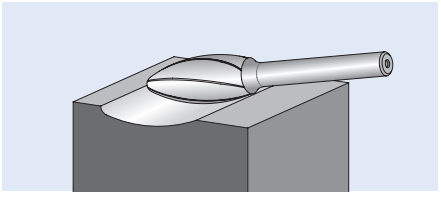


Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

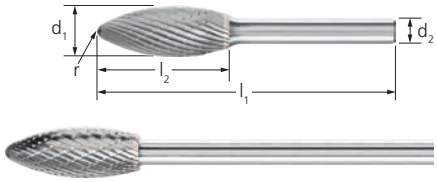
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number			
				Single	Double	Diamond	
Shank dia. 1/8" [d_2]							
1/8	1/4	SG-41	1-1/2	23341	23342	-	1
	3/8	SG-43	1-1/2	23361	23362	-	1
3/16	1/2	SG-53	1-11/16	-	23392	-	1
1/4	1/2	SG-51	1-11/16	23381	23382	-	1
Shank dia. 1/4" [d_2]							
1/4	5/8	SG-1	1-15/16	24781	24782	24783	1
5/16	3/4	SG-2	2-1/2	-	24792	24793	1
3/8	3/4	SG-3	2-1/2	24801	24802	24803	1
1/2	3/4	SG-13	2-1/2	-	24822	24823	1
	1	SG-5	2-3/4	24811	24812	24813	1
5/8	1	SG-6	2-3/4	-	24832	24833	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)							
1/4	5/8	SG-1L6	6-9/16	-	26102	-	1
3/8	3/4	SG-3L6	6-3/4	-	26112	-	1
1/2	1	SG-5L6	6-7/8	-	26122	-	1

Flame bur – Shape H



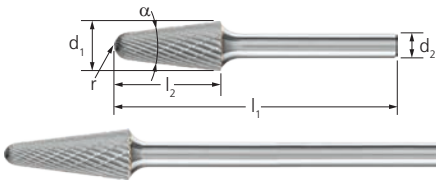
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

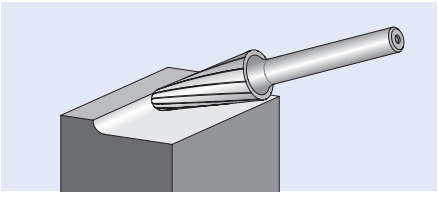


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number			
					Single	Double	Diamond	
Shank dia. 1/8" [d_2]								
1/8	1/4	SH-41	1-1/2	.031	23401	23402	-	1
Shank dia. 1/4" [d_2]								
1/4	5/8	SH-1	1-15/16	.039	-	24862	24863	1
5/16	3/4	SH-2	2-1/2	.059	24871	24872	-	1
1/2	1-1/4	SH-5	3	.082	24881	24882	24883	1
5/8	1-7/16	SH-6	3-3/16	.102	-	24892	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)								
5/16	3/4	SH-2L6	6-5/8	.059	-	26162	-	1
1/2	1-1/4	SH-5L6	7-1/4	.082	-	26172	-	1

Carbide burs, universal line
For fine and coarse stock removal



14° Taper bur with radius end – Shape L



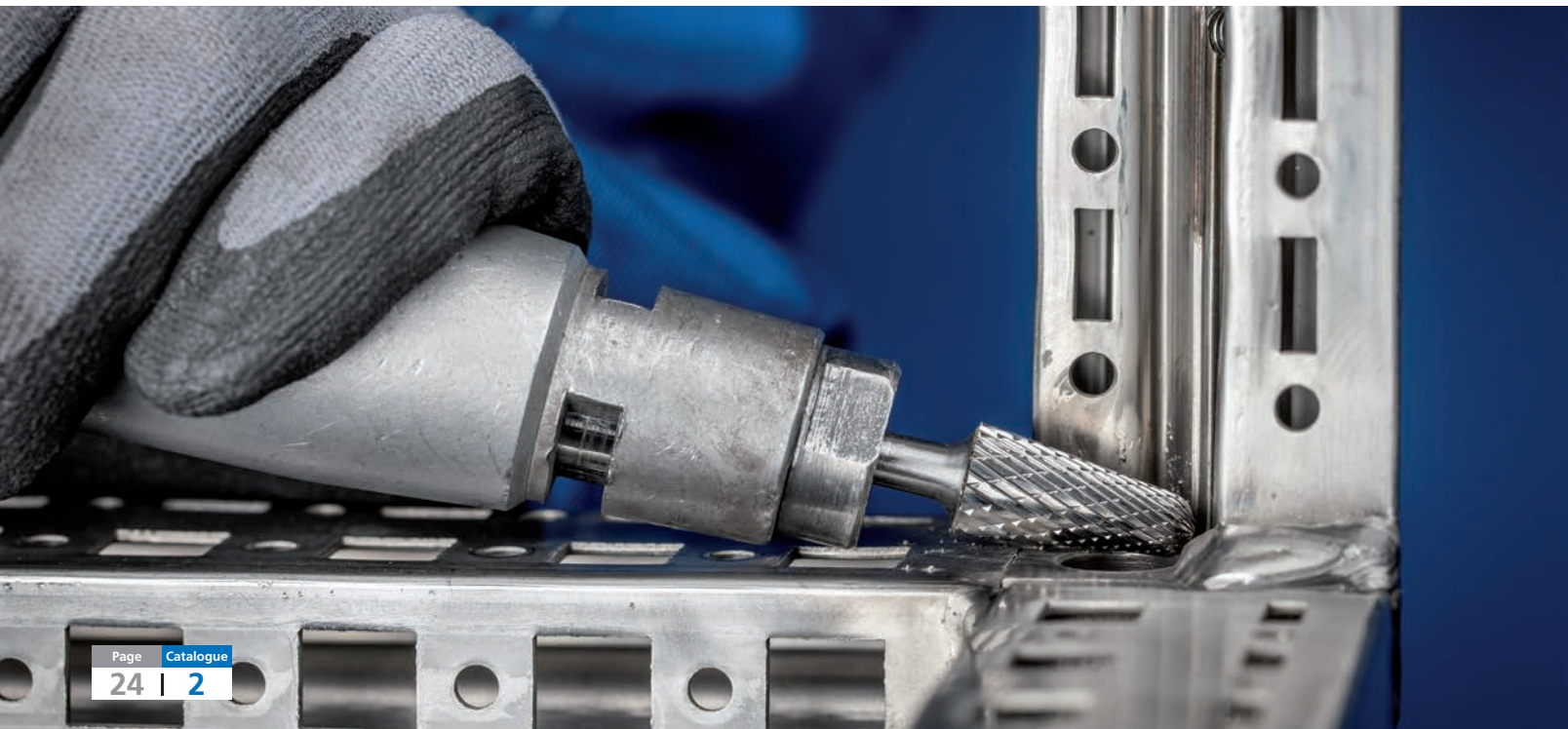
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

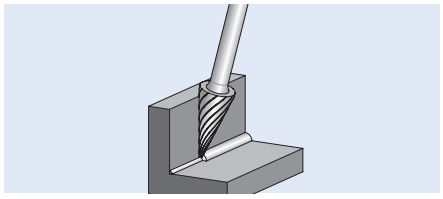
PFERDVALUE®**:**
With HICOAT® coating:

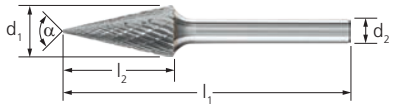
Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	r [Inches]	Cut type and EDP number				
						Single	Double	Double HC-FEP	Diamond	
Shank dia. 1/8" [d_2]										
1/8	1/2	SL-42	14°	1-1/2	.035	23451	23452	-	-	1
Shank dia. 1/4" [d_2]										
1/4	5/8	SL-1	14°	1-15/16	.055	25131	25132	-	25133	1
5/16	1	SL-2	16°	2-13/16	.049	-	25142	-	25143	1
3/8	1-1/16	SL-3	14°	3	.114	-	25152	27457	25153	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	25161	25162	27462	25163	1
5/8	1-5/16	SL-6	14°	3-1/4	.189	-	25182	-	25183	1
3/4	1-1/2	SL-7	14°	3-7/16	.212	-	25192	-	-	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)										
1/4	5/8	SL-1L6	14°	6-9/16	.055	-	26212	-	-	1
3/8	1-1/16	SL-3L6	14°	7-1/8	.114	-	26222	-	-	1
1/2	1-1/8	SL-4L6	14°	7-3/16	.130	-	26232	-	-	1



Cone bur with pointed end – Shape M





d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	Cut type and EDP number			
					Single	Double	Diamond	
Shank dia. 1/8" [d_2]								
1/8	3/8	SM-41	14°	1-1/2	-	23472	-	1
	1/2	SM-42	12°	1-1/2	23481	23482	-	1
	5/8	SM-43	9°	1-1/2	-	23492	-	1
1/4	1/2	SM-51	22°	1-13/16	23501	23502	-	1
Shank dia. 1/4" [d_2]								
1/4	1/2	SM-1	22°	1-15/16	25201	25202	-	1
	3/4	SM-2	14°	1-15/16	-	25212	25213	1
	1	SM-3	10°	1-15/16	-	25222	25223	1
3/8	3/4	SM-4	28°	2-1/2	25231	25232	-	1
1/2	1	SM-5	28°	2-3/4	-	25242	-	1
5/8	1-1/8	SM-6	31°	2-15/16	-	25252	25253	1

Carbide burs, universal line
For fine and coarse stock removal

12 piece carbide bur sets – Single cut, double cut

Contains twelve carbide burs in the shapes and dimensions most commonly used in the workshop.

The sturdy plastic box protects the burs from dirt and damage.

EDP 26525
12 piece single cut carbide bur set
1/8" shank (plastic case)
Contains 12 pcs. burs with 1/8" shank diameter and single cut.

EDP 26526
12 piece double cut carbide bur set
1/8" shank (plastic case)
Contains 12 pcs. burs with 1/8" shank diameter and double cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number		Cut type and set EDP number		
				Single 	Individual bur EDP's in set	Double 	Individual bur EDP's in set	
Cylindrical (plain end)	1/8	1/2	SA-43	26525	23121	26526	23122	1
Cylindrical (radius end)	3/32	1/2	SC-51		23201		23202	1
	1/8	1/2	SC-42		23191		23192	1
Ball	1/8	3/32	SD-42		23241		23242	1
	3/16	1/8	SD-53		23261		23262	1
Oval	1/4	3/8	SE-51		23281		23282	1
Tree (radius end)	1/8	1/4	SF-41		23301		23302	1
	1/8	1/2	SF-42		23311		23312	1
Tree (pointed end)	1/8	3/8	SG-43		23361		23362	1
Flame shape	1/8	1/4	SH-41		23401		23402	1
14° Taper	1/8	1/2	SL-42		23451		23452	1
Cone	1/8	1/2	SM-42		23481		23482	1

8 piece carbide bur sets – Single cut, double cut

Contains eight carbide burs in the shapes and dimensions most commonly used in the workshop.

The sturdy plastic box protects the burs from dirt and damage.
Two additional unused slots are available for other burs.

EDP 26546
8 piece single cut carbide bur set
1/4" shank (plastic case)
Contains 8 pcs. burs with 1/4" shank diameter and single cut.

EDP 26547
8 piece double cut carbide bur set
1/4" shank (plastic case)
Contains 8 pcs. burs with 1/4" shank diameter and double cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number: Single	Individual bur EDP's in set	Cut type and set EDP number: Double	Individual bur EDP's in set	
Cylindrical (plain end)	3/8	3/4	SA-3	26546	24061	26547	24062	1
	1/2	1	SA-5		24101		24102	1
Cylindrical (radius end)	3/8	3/4	SC-3		24421		24422	1
	1/2	1	SC-5		24461		24462	1
Ball	3/8	5/16	SD-3		24561		24562	1
Tree (radius end)	3/8	3/4	SF-3		24701		24702	1
	1/2	1	SF-5		24721		24722	1
Tree (pointed end)	3/8	3/4	SG-3		24801		24802	1

5 piece carbide bur set – diamond cut

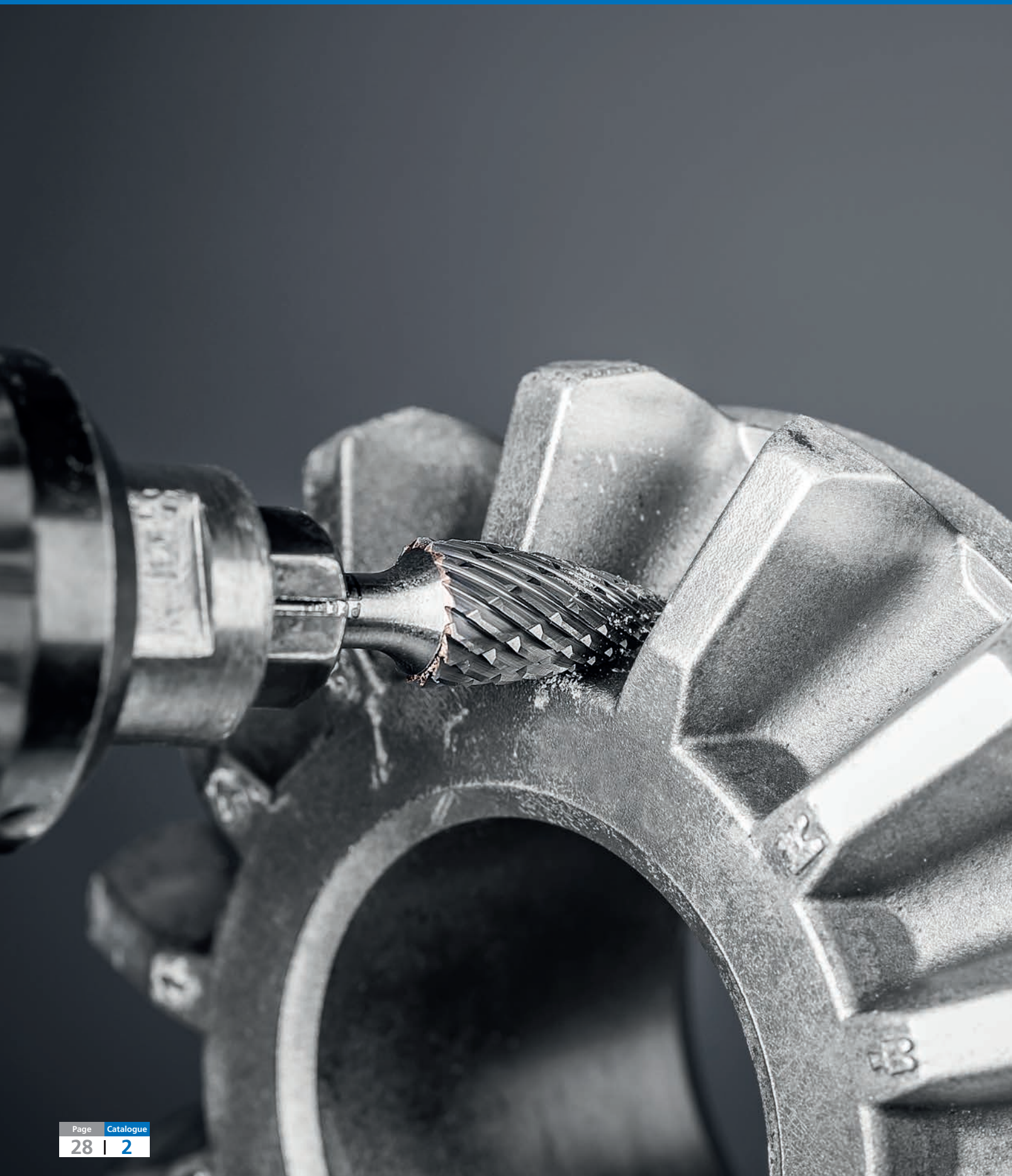
Contains five carbide burs in the shapes and dimensions most commonly used in the workshop.

The sturdy plastic box protects the burs from dirt and damage.
Five additional unused slots are available for other burs.

EDP 26552
5 piece carbide bur set 1/4" shank
diamond cut (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and diamond cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number: Diamond	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26552	24103	1
Cylindrical (radius end)	1/2	1	SC-5		24463	1
Oval	1/2	7/8	SE-5		24653	1
Tree (radius end)	1/2	1	SF-5		24723	1
14° Taper	1/2	1-1/8	SL-4		25163	1

Carbide burs, performance line



Carbide burs, performance line
OMNI cut for versatile use

With the innovative OMNI cut, PFERD has developed unique burs for versatile use on key materials such as steel and cast steel, stainless steel (INOX), non-ferrous metals and cast iron. The OMNI cut offers all the benefits of the tried-and-tested double cut, but its stock removal rate is up to 30% higher for steel. It enables comfortable working with reduced vibration and less noise. They also offer significant time savings and a high economic value.

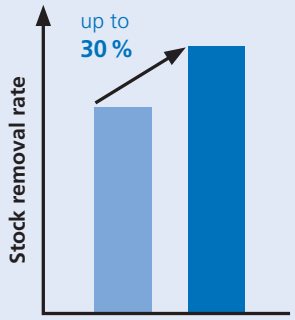
Advantages:

- Significantly better stock removal rate than burs with a conventional double cut.
- Saves money and time with its very high stock removal rate on key materials.
- Comfortable working with reduced vibration and less noise.

Workpiece materials:

- Steel, cast steel
- Stainless steel (INOX)
- Non-ferrous metals
- Cast iron

Performance values for applications on steel



- Conventional double cut burs
- Carbide burs, OMNI cut

Applications:

- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Recommendations for use:

- It is recommended to use the burs on powerful power tools with elastically mounted spindles to avoid vibration.
- For the most cost-effective use of burs, work with higher rotational/peripheral speeds. Power recommendation for power tools: from 300 watts.
- Please observe the rotational speed recommendations.

Compatible with:

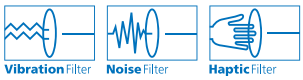
- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

Safety note:

- The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.

PFERDVALUE®:

PFERDERGONOMICS® recommends burs with OMNI cut as an innovative bur solution for comfortable working with significantly reduced vibration and less noise.



PFERDEFFICIENCY® recommends burs with OMNI cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

Carbide burs, performance line
OMNI cut for versatile use

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Establish the peripheral speed range.

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

❸ Select the required bur diameter.
❹ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

Safety note:

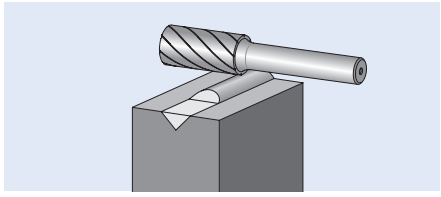
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

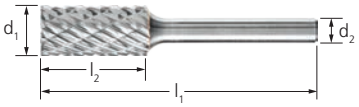
❶ Material group			Application	Cut	❷ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal	OMNI	1,500 - 2,500 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel	Coarse stock removal	OMNI	850 - 1,500 SFPM
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse stock removal	OMNI	1,500 - 2,000 SFPM
Non-ferrous metals	Soft non-ferrous metals	Brass, copper, zinc	Coarse stock removal	OMNI	1,500 - 2,500 SFPM
	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminum alloys (high Si content)	Coarse stock removal	OMNI	1,500 - 2,000 SFPM
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse stock removal	OMNI	1,500 - 3,000 SFPM

Example:
Carbide bur,
OMNI cut,
bur diameter 1/2".
Coarse stock removal on steels up to 370 HV.
Peripheral speed: 1,500–2,500 SFPM
Rotational speed range:
12,00–20,000 RPM

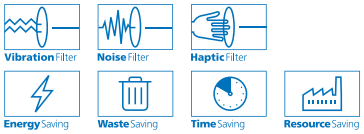
❸ Bur dia. [Inches]	❹ Peripheral speed [SFPM]				
	850	1,500	2,000	2,500	3,000
	Rotational speeds [RPM]				
1/4	13,000	24,000	32,000	40,000	48,000
3/8	8,000	14,000	19,000	24,000	29,000
7/16	8,000	13,000	17,500	22,000	29,000
1/2	7,000	12,000	16,000	20,000	26,500
5/8	5,000	9,000	12,000	15,000	18,000

Cylindrical bur with plain end (uncut) – Shape A



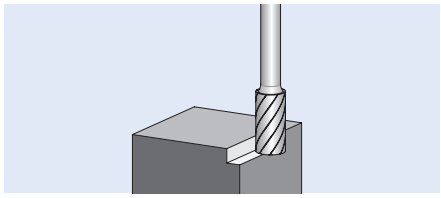


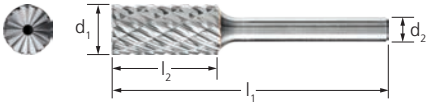
PFERDVALUE®:



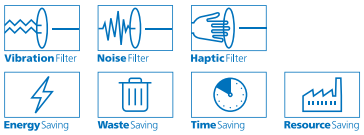
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]					
1/4	5/8	SA-1	1-15/16	28026	1
3/8	3/4	SA-3	2-1/2	28018	1
1/2	1	SA-5	2-3/4	28005	1

Cylindrical bur with end cut – Shape B



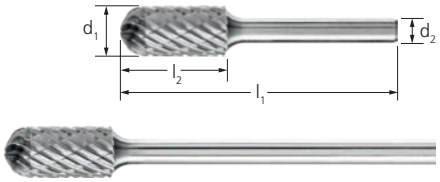


PFERDVALUE®:

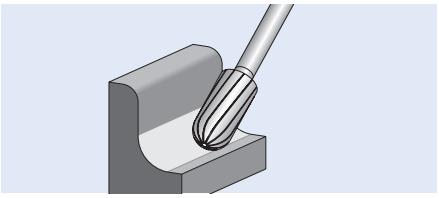


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]					
1/4	5/8	SB-1	1-15/16	28029	1
3/8	3/4	SB-3	2-1/2	28019	1
1/2	1	SB-5	2-3/4	28010	1
5/8	1	SB-6	2-3/4	28032	1

Carbide burs, performance line
OMNI cut for versatile use



Cylindrical bur with radius end – Shape C



Safety notes:

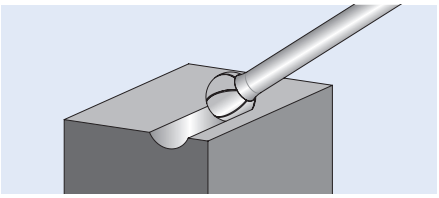
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

PFERDVALUE®:

Vibration Filter · Noise Filter · Haptic Filter · Energy Saving · Waste Saving · Time Saving · Resource Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]					
1/4	5/8	SC-1	1-15/16	28024	1
3/8	3/4	SC-3	2-1/2	28006	1
1/2	1	SC-5	2-3/4	28001	1
5/8	1	SC-6	2-3/4	28030	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SC-3L6	6-5/8	28020	1
1/2	1	SC-5L6	6-7/8	28017	1

Ball bur – Shape D



PFERDVALUE®:

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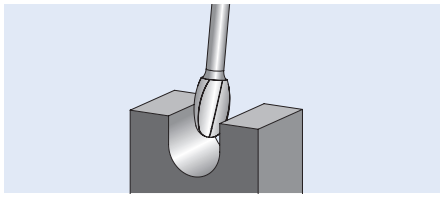
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]					
1/4	3/16	SD-1	1-15/16	28034	1
3/8	5/16	SD-3	2-1/16	28021	1
1/2	7/16	SD-5	2-3/16	28028	1

Oval bur – Shape E



Safety notes:
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

PFERDVALUE®:
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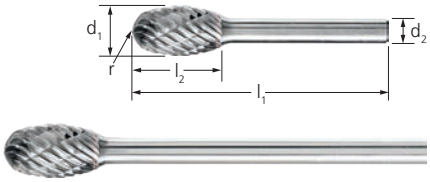
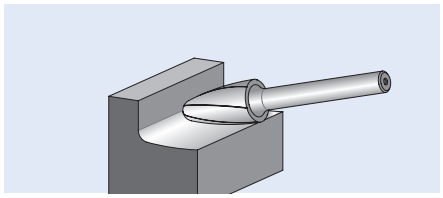


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]						
3/8	5/8	SE-3	2-3/8	.157	28035	1
1/2	7/8	SE-5	2-5/8	.196	28025	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)						
1/2	7/8	SE-5L6	6-3/4	.196	28022	1

Tree bur with radius end – Shape F



Safety notes:
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

PFERDVALUE®:
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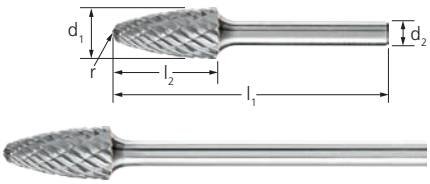
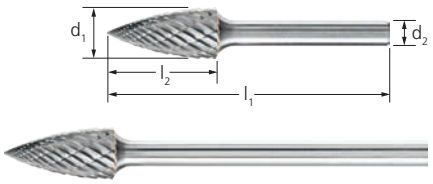
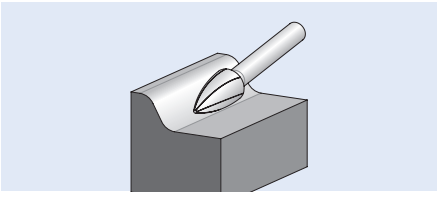


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]						
1/4	5/8	SF-1	1-15/16	.059	28012	1
3/8	3/4	SF-3	2-1/2	.098	28007	1
7/16	1	SF-4	2-3/4	.012	28002	1
1/2	1	SF-5	2-3/4	.098	28000	1
5/8	1	SF-6	2-3/4	.141	28033	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)						
3/8	3/4	SF-3L6	6-3/4	.098	28027	1
1/2	1	SF-5L6	6-7/8	.098	28008	1

Carbide burs, performance line
OMNI cut for versatile use



Tree bur with pointed end – Shape G



Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

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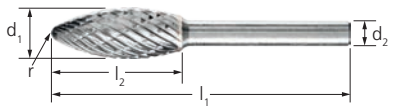
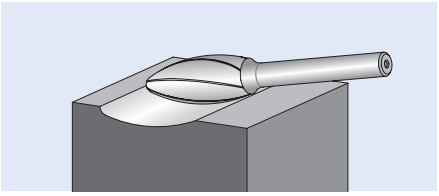
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]					
3/8	3/4	SG-3	2-1/2	28015	1
1/2	1	SG-5	2-3/4	28009	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SG-3L6	6-3/4	28031	1
1/2	1	SG-5L6	6-7/8	28023	1



Flame bur – Shape H



PFERDVALUE®:

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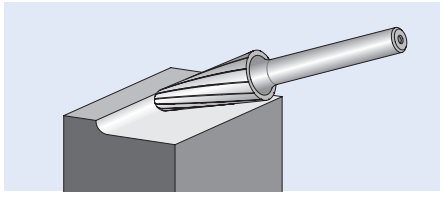
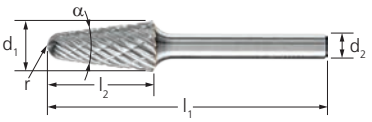
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d_2]						
1/2	1-1/4	SH-5	3	.082	28004	1

14° Taper bur with radius end – Shape L





PFERDVALUE®:

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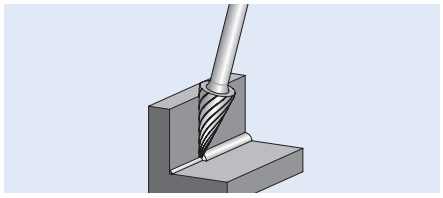
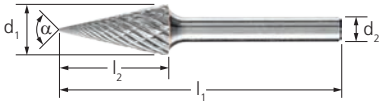
d1 [Inches]	l2 [Inches]	SCTI no.	α	l1 [Inches]	r [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d2]							
3/8	1-1/16	SL-3	16°	3	.114	28003	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	28014	1
5/8	1-5/16	SL-6	14°	3-1/4	.189	28013	1

Cone bur with pointed end – Shape M





PFERDVALUE®:

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d1 [Inches]	l2 [Inches]	SCTI no.	α	l1 [Inches]	Cut type and EDP number OMNI	
Shank dia. 1/4" [d2]						
1/4	1	SM-3	10°	1-15/16	28036	1
1/2	1	SM-5	28°	2-3/4	28016	1

Carbide burs, performance line
OMNI cut for versatile use

8 piece carbide bur sets – OMNI cut

Contains eight carbide burs in the shapes and dimensions most commonly used in the workshop.

The sturdy plastic box protects the burs from dirt and damage.
Two additional unused slots are available for other burs.

EDP 28011
8 piece OMNI cut carbide bur set
1/4" shank (plastic case)
Contains 8 pcs. burs with 1/4" shank diameter and OMNI cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number		
				OMNI	Individual bur EDP's in set	
Cylindrical (plain end)	3/8	3/4	SA-3	28011	28018	1
	1/2	1	SA-5		28005	1
Cylindrical (radius end)	3/8	3/4	SC-3		28006	1
	1/2	1	SC-5		28001	1
Ball	3/8	5/16	SD-3		28021	1
Tree (radius end)	3/8	3/4	SF-3		28007	1
	1/2	1	SF-5		28000	1
Tree (pointed end)	3/8	3/4	SG-3		28015	1

5 piece carbide bur sets – OMNI cut

Contains five carbide burs in the shapes and dimensions most commonly used in the workshop.

The sturdy plastic box protects the burs from dirt and damage.
Five additional unused slots are available for other burs.

EDP 28037
5 piece OMNI cut carbide bur set
1/4" shank (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and OMNI cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number		
				OMNI	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	28037	28005	1
Cylindrical (radius end)	1/2	1	SC-5		28001	1
Oval	1/2	7/8	SE-5		28025	1
Tree (radius end)	1/2	1	SF-5		28000	1
14° Taper	1/2	1-1/8	SL-4		28014	1

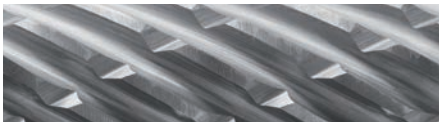
PFERD

Carbide burs, high performance line

2

Carbide burs, high performance line
STEEL cut for steel and cast steel

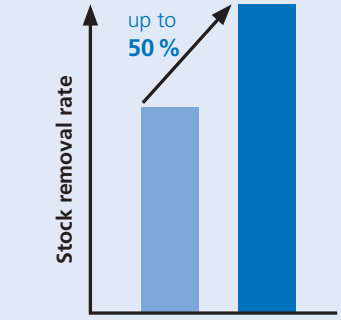
With the innovative STEEL cut, PFERD has developed unique burs for working with steel and cast steel. They are characterized by significantly increased aggressiveness and good guidance, ensuring safe and precise work.
The extremely high stock removal rate makes burs with the STEEL cut impressive, with significant time savings and a high economic value.



Advantages:

- Up to 50% higher stock removal rate when used on steel and cast steel in comparison to conventional double cut burs.
- Significantly increased aggressiveness, large chips and very good chip removal resulting from the innovative tooth geometry.
- Workpiece is protected through much lower thermal load.

Performance values for applications on steel and cast steel



- Conventional burs with cross cut
- Carbide burs, STEEL cut

Applications:

- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Workpiece materials:

- Steel
- Cast steel

Recommendations for use:

- It is recommended to use the burs on powerful power tools with elastically mounted spindles to avoid vibration.
- For the most cost-effective use of burs, work with higher rotational/peripheral speeds. Power recommendation for power tools: from 300 watts.
- Please observe the rotational speed recommendations.

Compatible with:

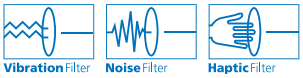
- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

Safety note:

- The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.

PFERDVALUE®:

PFERDERGONOMICS® recommends burs with STEEL cut as an innovative product solution for comfortable working with significantly reduced vibration and less noise.



PFERDEFFICIENCY® recommends burs with STEEL cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

More PFERD products and information on working with steel can be found in our PRAXIS brochure "PFERD products for use on steel".

Recommended rotational speed range [RPM]

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

❶ Refer to the table for the peripheral speed.
❷ Select the required bur diameter.
❸ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

Safety note:

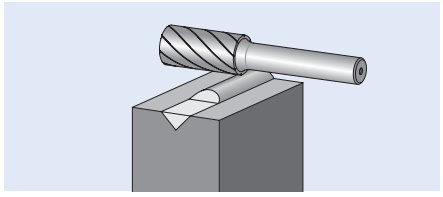
Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

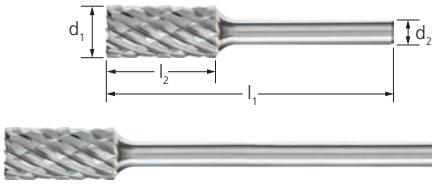
Material group			Application	Cut	❶ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal	STEEL	1,500 - 2,500 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel			

Example:
Carbide bur,
STEEL cut,
bur diameter of 1/2" .
Peripheral speed: 1,500–2,500 SFPM
Rotational speed range:
12,000–20,000 RPM

❷ Bur dia. [Inches]	❸ Peripheral speed [SFPM]	
	1,500	2,500
	Rotational speed [RPM]	
1/4	24,000	40,000
3/8	14,000	24,000
1/2	12,000	20,000
5/8	9,000	15,000

Cylindrical bur with plain end (uncut) – Shape A





Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

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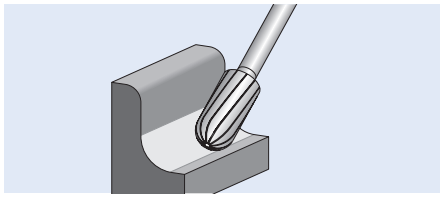
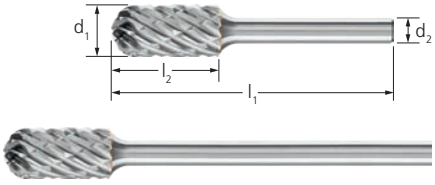
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]					
1/4	5/8	SA-1	1-15/16	24038	1
3/8	3/4	SA-3	2-1/2	24068	1
1/2	1	SA-5	2-3/4	24108	1
5/8	1	SA-6	2-3/4	24118	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SA-3L6	6-5/8	25640	1
1/2	1	SA-5L6	6-7/8	25642	1

Cylindrical bur with radius end – Shape C





Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

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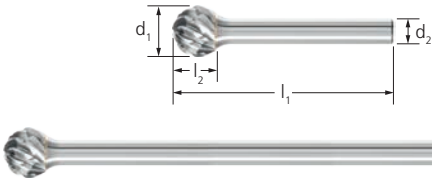
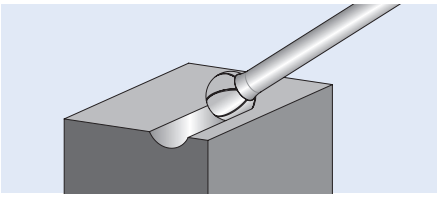
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]					
1/4	5/8	SC-1	1-15/16	24398	1
3/8	3/4	SC-3	2-1/2	24428	1
1/2	1	SC-5	2-3/4	24468	1
5/8	1	SC-6	2-3/4	24478	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SC-3L6	6-5/8	25641	1
1/2	1	SC-5L6	6-7/8	25643	1

Carbide burs, high performance line
STEEL cut for steel and cast steel



Ball bur – Shape D



Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

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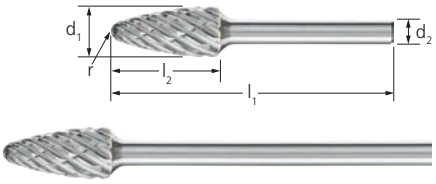
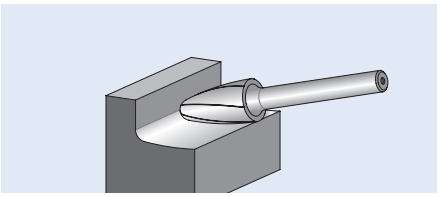
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]					
1/4	3/16	SD-1	1-15/16	24546	1
3/8	5/16	SD-3	2-1/16	24568	1
1/2	7/16	SD-5	2-3/16	24588	1
5/8	9/16	SD-6	2-5/16	24599	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	5/16	SD-3L6	6-1/4	25650	1
1/2	7/16	SD-5L6	6-5/16	25651	1



Tree bur with radius end – Shape F



Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

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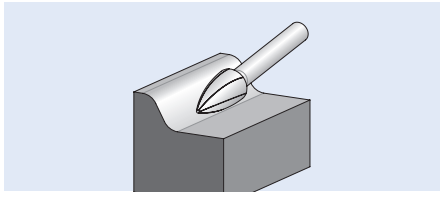
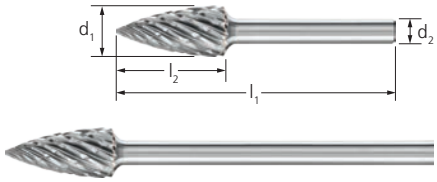
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]						
1/4	5/8	SF-1	1-15/16	.059	24698	1
3/8	3/4	SF-3	2-1/2	.098	24708	1
1/2	1	SF-5	2-3/4	.098	24728	1
5/8	1	SF-6	2-3/4	.141	24748	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)						
3/8	3/4	SF-3L6	6-3/4	.098	25645	1
1/2	1	SF-5L6	6-7/8	.098	25647	1

Tree bur with pointed end – Shape G





Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

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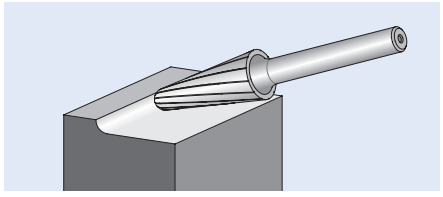
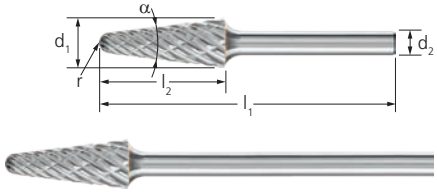
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]					
1/4	5/8	SG-1	1-15/16	24788	1
3/8	3/4	SG-3	2-1/2	24808	1
1/2	1	SG-5	2-3/4	24818	1
5/8	1	SG-6	2-3/4	24838	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SG-3L6	6-3/4	25644	1
1/2	1	SG-5L6	6-7/8	25646	1

14° Taper bur with radius end – Shape L





Safety notes:

The rotational speeds for extended shank burs relate to applications where the bur is in contact with the workpiece. More safety notes can be found on page 11.

PFERDVALUE®:

Vibration Filter · Noise Filter · Haptic Filter · Energy Saving · Waste Saving · Time Saving · Resource Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	r [Inches]	Cut type and EDP number STEEL	
Shank dia. 1/4" [d_2]							
1/4	5/8	SL-1	14°	1-15/16	.055	25138	1
3/8	1-1/16	SL-3	14°	3	.114	25158	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	25168	1
5/8	1-5/16	SL-6	14°	3-1/4	.189	25188	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)							
3/8	1-1/16	SL-3L6	14°	7-1/8	.114	25648	1
1/2	1-1/8	SL-4L6	14°	7-3/16	.130	25649	1

Carbide burs, high performance line
STEEL cut for steel and cast steel

5 piece carbide bur sets – STEEL cut

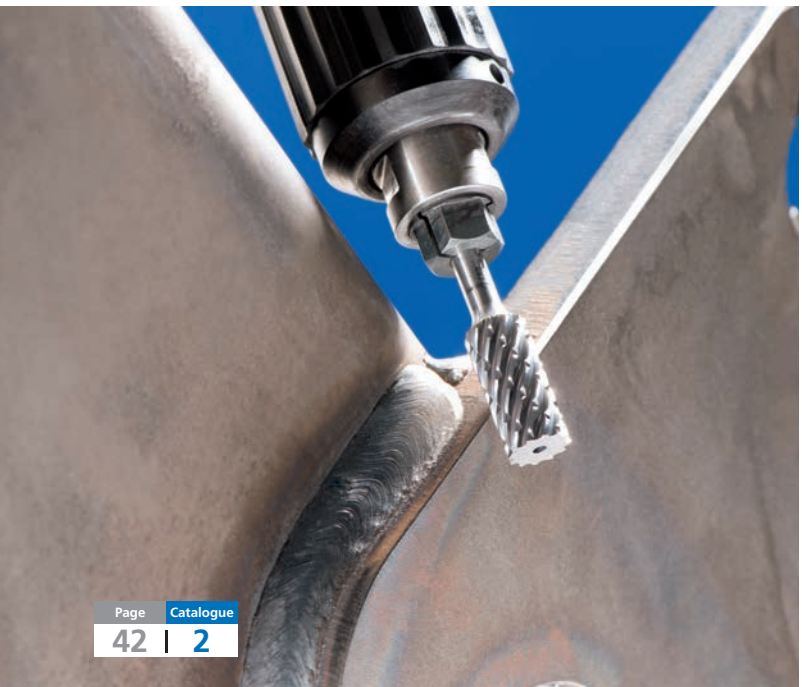
Contains five carbide burs for processing steel and cast steel in the most common shapes and dimensions.

The sturdy plastic box protects the burs from dirt and damage.
Five additional slots are available for other burs.

EDP 26553
5 piece STEEL cut carbide bur set
1/4" shank (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and STEEL cut.

PFERDVALUE®:
Vibration Filter · Noise Filter · Haptic Filter · Energy Saving · Waste Saving · Time Saving · Resource Saving

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number		
				STEEL	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26553	24108	1
Cylindrical (radius end)	1/2	1	SC-5		24468	1
Tree (radius end)	1/2	1	SF-5		24728	1
Tree (pointed end)	1/2	1	SG-5		24818	1
14° Taper (radius end)	1/2	1-1/8	SL-4		25168	1



With the INOX cut, PFERD has developed innovative burs for work on stainless steel (INOX). The INOX cut is characterized by an extremely high stock removal rate on all austenitic as well as rust- and acid-resistant steels. It creates significantly less vibration than a comparable cross cut.

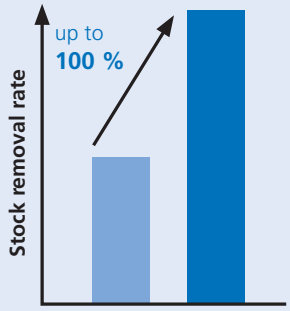
Advantages:

- Outstanding stock removal rate and service life due to the innovative tooth geometry.
- Achieves high surface qualities through optimum chip formation.
- Prevents heat discolouration in the material due to the reduced heat generation.

Workpiece materials:

- Stainless steel (INOX)
- Soft titanium alloys (tensile strength < 500 N/mm²)

Performance values for applications on stainless steel (INOX)



- Conventional double cut burs
- Carbide burs, INOX cut

Applications:

- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Recommendations for use:

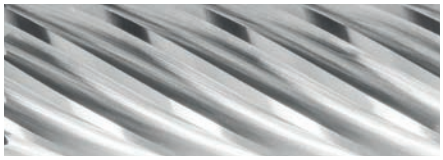
- If possible, use the tools on powerful drives with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burs, work with higher rotational/peripheral speeds.
  Power recommendation for power tools:
  - Shank diameter of 1/8": 75 to 300 watts
  - Shank diameter of 1/4": from 300 watts
- Please observe the rotational speed recommendations.

Compatible with:

- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

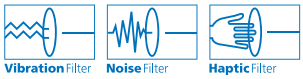
Safety note:

- The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.



PFERDVALUE®:

PFERDERGONOMICS® recommends burs with INOX cut as an innovative bur solution for comfortable working with significantly reduced vibration and less noise.



PFERDEFFICIENCY® recommends burs with INOX cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

More PFERD products and information on working with stainless steel (INOX) can be found in our PRAXIS brochure "PFERD tools for use on stainless steel (INOX)".

Recommended rotational speed range [RPM]

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

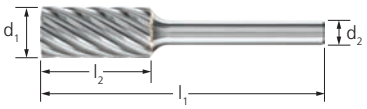
❶ Select the material group to be machined.
❷ Refer to the table for the peripheral speed.
❸ Select the required bur diameter.
❹ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

❶ Material group			Application	Cut	❷ Peripheral speed
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Coarse stock removal	INOX	1,500 - 2,000 SFPM
Non-ferrous metals	Non-ferrous metals	Titanium/titanium alloys	Coarse stock removal	INOX	850 - 1,500 SFPM

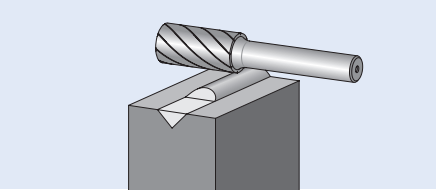
Example:
Carbide bur,
INOX cut,
bur diameter of 1/2".
Coarse stock removal on stainless steel (INOX).
Peripheral speed: 1,500–2,000 SFPM
Rotational speed range:
12,000–16,000 RPM

❸ Bur dia. [Inches]	❹ Peripheral speeds [SFPM]		
	850	1,500	2,000
	Rotational speeds [RPM]		
1/8	27,000	48,000	64,000
1/4	13,000	24,000	32,000
3/8	8,000	14,000	19,000
1/2	7,000	12,000	16,000

Carbide burs, high performance line
INOX cut for stainless steel (INOX)



Cylindrical bur with plain end (uncut) – Shape A



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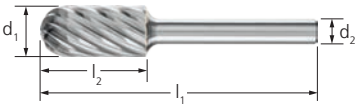
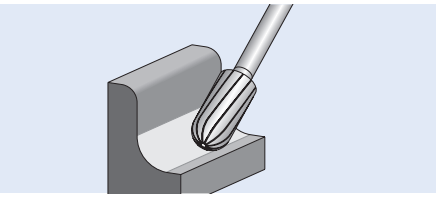
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]					
1/8	1/2	SA-43	1-1/2	23127	1
1/4	1/2	SA-51	1-11/16	23137	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SA-1	1-15/16	24037	1
3/8	3/4	SA-3	2-1/2	24067	1
1/2	1	SA-5	2-3/4	24107	1



Cylindrical bur with radius end – Shape C



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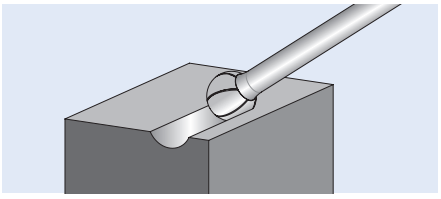
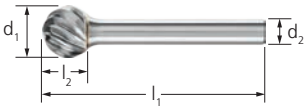
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]					
1/8	1/2	SC-42	1-1/2	23197	1
1/4	1/2	SC-51	1-11/16	23207	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SC-1	1-15/16	24397	1
3/8	3/4	SC-3	2-1/2	24427	1
1/2	1	SC-5	2-3/4	24467	1

Ball bur – Shape D





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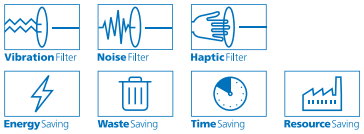
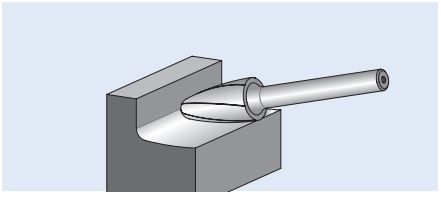
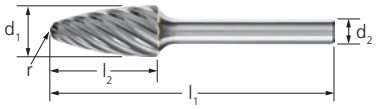


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]					
1/8	3/32	SD-42	1-1/2	23247	1
1/4	3/16	SD-51	1-3/8	23257	1
Shank dia. 1/4" [d_2]					
1/4	3/16	SD-1	1-15/16	24527	1
3/8	5/16	SD-3	2-1/16	24567	1
1/2	7/16	SD-5	2-3/16	24587	1

Tree bur with radius end – Shape F





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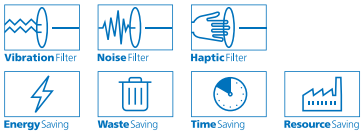
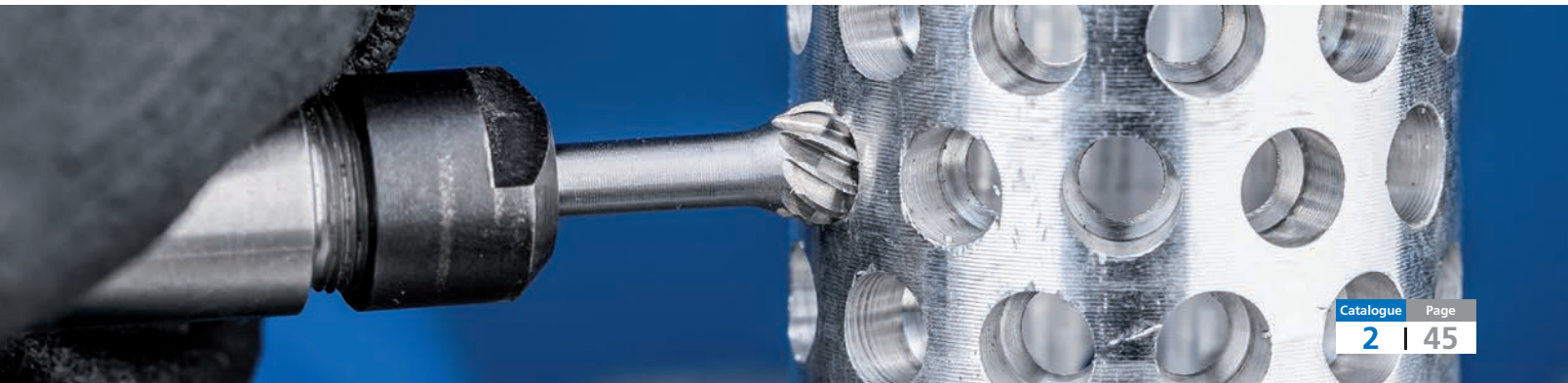
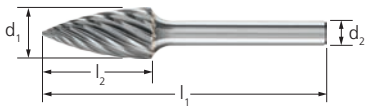


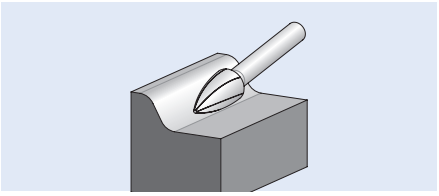
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]						
1/8	1/2	SF-42	1-1/2	.029	23317	1
1/4	1/2	SF-51	1-11/16	.059	23327	1
Shank dia. 1/4" [d_2]						
1/4	5/8	SF-1	1-15/16	.059	24697	1
3/8	3/4	SF-3	2-1/2	.098	24707	1
1/2	1	SF-5	2-3/4	.098	24727	1



Carbide burs, high performance line
INOX cut for stainless steel (INOX)



Tree bur with pointed end – Shape G



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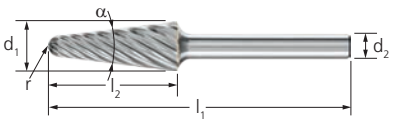
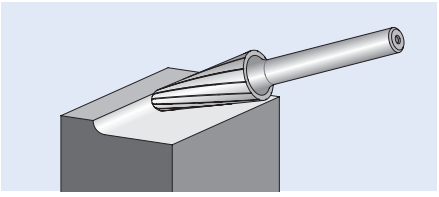
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]					
1/8	1/4	SG-41	1-1/2	23357	1
1/4	1/2	SG-51	1-11/16	23387	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SG-1	1-15/16	24787	1
3/8	3/4	SG-3	2-1/2	24807	1
1/2	1	SG-5	2-3/4	24817	1



14° Taper bur with radius end – Shape L



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d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	r [Inches]	Cut type and EDP number INOX	
Shank dia. 1/8" [d_2]							
1/8	1/2	SL-42	14°	1-1/2	.035	23457	1
Shank dia. 1/4" [d_2]							
1/4	5/8	SL-1	14°	1-15/16	.055	25137	1
3/8	1-1/16	SL-3	14°	3	.114	25157	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	25167	1

5 piece carbide bur sets – INOX cut

Contains five carbide burs for processing stainless steel (INOX) in the most common shapes and dimensions.

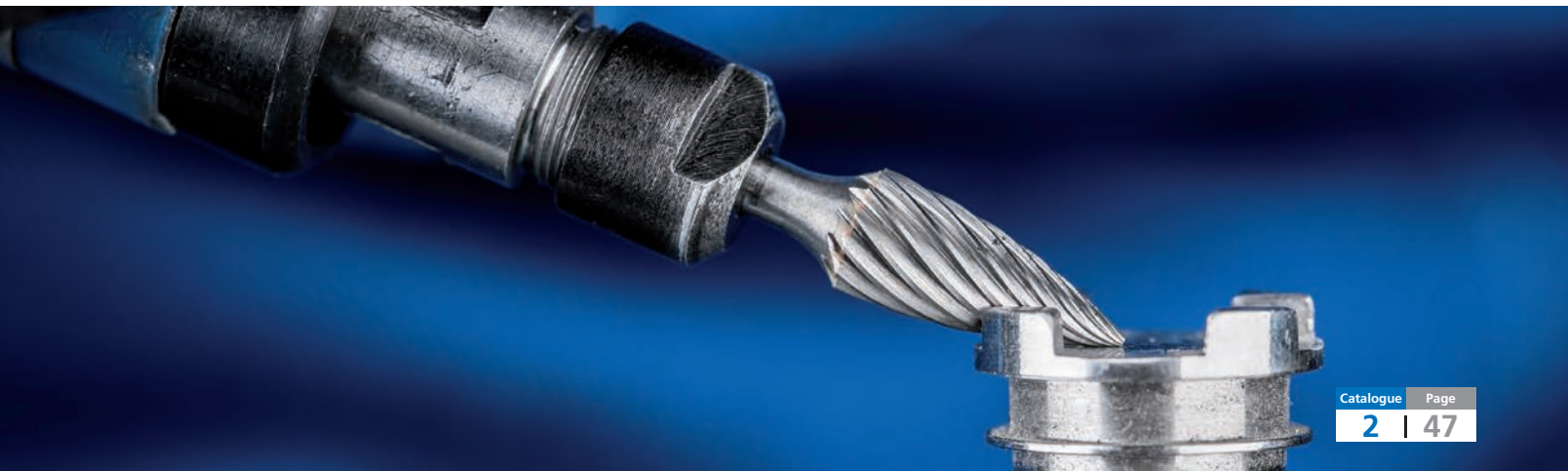
The sturdy plastic box protects the burs from dirt and damage.
Five additional slots are available for other burs.

EDP 26554
5 piece INOX cut carbide bur set 1/4" shank (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and INOX cut.

PFERDVALUE®:

Vibration Filter · Noise Filter · Haptic Filter · Energy Saving · Waste Saving · Time Saving · Resource Saving

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number		
				INOX	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26554	24107	1
Cylindrical (radius end)	1/2	1	SC-5		24467	1
Tree (radius end)	1/2	1	SF-5		24727	1
Tree (pointed end)	1/2	1	SG-5		24817	1
14° Taper (radius end)	1/2	1-1/8	SL-4		25167	1



Carbide burs, high performance line
ALU cut for aluminum/non-ferrous metals

When it comes to machining aluminum and non-ferrous metals, PFERD offers two high-performance cuts and a HICOAT® coating which have been designed specifically for demanding machining tasks on long-chipping and lubricating materials.

Applications:

- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Compatible with:

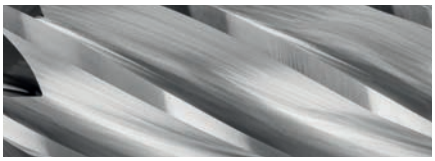
- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

Recommendations for use:

- If possible, use the tools on powerful drives with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burs, work with higher rotational/peripheral speeds.
  Power recommendation for power tools:
  - Shank diameter of 1/8": 75 to 300 watts
  - Shank diameter of 1/4": from 500 watts
- Please observe the rotational speed recommendations.

More PFERD tools and a wealth of useful information on working with aluminum can be found in our PRAXIS brochure "PFERD tools for use on aluminum".

ALU cut



The ALU cut is especially designed for stock removal on aluminum. This cut is characterized by its high stock removal rate.

Advantages:

- Extremely high stock removal rate.
- Large chips.
- Reduced material adhesion.
- Long service life and smooth running.
- Can be used with peripheral speeds of up to 3,600 SFPM.

ALU cut with HICOAT® coating HC-NFE

The use of burs with the PFERD HICOAT® coating HC-NFE prevents chips adhering during work on soft aluminum alloys. This increases the service life and improves the surface quality of the workpiece.

Advantages:

- Mainly used for long-chipping and lubricating non-ferrous metals.
- Highest stock removal rate.
- Effective chip removal through improved anti-adhesion characteristics.
- Lower thermal loads.
- Longer service life.

Workpiece materials:

- Aluminum
- Bronze
- Copper
- Brass
- Titanium
- Titanium alloys
- Zinc
- Fibre-reinforced plastics (GRP/CRP)
- Thermoplastics

PFERDVALUE®:

PFERDEFFICIENCY® recommends burs with HICOAT® coating for long fatigue-free and resource-saving work with perfect results in a very short period of time.

Waste Saving Time Saving

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Determine the type of application.
❸ Select the cut.
❹ Establish the peripheral speed range.

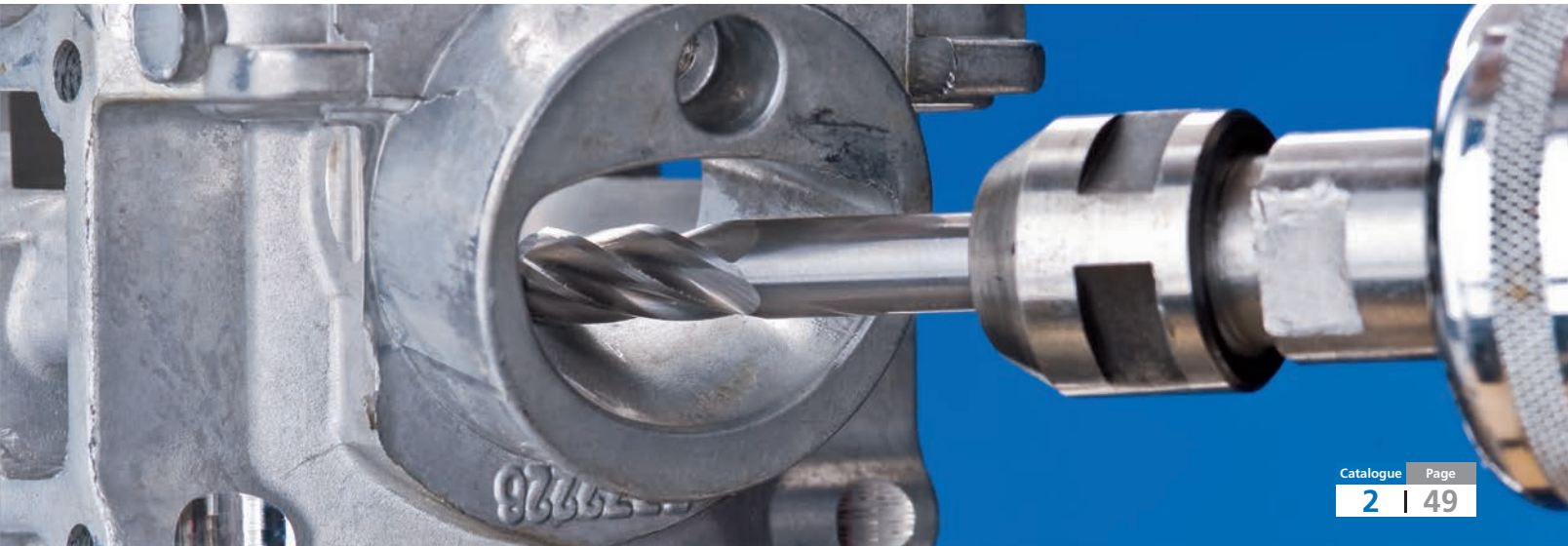
To determine the recommended rotational speed range [RPM], please proceed as follows:

❺ Select the required bur diameter.
❻ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

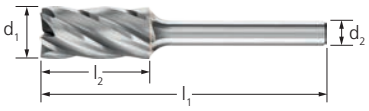
❶ Material group			❷ Application	❸ Cut	❹ Peripheral speed
Non-ferrous metals	Soft non-ferrous metals	Aluminum alloys	Coarse stock removal	ALU HICOAT® HC-NFE	2,000 - 3,600 SFPM
			Fine stock removal	ALU HICOAT® HC-NFE	3,000 - 3,600 SFPM
		Brass, copper, zinc	Coarse stock removal	ALU HICOAT® HC-NFE	2,000 - 3,600 SFPM
			Fine stock removal	ALU HICOAT® HC-NFE	3,000 - 3,600 SFPM
	Hard non-ferrous metals	Hard aluminum alloys (high Si content)	Coarse stock removal	ALU HICOAT® HC-NFE	2,000 - 3,600 SFPM
			Fine stock removal	ALU HICOAT® HC-NFE	3,000 - 3,600 SFPM
		Bronze	Coarse stock removal	ALU HICOAT® HC-NFE	2,000 - 3,000 SFPM
			Fine stock removal	ALU HICOAT® HC-NFE	2,000 - 3,600 SFPM
Plastics, other materials	Thermoplastics, fibre-reinforced plastics (GRP/CRP)		Coarse stock removal	ALU HICOAT® HC-NFE	2,000 - 3,600 SFPM
			Fine stock removal	ALU HICOAT® HC-NFE	

Example:
Carbide bur,
ALU cut,
bur diameter of 1/2".
Coarse stock removal on hard non-ferrous metals, e.g. bronze.
Peripheral speed: 2,000–3,000 SFPM
Rotational speed range:
16,000–24,000 RPM

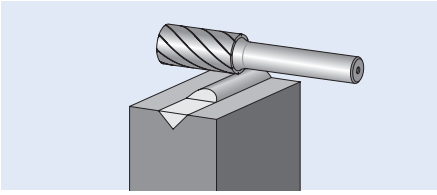
❺ Bur dia. [Inches]	❻ Peripheral speed [SFPM]		
	2,000	3,000	3,600
	Rotational speed [RPM]		
1/8	64,000	95,000	117,000
1/4	32,000	48,000	59,000
5/16	24,000	36,000	44,000
3/8	19,000	29,000	35,000
1/2	16,000	24,000	30,000
5/8	12,000	18,000	22,000



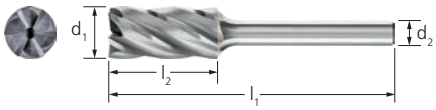
Carbide burs, high performance line
ALU cut for aluminum/non-ferrous metals



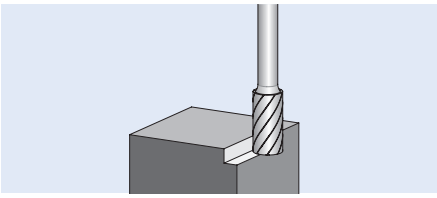
Cylindrical bur with plain end (uncut) – Shape A



d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number ALU	
Shank dia. 1/4" [d_2]					
1/4	5/8	SA-1	1-15/16	24035	1
3/8	3/4	SA-3	2-1/2	24065	1
1/2	1	SA-5	2-3/4	24105	1
5/8	1	SA-6	2-3/4	24115	1



Cylindrical bur with end cut – Shape B

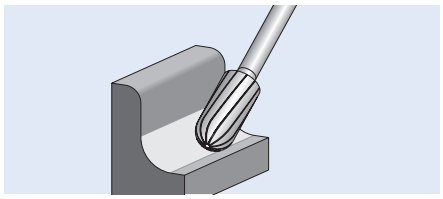


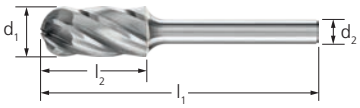
PFERDVALUE®:
With HICOAT® coating:

Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number ALU	ALU HC-NFE	
Shank dia. 1/8" [d_2]						
1/8	9/16	SB-43	1-1/2	23165	-	1
1/4	1/2	SB-51	1-11/16	23175	-	1
Shank dia. 1/4" [d_2]						
1/4	5/8	SB-1	1-15/16	24215	-	1
3/8	3/4	SB-3	2-1/2	24245	24250	1
1/2	1	SB-5	2-3/4	24285	27105	1
5/8	1	SB-6	2-3/4	24295	-	1

Cylindrical bur with radius end – Shape C



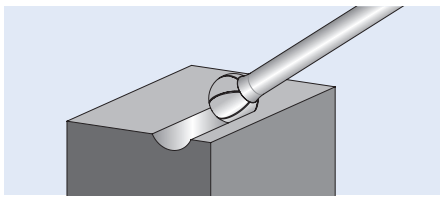


PFERDVALUE®:
With HICOAT® coating:

Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number ALU	ALU HC-NFE	
Shank dia. 1/8" [d_2]						
1/8	1/2	SC-42	1-1/2	23195	-	1
1/4	1/2	SC-51	1-11/16	23205	-	1
Shank dia. 1/4" [d_2]						
1/4	5/8	SC-1	1-15/16	24395	-	1
3/8	3/4	SC-3	2-1/2	24425	24433	1
1/2	1	SC-5	2-3/4	24465	27165	1
5/8	1	SC-6	2-3/4	24475	-	1

Ball bur – Shape D

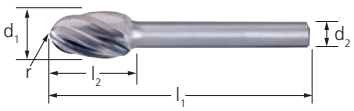


PFERDVALUE®:
With HICOAT® coating:

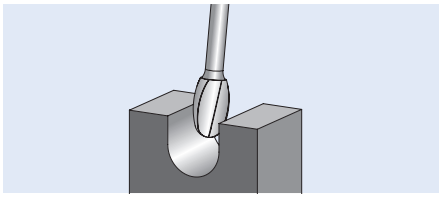
Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number ALU	ALU HC-NFE	
Shank dia. 1/8" [d_2]						
1/8	3/32	SD-42	1-1/2	23245	-	1
1/4	3/16	SD-51	1-3/8	23255	-	1
Shank dia. 1/4" [d_2]						
1/4	3/16	SD-1	1-15/16	24545	-	1
3/8	5/16	SD-3	2-1/16	24565	24570	1
1/2	7/16	SD-5	2-3/16	24585	27235	1
5/8	9/16	SD-6	2-5/16	24595	-	1

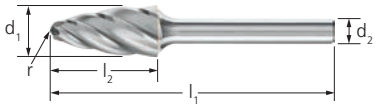
Carbide burs, high performance line
ALU cut for aluminum/non-ferrous metals



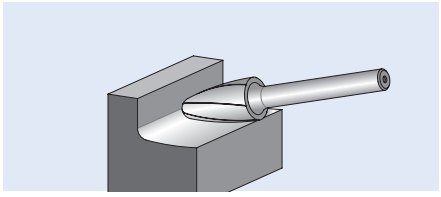
Oval bur – Shape E



d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number ALU	
Shank dia. 1/4" [d_2]						
1/4	3/8	SE-1	1-15/16	.110	25652	1
3/8	5/8	SE-3	2-3/8	.157	24645	1
1/2	7/8	SE-5	2-5/8	.196	24655	1
5/8	1	SE-6	2-3/4	.256	24665	1



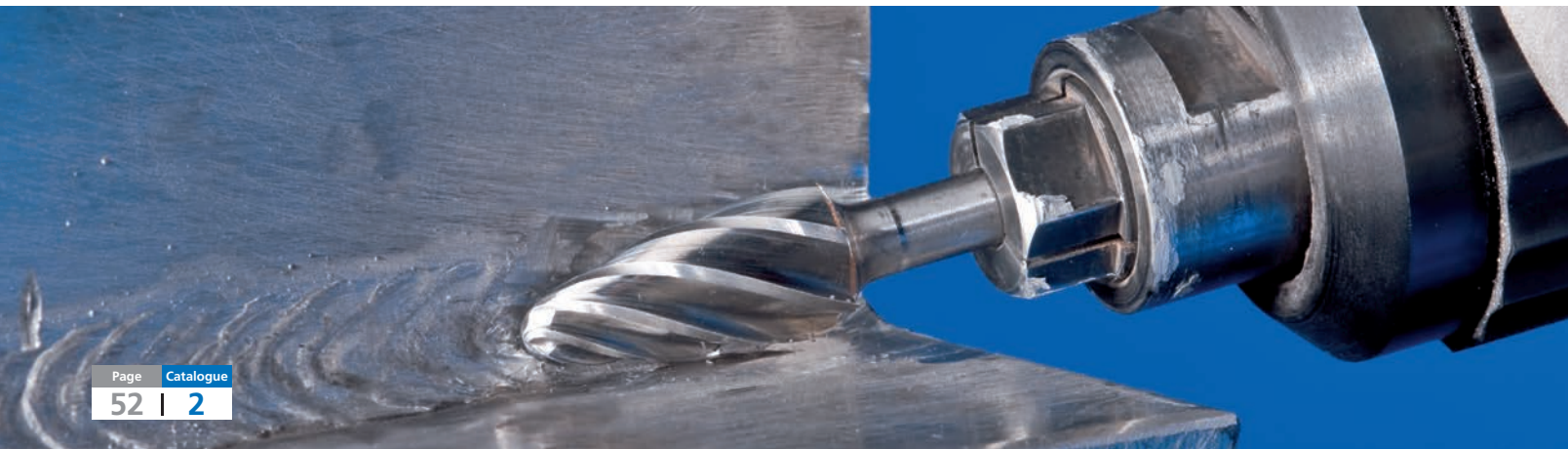
Tree bur with radius end – Shape F



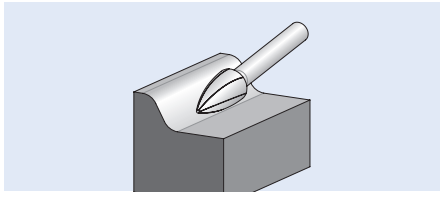
PFERDVALUE®:
With HICOAT® coating:

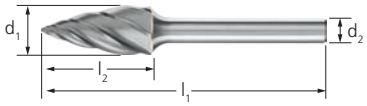
Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number ALU	ALU HC-NFE	
Shank dia. 1/8" [d_2]							
1/8	1/2	SF-42	1-1/2	.029	23315	-	1
1/4	1/2	SF-51	1-11/16	.059	23325	-	1
Shank dia. 1/4" [d_2]							
1/4	5/8	SF-1	1-15/16	.059	24695	-	1
3/8	3/4	SF-3	2-1/2	.098	24705	24710	1
1/2	1	SF-5	2-3/4	.098	24725	27280	1
5/8	1	SF-6	2-3/4	.141	24745	-	1



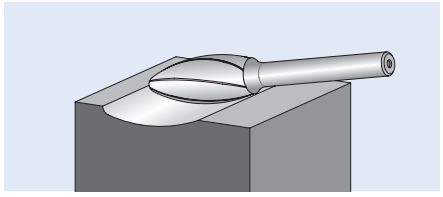
Tree bur with pointed end – Shape G





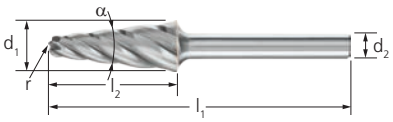
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number ALU	
Shank dia. 1/4" [d_2]					
1/4	5/8	SG-1	1-15/16	25653	1
3/8	3/4	SG-3	2-1/2	25654	1
1/2	1	SG-5	2-3/4	25655	1
5/8	1	SG-6	2-3/4	25656	1

Flame bur – Shape H

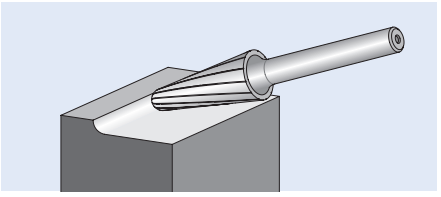


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number ALU	
Shank dia. 1/4" [d_2]						
1/4	5/8	SH-1	1-15/16	.039	25657	1
5/16	3/4	SH-2	2-1/2	.059	25658	1
1/2	1-1/4	SH-5	3	.082	25659	1

Carbide burs, high performance line
ALU cut for aluminum/non-ferrous metals



14° Taper bur with radius end – Shape L



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With HICOAT® coating:

Waste Saving Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	α [Inches]	l_1 [Inches]	r [Inches]	Cut type and EDP number ALU	ALU HC-NFE	
Shank dia. 1/4" [d_2]								
3/8	1-1/16	SL-3	14°	3	.114	25155	25160	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	25165	27450	1
5/8	1-5/16	SL-6	14°	3-1/4	.189	25185	-	1

5-piece carbide bur set – ALU cut

Contains five carbide burs for processing aluminum in the most common shapes and dimensions.

The sturdy plastic box protects the burs from dirt and damage.
Five additional slots are available for other burs.

EDP 26550
5 piece ALU cut carbide bur set 1/4" shank (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and ALU cut.

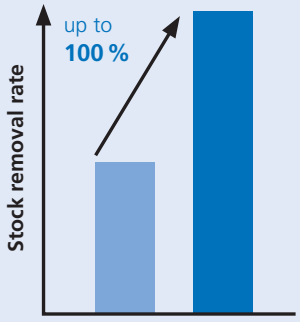
Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number ALU	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26550	24105	1
Cylindrical (radius end)	1/2	1	SC-5		24465	1
Oval	1/2	7/8	SE-5		24655	1
Tree	1/2	1	SF-5		24725	1
14° Taper	1/2	1-1/8	SL-4		25165	1

With the CAST cut, PFERD has developed innovative burs especially for work on cast iron. They are characterized by an extremely high stock removal rate on cast iron and impress through smooth milling with significantly reduced vibration and less noise.

Advantages:

- Up to 100% higher stock removal rate when used on cast iron due to the innovative tooth geometry, when compared with conventional double cut burs.
- Significantly increased aggressiveness, large chips and very good chip removal.
- Comfortable working with reduced vibration and less noise.

Performance values for applications on cast iron



- Conventional double cut burs
- Carbide burs, CAST cut

Workpiece materials:

- Grey cast iron
- Nodular cast iron
- Annealed cast iron

Applications:

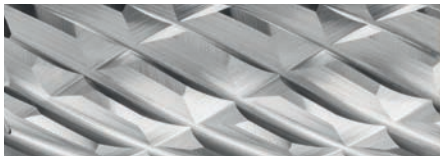
- Milling out
- Leveling
- Deburring
- Cutting out holes
- Surface work
- Work on weld seams

Recommendations for use:

- If possible, use the tools on powerful drives with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burs, work with higher rotational/peripheral speeds. Power recommendation for power tools: from 300 watts.
- Please observe the rotational speed recommendations.

Compatible with:

- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

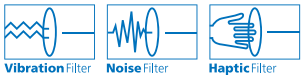


Safety note:

- The very high stock removal rate can cause discolouration on the shank. This does not constitute a safety risk.

PFERDVALUE®:

PFERDERGONOMICS® recommends burs with CAST cut as an innovative bur solution for comfortable working with significantly reduced vibration and less noise.



PFERDEFFICIENCY® recommends burs with CAST cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

Recommended rotational speed range [RPM]

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

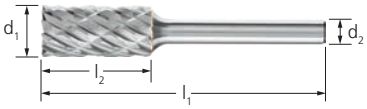
❶ Refer to the table for the peripheral speed.
❷ Select the required bur diameter.
❸ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

Material group			Application	Cut	❶ Peripheral speed
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse stock removal	CAST	1,500 - 2,500 SFPM

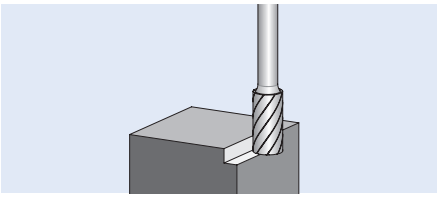
Example
Carbide bur, CAST cut,
bur diameter: 1/2".
Coarse stock removal on cast iron.
Peripheral speed: 1,500–2,500 SFPM
Rotational speed: 12,000–20,000 RPM

❷ Bur dia. [Inches]	❸ Peripheral speeds [SFPM]	
	1,500	2,500
	Rotational speeds [RPM]	
3/8	14,000	24,000
1/2	12,000	20,000

Carbide burs, high performance line
CAST cut for cast iron



Cylindrical bur with plain end (uncut) – Shape A



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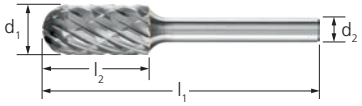
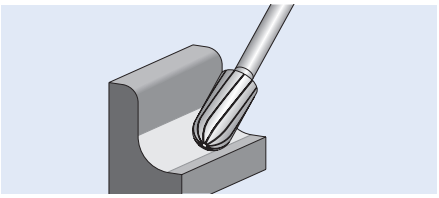
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number CAST	
Shank dia. 1/4" [d_2]					
3/8	3/4	SA-3	2-1/2	24069	1
1/2	1	SA-5	2-3/4	24109	1



Cylindrical bur with radius end – Shape C



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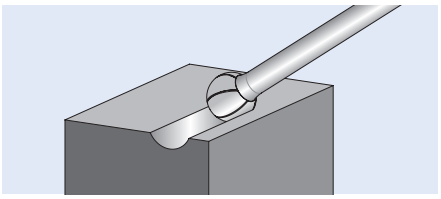
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number CAST	
Shank dia. 1/4" [d_2]					
3/8	3/4	SC-3	2-1/2	24429	1
1/2	1	SC-5	2-3/4	24469	1

Ball bur – Shape D



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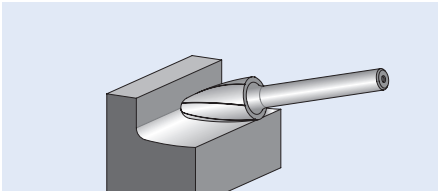
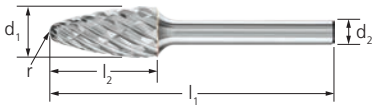
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number CAST	
Shank dia. 1/4" [d_2]					
3/8	5/16	SD-3	2-1/16	24569	1
1/2	7/16	SD-5	2-3/16	24589	1

Tree bur with radius end – Shape F





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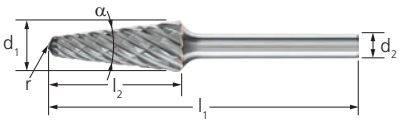
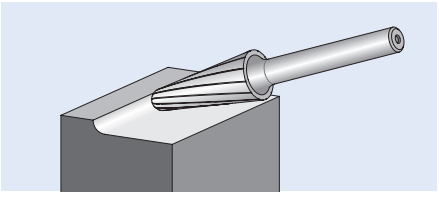
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number CAST	
Shank dia. 1/4" [d_2]						
3/8	3/4	SF-3	2-1/2	.098	24709	1
1/2	1	SF-5	2-3/4	.098	24729	1



14° Taper bur with radius end – Shape L



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d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	r [Inches]	Cut type and EDP number CAST	
Shank dia. 1/4" [d_2]							
3/8	1-1/16	SL-3	14°	3	.114	25159	1
1/2	1-1/8	SL-4	14°	3-1/16	.130	25169	1

5-piece carbide bur set – CAST cut

Contains five carbide burs for processing cast iron in the most common shapes and dimensions.

The sturdy plastic box protects the burs from dirt and damage.
Five additional slots are available for other burs.

EDP 26555
5 piece carbide bur set 1/4" shank CAST cut (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and CAST cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number CAST	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26555	24109	1
Cylindrical (radius end)	1/2	1	SC-5		24469	1
Ball	1/2	7/16	SD-5		24589	1
Tree (radius end)	1/2	1	SF-5		24729	1
14° Taper (radius end)	1/2	1-1/8	SL-4		25169	1

The TOUGH cut has been specially designed for tough operating conditions in shipyards, foundries and steel construction. They are also ideal for use in all manufacturing sectors where, due to the difficult production environment, tooth breakages or other damage to conventional burs is a frequent occurrence.

Advantages:

- Innovative, special cuts providing exceptional impact resistance.
- Minimized tooth chipping/breakage, splintering and bur failures due to very robust, high-performance cuts.
- Can also be used at low rotational speeds.
- Due to their extreme impact resistance, they can be used as long-shank variants.

Applications:

- High-impact applications when using shank extensions
- Applications with a high angle of surface contact
- Milling of narrow contours
- Applications where high rotational speeds are not available

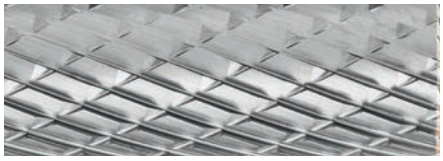
Workpiece materials:

- Cast iron
- Steel
- Cast steel
- The TOUGH cut can be used on materials up to 580 HV (54 HRC). For harder materials, it is recommended to perform trials beforehand.

Recommendations for use:

- For the cost-effective use of burs, work with higher rotational/peripheral speeds.
  Power recommendation for power tools:
  - Shank diameter of 1/8": 75 to 300 watts
  - Shank diameter of 1/4": from 300 watts
- Please observe the rotational speed recommendations.

TOUGH cut



Carbide burs with the TOUGH cut are particularly aggressive and are characterized by high stock removal.

Compatible with:

- Flexible shaft drive
- Straight grinder

Safety note:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Select the cut.
❸ Establish the peripheral speed range.

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

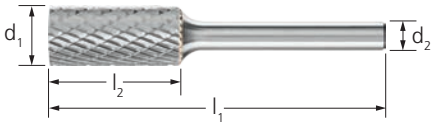
❹ Select the required bur diameter.
❺ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

❶ Material group			Application	❷ Cut	❸ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Coarse stock removal with impact load	TOUGH	850 - 2,000 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel		TOUGH	850 - 1,150 SFPM
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Coarse stock removal with impact load	TOUGH	850 - 2,000 SFPM

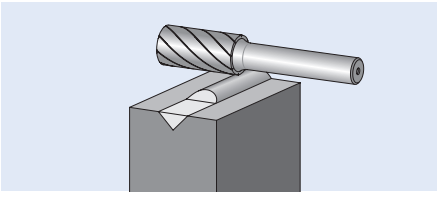
Example:
Carbide bur,
TOUGH cut,
bur diameter of 1/2".
Coarse stock removal with impact load on steels up to 370 HV.
Peripheral speed: 850–2,000 SFPM
Rotational speed range: 7,000–16,000 RPM

❹ Bur dia. [Inches]	❺ Peripheral speeds [SFPM]		
	850	1,150	2,000
	Rotational speeds [RPM]		
3/8	8,000	11,000	19,000
1/2	7,000	9,000	16,000
5/8	5,000	7,000	12,000

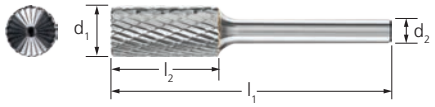
Carbide burs, high performance line
TOUGH cut for tough applications



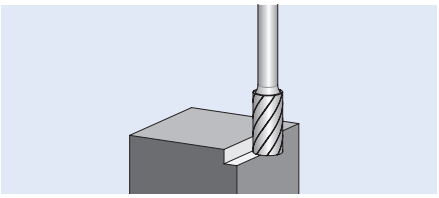
Cylindrical bur with plain end (uncut) – Shape A



d1 [Inches]	l2 [Inches]	SCTI no.	l1 [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d2]					
3/8	3/4	SA-3	2-1/2	22152	1
1/2	1	SA-5	2-3/4	22156	1

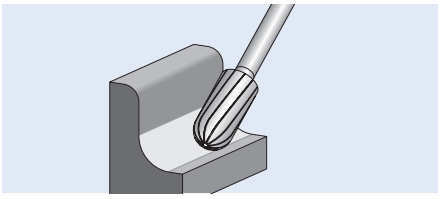


Cylindrical bur with end cut – Shape B



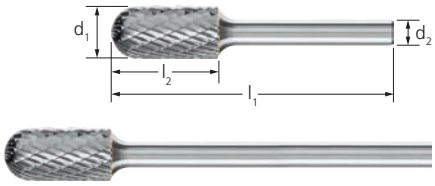
d1 [Inches]	l2 [Inches]	SCTI no.	l1 [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d2]					
3/8	3/4	SB-3	2-1/2	22182	1
1/2	1	SB-5	2-3/4	22186	1

Cylindrical bur with radius end – Shape C



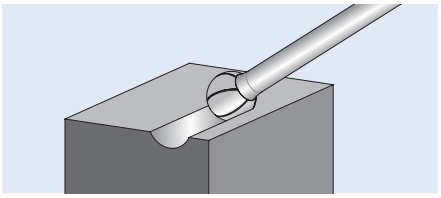
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

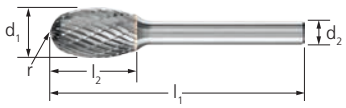


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d_2]					
3/8	3/4	SC-3	2-1/2	22212	1
1/2	1	SC-5	2-3/4	22216	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
3/8	3/4	SC-3L6	6-5/8	22734	1

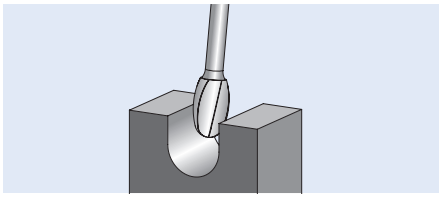
Ball bur – Shape D



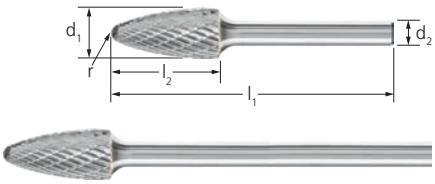
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d_2]					
1/2	7/16	SD-5	2-3/16	22244	1
5/8	9/16	SD-6	2-5/16	22246	1



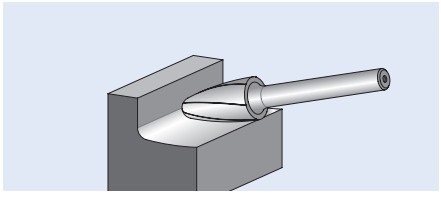
Oval bur – Shape E



d1 [Inches]	l2 [Inches]	SCTI no.	l1 [Inches]	r [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d2]						
3/8	5/8	SE-3	2-3/8	.157	22260	1



Tree bur with radius end – Shape F

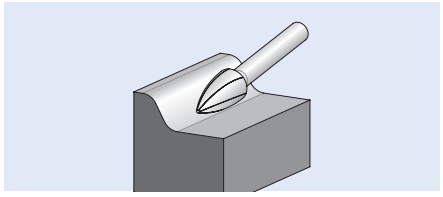


Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

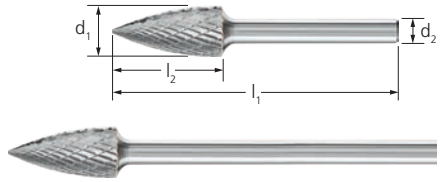
d1 [Inches]	l2 [Inches]	SCTI no.	l1 [Inches]	r [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d2]						
1/2	1	SF-5	2-3/4	.098	22276	1
5/8	1	SF-6	2-3/4	.141	22278	1
Extended shank – dia. 1/4" [d2], SL 6" (L6)						
1/2	1	SF-5L6	6-7/8	.098	22754	1

Tree bur with pointed end – Shape G



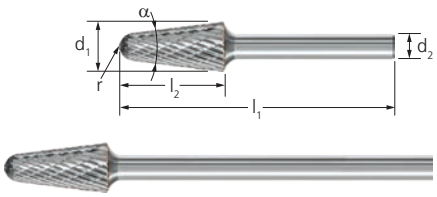
Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

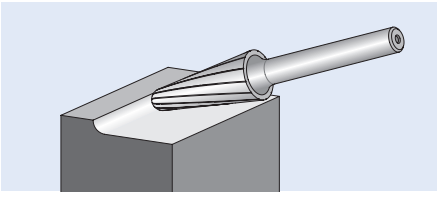


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d_2]					
3/8	3/4	SG-3	2-1/2	22294	1
1/2	1	SG-5	2-3/4	22296	1
5/8	1	SG-6	2-3/4	22298	
Extended shank – dia. 1/4" [d_2], SL 6" (L6)					
1/2	1	SG-5L6	6-7/8	22760	1

Carbide burs, high performance line
TOUGH cut for tough applications



14° Taper bur with radius end – Shape L



Safety notes:

Please observe the reduced rotational speeds for extended shank burs. They can be found on page 11.

d_1 [Inches]	l_2 [Inches]	SCTI no.	α	l_1 [Inches]	r [Inches]	Cut type and EDP number TOUGH	
Shank dia. 1/4" [d_2]							
1/2	1-1/8	SL-4	14°	3-1/16	.130	22346	1
Extended shank – dia. 1/4" [d_2], SL 6" (L6)							
1/2	1-1/8	SL-4L6	14°	7-3/16	.130	22774	1

5-piece carbide bur set – TOUGH cut

Contains five carbide burs for tough applications in the most common shapes and dimensions.

The sturdy plastic box protects the burs from dirt and damage.
Five additional unused slots are available for other burs.

EDP 26551
5 piece carbide bur set 1/4" shank TOUGH cut (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter and TOUGH cut.

Set contents shape	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	Cut type and set EDP number TOUGH	Individual bur EDP's in set	
Cylindrical (plain end)	1/2	1	SA-5	26551	22156	1
Cylindrical (radius end)	1/2	1	SC-5		22216	1
Ball	1/2	7/16	SD-5		22244	1
Tree (radius end)	1/2	1	SF-5		22276	1
Tree (pointed)	1/2	1	SG-5		22296	1

Carbide burs, high performance line
MICRO cut for fine finishing

Carbide burs with MICRO cut are specifically designed for finishing and are used in areas in which abrasive mounted points are usually used. They offer a higher stock removal rate and produce a high surface quality, particularly compared with conventionally milled surfaces. They also operate with low vibration and little noise. They maintain their geometry over their entire service life, and are well suited to manual and machine applications. Almost all materials up to a hardness of 940 HV (68 HRC) can be machined.

Advantages:

- High surface quality.
- Unlike with abrasive mounted points, there is no change in geometry due to wear and tear.
- Work on almost all materials up to 940 HV (68 HRC).

Applications:

- Finishing
- Very fine cleaning work
- Corrections in die and mold construction
- Sharpening cutting tools

Workpiece materials:

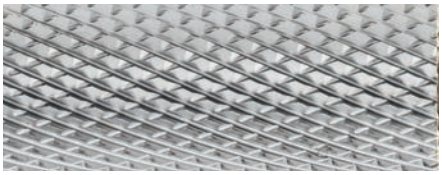
- Steel and cast steel
- Stainless steel (INOX)
- Non-ferrous metals
- Cast iron

Recommendations for use:

- If possible, use the tools on powerful drives with elastically mounted spindles to avoid vibration.
- For the cost-effective use of burs, work with higher rotational/peripheral speeds.
  Power recommendation for power tools:
  - Shank diameter of 1/8": 75 to 300 watts
  - Shank diameter of 1/4": from 300 watts
- Please observe the rotational speed recommendations.

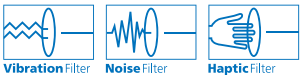
Compatible with:

- Flexible shaft drive
- Straight grinder
- Robot applications
- CNC machines



PFERDVALUE®:

PFERDERGONOMICS® recommends burs with MICRO cut as an innovative bur solution for comfortable working with significantly reduced vibration and less noise.



PFERDEFFICIENCY® recommends burs with MICRO cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Establish the peripheral speed range.

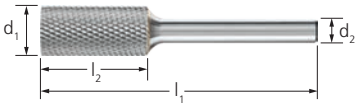
To determine the recommended rotational speed range [RPM], please proceed as follows:

❸ Select the required bur diameter.
❹ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

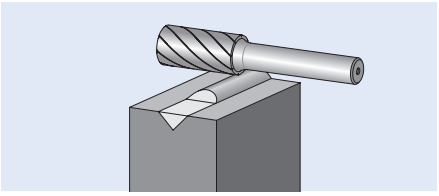
❶ Material group			Application	Cut	❷ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Fine stock removal	MICRO	2,000 - 2,500 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel			1,500 - 2,000 SFPM
Stainless steel (INOX)	Rust and acid-resistant steels	Austenitic and ferritic stainless steels	Fine stock removal	MICRO	1,500 - 2,000 SFPM
Non-ferrous metals	Hard non-ferrous metals	Bronze, titanium/titanium alloys, hard aluminum alloys (high Si content)	Fine stock removal	MICRO	1,500 - 2,000 SFPM
	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, with nodular graphite cast iron, white annealed cast iron, black cast iron	Fine stock removal	MICRO	2,000 - 2,500 SFPM

Example
Micro bur, MICRO cut,
bur diameter: 3/8".
Fine stock removal on steel and cast steel up to 370 HV (38 HRC), e.g. construction steels, carbon steels etc.
Peripheral speed: 2,000–2,500 SFPM
Rotational speed: 19,000–24,000 RPM

❺ Bur dia. [Inches]	❹ Peripheral speed [SFPM]		
	1,500	2,000	2,500
	Rotational speed [RPM]		
3/32	72,000	95,000	120,000
1/8	48,000	64,000	80,000
1/4	24,000	32,000	40,000
3/8	14,000	19,000	24,000



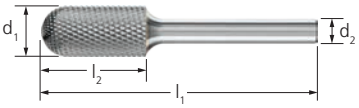
Cylindrical bur with plain end (uncut) – Shape A



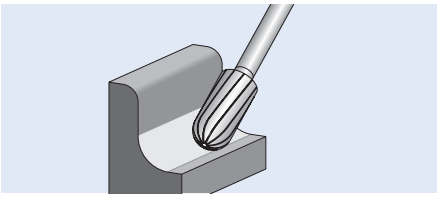
PFERDVALUE®:

Vibration Filter · Noise Filter · Haptic Filter · Time Saving

d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number MICRO	
Shank dia. 1/8" [d_2]					
1/8	1/2	SA-43	1-1/2	27500	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SA-1	1-15/16	27512	1
3/8	3/4	SA-3	2-1/2	27516	1



Cylindrical bur with radius end – Shape C



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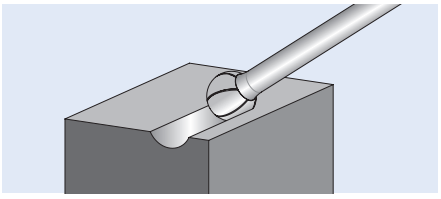
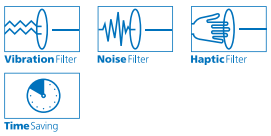
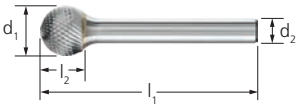
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number MICRO	
Shank dia. 1/8" [d_2]					
1/8	1/2	SC-42	1-1/2	27540	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SC-1	1-15/16	27541	1
3/8	3/4	SC-3	2-1/2	27542	1

Ball bur – Shape D



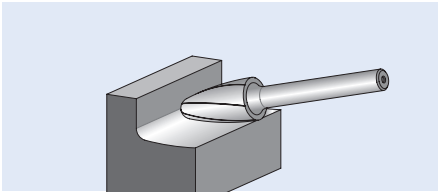
PFERDVALUE®:



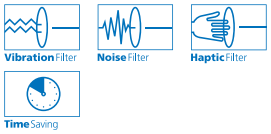


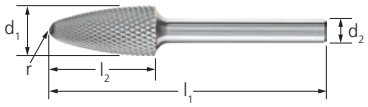
d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number MICRO	
Shank dia. 1/8" [d_2]					
3/32	3/32	SD-41	1-1/2	27519	1
1/8	3/32	SD-42	1-1/2	27520	1
Shank dia. 1/4" [d_2]					
1/4	3/16	SD-1	1-15/16	27521	1
3/8	5/16	SD-3	2-1/16	27522	1

Tree bur with radius end – Shape F



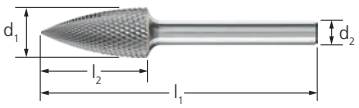
PFERDVALUE®:



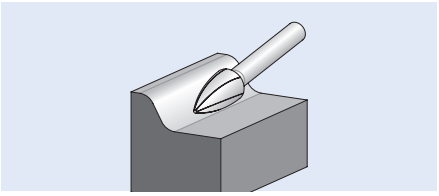


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	r [Inches]	Cut type and EDP number MICRO	
Shank dia. 1/8" [d_2]						
1/8	1/2	SF-42	1-1/2	.029	27524	1
Shank dia. 1/4" [d_2]						
1/4	5/8	SF-1	1-15/16	.059	27528	1
3/8	3/4	SF-3	2-1/2	.141	27532	1

Carbide burs, high performance line
MICRO cut for finishing work



Tree bur with pointed end – Shape G



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d_1 [Inches]	l_2 [Inches]	SCTI no.	l_1 [Inches]	Cut type and EDP number MICRO	
Shank dia. 1/8" [d_2]					
1/8	1/4	SG-41	1-1/2	27546	1
Shank dia. 1/4" [d_2]					
1/4	5/8	SG-1	1-15/16	27547	1
3/8	3/4	SG-3	2-1/2	27548	1

Carbide burs for work on edges are mainly used in steel and aluminum construction, and have been specifically designed for chamfering, deburring, and rounding of edges. PFERD offers burs for both flexible as well as for defined work on edges, including EDGE ALU designed with ALU cut for use on aluminum.

Workpiece materials:

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

Compatible with:

- Flexible shaft drive
- Straight grinder
- Robot
- CNC machines

Defined work on edges with the EDGE cut

Carbide burs with the EDGE cut have been specially developed for defined work on edges. The special design allows the bur to run directly along the edges without damaging the workpiece. Exact edge shapes can be created in a single step – with either defined chamfers of 30° or 45°, or to a defined radius of 1/8". Among other things, rounding edges is a precautionary measure for anti-corrosion protection according to ISO 12944-3, ISO 8501-3, SOLAS XII/6.3 (Ref. T4/3.01 MSC.1/Circ.1198).

Advantages:

- Special design for precise guidance.
- Safe and comfortable to guide.
- Create exact edge shapes in a single step.

Applications:

- Defined work on edges
- Defined deburring
- Breaking and rounding edges in steel and aluminum construction
- Rounding edges in preparation for the application of anti-corrosion coatings in shipbuilding, on crane systems and other steel constructions which are exposed to corrosion loading
- Defined chamfering for weld seam preparation for V-shaped seams (60°, ISO 9692-1)
- Defined chamfering for edge breaking (45°)

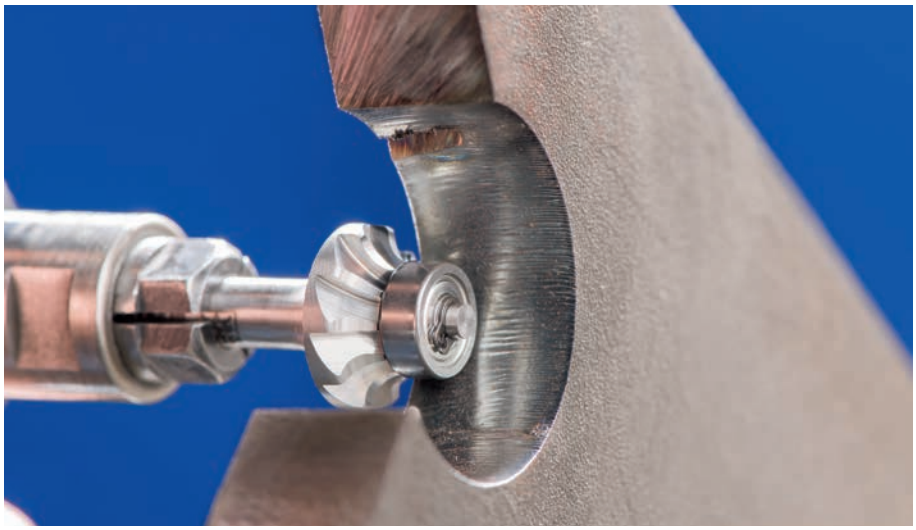
Recommendations for use:

- Use the burs counterrotationally. In order to produce a fine surface, pass the bur over the edges in the rotational direction.
- If possible, use EDGE cut burs with the PFERD pneumatic straight grinder PG 3/210 (EDP 90036) with matching guide sleeve EFH PG 3/210 (EDP 95294) (see the info box on the right).

PFERDVALUE®:

PFERDEFFICIENCY® recommends burs with EDGE cut for long fatigue-free and resource-saving work with perfect results in a very short period of time.

Energy Saving Time Saving



EDGE Cutting System (ECS)

The EDGE Cutting System consists of burs with the EDGE cut and a special guide sleeve that can be mounted into a conventional power tool collet to ensure optimal guidance during light deburring work (see pages 71–72).

Advantages:

- Improved guidance.
- Can be used with any conventional straight grinder.
- Bur is interchangeable.

Compressed-air straight grinder PG 3/210 DH and accessories

The combination of this compressed-air straight grinder, the specially designed guide sleeve for this power tool and burs with the EDGE cut, guarantees optimal guidance for creating exact edge shapes.

Advantages:

- Improved guidance due to additional contact surface.
- Exhaust is discharged towards the front, so that the thermal load on the workpiece and the bur is reduced (this is a key advantage when working with materials which do not conduct heat well, such as stainless steel (INOX)).
- Avoids the build-up of chip deposits when working on aluminum materials.
- Chips are removed in a targeted way by the power tool's exhaust air.

Ordering data:

Compressed-air straight grinder

PG 3/210
EDP 90036

Guide sleeve

EFH PG 3/210
EDP 95294

Guide plate

EFP PG 3/210
EDP 95295

Carbide burs, high performance line
Carbide burs for work on edges

Recommended rotational speed range [RPM]

To determine the recommended peripheral speed range [SFPM], please proceed as follows:

❶ Select the material group to be machined.
❷ Select the cut.
❸ Establish the peripheral speed range.

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

❹ Select the required bur diameter.
❺ The peripheral speed range and the bur diameter determine the recommended rotational speed range.

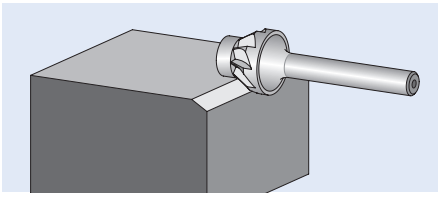
❶ Material group			Application	❷ Cut	❸ Peripheral speed
Steel, cast steel	Steels up to 370 HV (38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steel, alloyed steels	Work on edges	EDGE	2,000 - 3,000 SFPM
	Hardened, heat-treated steels over 370 HV (38 HRC)	Tool steels, tempering steels, alloyed steels, cast steel			2,000 - 2,500 SFPM
Non-ferrous metals	Soft non-ferrous metals	Soft aluminum alloys	Work on edges	EDGE ALU	3,000 - 3,600 SFPM
		Brass, copper, zinc		EDGE	2,000 - 3,000 SFPM
	Hard non-ferrous metals	Bronze, hard aluminum alloys (high Si content)	Work on edges	EDGE ALU	3,000 - 3,600 SFPM
		Titanium/titanium alloys		EDGE	850 - 1,500 SFPM
	High-temperature-resistant materials	Nickel-based and cobalt-based alloys (engine and turbine construction)	Work on edges	EDGE	850 - 1,500 SFPM
Cast iron	Grey cast iron, white cast iron	Cast iron with flake graphite, with nodular graphite cast iron, white annealed cast iron, black cast iron	Work on edges	EDGE	2,000 - 3,000 SFPM
Plastics, other materials	Fibre-reinforced plastics (GRP/CRP), thermoplastics		Work on edges	EDGE ALU	2,500 - 3,600 SFPM

Example:
Carbide bur,
EDGE cut,
bur diameter of 5/8".
Steel and cast steel up to 370 HV (38 HRC),
e.g. construction steels, carbon steels etc.
Peripheral speed: 2,000 - 3,000 SFPM
Rotational speed range:
12,000 - 18,000 RPM

❹ Bur dia. [Inches]	❺ Peripheral speeds [SFPM]					
	850	1,500	2,000	2,500	3,000	3,600
	Rotational speeds [RPM]					
5/8	5,000	9,000	12,000	15,000	18,000	22,000

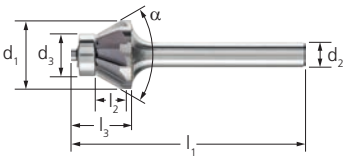
Cone counterbore EDGE 30°

Cone counterbore bur for the production of precisely defined chamfers. Suitable for counterboring and chamfering of defined 30° chamfer angles.



PFERDVALUE®:

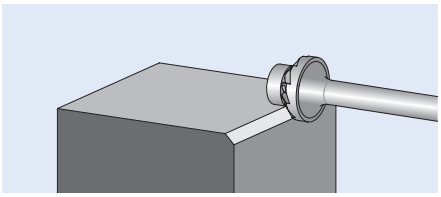
Time Saving | Energy Saving



d_1 [Inches]	l_2 [Inches]	SCTI no.	l_3 [Inches]	α [Inches]	l_1 [Inches]	d_3 [Inches]	Cut type and EDP number EDGE	EDGE ALU	
Shank dia. 1/4" [d_2]									
5/8	3/16	SJ-6	9/16	60°	2-1/4	3/8	25045	25175	1

Cone counterbore EDGE 45°

Cone counterbore bur for the production of precisely defined chamfers. Suitable for counterboring and chamfering of defined 45° chamfer angles. The chamfers created using the EDGE Cutting System (ECS) are .047" (+/- .007") wide.



Ordering notes:

- The EDGE Cutting System (ECS) bur can be reordered and replaced if required. Matching burs: EDP 25105 (EDGE) and EDP 25176 (EDGE ALU)

PFERDVALUE®:

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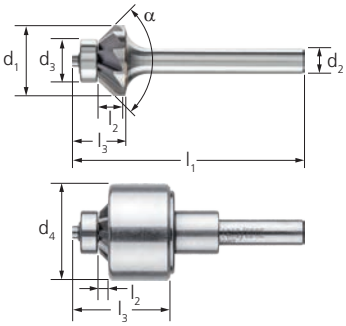
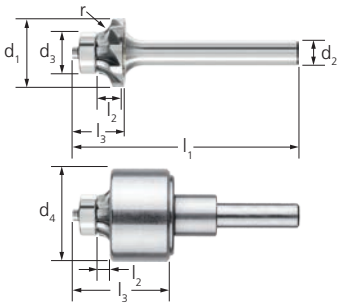
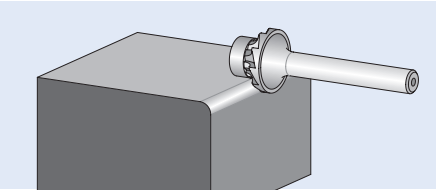


d_1 [Inches]	l_2 [Inches]	SCTI no.	l_3 [Inches]	α [Inches]	l_1 [Inches]	d_3 [Inches]	d_4 [Inches]	Cut type and EDP number EDGE	EDGE ALU	
Shank dia. 1/4" [d_2]										
5/8	1/8	SK-6	1/2	90°	2	3/8	-	25105	25176	1
EDGE Cutting System (ECS) – Shank dia. 1/4" [d_2]										
5/8	.040	SK-6	5/16	90°	2	3/8	1	25106	25177	1



Concave radius bur EDGE R-1/8"

Concave radius burs for the production of precise radii. Cannot be re-sharpened. Suitable for the production and processing of 1/8" outer radii.



Ordering notes:
- The EDGE Cutting System (ECS) bur can be reordered and replaced if required. Matching bur: EDP 25150

PFERDVALUE®:

TimeSaving EnergySaving

d_1 [Inches]	l_2 [Inches]	l_3 [Inches]	l_1 [Inches]	d_3 [Inches]	d_4 [Inches]	r [Inches]	Cut type and EDP number EDGE	
Shank dia. 1/4" [d_2]								
5/8	1/8	1/2	2	3/8	-	1/8	25150	1
EDGE Cutting System (ECS) – Shank dia. 1/4" [d_2]								
5/8	1/8	1/2	2	3/8	1	1/8	25149	1

Evaluation bur sets

5-piece carbide bur set – Multi-material

Contains five carbide burs in different cuts in the most common shapes and dimensions, uniquely designed for various materials including steel, stainless steel, aluminum and cast iron.

The sturdy plastic box protects the burs from dirt and damage.
Five additional unused slots are available for other burs.

EDP 26557
5 piece carbide bur set 1/4" shank (plastic case)
Contains 5 pcs. burs with 1/4" shank diameter.

Set contents shape	Cut	Bur dia. d_1 [Inches]	Bur length l_2 [Inches]	SCTI no.	EDP number	Individual bur EDP's in set	
Tree (radius end)	STEEL	1/2	2-3/4	SF-5	26557	24728	1
Tree (radius end)	INOX	1/2	2-3/4	SF-5		24727	1
Tree (radius end)	ALU	1/2	2-3/4	SF-5		24725	1
Tree (radius end)	CAST	1/2	2-3/4	SF-5		24729	1
Tree (radius end)	OMNI	1/2	2-3/4	SF-5		28000	1

PFERD

Bi-metal hole saws

Bi-metal hole saws
General information

Hole saws are made from tough, shatter-proof, sturdy HSS bi-metal. The saw teeth are made from high-quality M42 material.

Advantages:

- Cost-effective sawing of round cut-outs.
- Chattering during sawing is prevented by the alternating tooth pitch.
- High concentricity.
- Good chip removal.
- The hole saw is conveniently centred and guided via the replaceable bi-metal pilot drill.
- Hole saw arbor is supplied with an ejection spring for improved ejection of the sawn cut material.

Workpiece materials:

- Steel
- Stainless steel (INOX)
- Aluminum
- Copper, bronze, brass
- Plastics
- Wood

Applications:

- Cutting out holes

Recommendations for use:

- Observe the recommended rotational speed.
- Clamp the pilot drill in the hole saw arbor and make sure that it projects at least 1/8" over the teeth of the hole saw.
- When cutting metals, use a high-quality cutting oil, if possible. This facilitates smooth running and lengthens the hole saw service life.
  Exception: When working on aluminum, use kerosene instead of cutting oil.
- Bi-metal hole saws are suitable for work on stainless steel (INOX). In order to avoid corrosion, remove any particles which develop during work from the workpiece. Clean the workpiece chemically or mechanically (etching/polishing, etc.).
- Make sure that all the teeth are applied evenly. To prevent tooth breakage, avoid swinging movements during sawing.
- Avoid overheating the saw.

Compatible with:

- Power drill
- Drill press

Safety notes:

- When using shank extensions, the recommended hole saw rotational speed must not be exceeded. Risk of accidents!

= Wear eye protection!

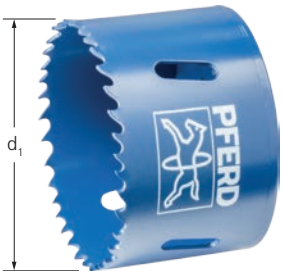
= Follow the safety instructions!

Bi-metal hole saws

Hole saws made from tough, shatter-proof, sturdy HSS bi-metal for cutting out holes.

Thread:
LS 14–LS 30 = 1/2–20
LS 32–LS 152 = 5/8-18

Ordering notes:
- Please refer to the table below for the maximum cutting depth.
- Please order hole saw arbors separately. Detailed information and ordering data on hole saw arbors can be found on page 78.



d_1 [Inches]	Max. cutting depth [Inches]	EDP number	Suitable arbors	Recommended rotational speed [RPM]				
				Steel	Stainless steel (INOX)	Non-ferrous metals	Plastics	
9/16	1-5/16	29100	EDP 29033, EDP 29034	620	310	800	1,000	1
5/8	1-5/16	29101	EDP 29033, EDP 29034	550	275	730	880	1
11/16	1-7/16	29102	EDP 29033, EDP 29034	520	260	680	820	1
3/4	1-7/16	29103	EDP 29033, EDP 29034	460	230	600	740	1
13/16	1-7/16	29104	EDP 29033, EDP 29034	410	205	540	670	1
7/8	1-7/16	29105	EDP 29033, EDP 29034	390	195	520	640	1
15/16	1-7/16	29106	EDP 29033, EDP 29034	360	180	470	580	1
1	1-7/16	29107	EDP 29033, EDP 29034	350	175	470	560	1
1-1/16	1-7/16	29108	EDP 29033, EDP 29034	325	160	435	520	1
1-1/8	1-7/16	29109	EDP 29033, EDP 29034	300	150	400	480	1
1-3/16	1-7/16	29110	EDP 29033, EDP 29034	285	145	380	470	1
1-1/4	1-7/16	29111	EDP 29036	275	140	360	440	1
1-5/16	1-7/16	29112	EDP 29036	260	135	345	420	1
1-3/8	1-7/16	29113	EDP 29036	250	125	330	400	1
1-7/16	1-7/16	29114	EDP 29036	235	115	310	370	1
1-1/2	1-7/16	29115	EDP 29036	230	115	300	370	1
1-9/16	1-7/16	29116	EDP 29036	215	110	280	350	1
1-5/8	1-7/16	29117	EDP 29036	210	105	280	340	1
1-11/16	1-1/4	29118	EDP 29036	200	100	260	330	1
1-3/4	1-1/4	29119	EDP 29036	195	95	260	320	1
1-13/16	1-1/4	29120	EDP 29036	185	90	250	300	1
1-7/8	1-1/4	29121	EDP 29036	180	90	240	290	1
2	1-1/4	29122	EDP 29036	170	85	230	270	1
2-1/16	1-1/4	29123	EDP 29036	165	80	220	270	1
2-1/8	1-1/4	29124	EDP 29036	160	80	210	260	1
2-1/4	1-1/4	29125	EDP 29036	150	75	200	250	1
2-5/16	1-1/4	29126	EDP 29036	145	70	190	240	1
2-3/8	1-1/4	29127	EDP 29036	140	70	190	230	1
2-1/2	1-1/4	29128	EDP 29036	135	65	180	220	1
2-9/16	1-1/4	29129	EDP 29036	135	60	180	220	1
2-5/8	1-1/4	29130	EDP 29036	130	65	170	210	1
2-3/4	1-1/4	29131	EDP 29036	125	60	160	200	1
2-7/8	1-1/4	29132	EDP 29036	120	60	160	190	1
3	1-1/4	29133	EDP 29036	115	55	150	180	1
3-1/8	1-1/4	29134	EDP 29036	110	55	140	180	1
3-1/4	1-1/4	29135	EDP 29036	105	50	140	170	1

Continued on next page

d_1 [Inches]	Max. cutting depth [Inches]	EDP number	Suitable arbors	Recommended rotational speed [RPM]				
				Steel	Stainless steel (INOX)	Non-ferrous metals	Plastics	
3-3/8	1-1/4	29136	EDP 29036	100	50	130	160	1
3-1/2	1-1/4	29137	EDP 29036	95	45	130	160	1
3-5/8	1-1/4	29138	EDP 29036	95	45	120	150	1
3-3/4	1-1/4	29139	EDP 29036	90	45	120	150	1
3-7/8	1-1/4	29140	EDP 29036	90	45	120	140	1
4	1-1/4	29141	EDP 29036	85	40	110	140	1
4-1/8	1-1/4	29142	EDP 29036	80	40	110	130	1
4-3/8	1-1/4	29144	EDP 29036	75	35	100	130	1
4-1/2	1-1/4	29145	EDP 29036	75	35	100	120	1
4-3/4	1-1/4	29146	EDP 29036	70	35	90	120	1
5	1-1/4	29147	EDP 29036	65	30	80	110	1
5-1/2	1-1/4	29148	EDP 29036	60	30	75	100	1
6	1-1/4	29149	EDP 29036	55	25	70	90	1

Bi-metal hole saw sets

13-piece hole saw set

The set contains nine bi-metal hole saws in the most common diameters, including accessories, for engineers in the construction, container and pipeline industries. It is supplied in a clearly structured plastic box which protects against dirt and damage. The operating instructions are included.
It is possible to use the 1-3/8" and 1-1/2" diameter hole saws with the adapter and washer.

Industry/ target group:
Process equipment construction, tank and pressure vessel construction, pipeline construction

Number of pieces	Dimension [Inches]	Contents			EDP number		
		Description	Diameter [Inches]	Shank dia. [Inches]		Individual EDP's in set	
13	8-1/2 x 7 x 2-1/2	Bi-metal hole saw	3/4	-	29180	29103	1
		Bi-metal hole saw	7/8	-		29105	1
		Bi-metal hole saw	1-1/8	-		29109	1
		Bi-metal hole saw	1-3/8	-		29113	1
		Bi-metal hole saw	1-1/2	-		29115	1
		Bi-metal hole saw	1-3/4	-		29119	1
		Bi-metal hole saw	2	-		29122	1
		Bi-metal hole saw	2-1/4	-		29125	1
		Bi-metal hole saw	2-1/2	-		29128	1
		Hole saw arbor	-	1/4		29036	1
		Hole saw arbor	-	3/8		29034	1
		Bi-metal pilot drill	-	1/4		29039	1
		Thread adapter	-	-		29070	1

Quick-mounting system for hole saws, adapter sets

PFERD offers a clamping system for easily and quickly using bi-metal hole saws. The quick-mounting system and the two three-part adapter sets, which have been tailored to the hole saw diameter, enable PFERD bi-metal hole saws to be used easily and conveniently on all conventional power drills.

Advantages:
- Easily and quickly swap different hole saws.
- After the application is completed, the hole saw and quick-mounting system can be separated without the use of additional tools by simply pressing a button.
- Interchangeable bi-metal pilot drill.

Recommendations for use:
- Screw the adapters quickly and easily into the desired hole saw and clamp them in the quick-mounting system.

Ordering notes:
- Adapter set EDP 29043 is available for hole saw diameter 9/16" - 1-3/16", and adapter set EDP 29044 for hole saw diameter 1-1/4" - 6". Both adapter sets contain three adapters with the same dimensions.

EDP 29042

EDP 29043

EDP 29044

For hole saw threads	Suitable for hole saw diameters [Inches]	d_2 [Inches]	Shank type	Description	EDP number	
-	9/16 - 6	7-1/16	hexagonal	Quick-mounting system for hole saws	29042	1
1/2-20	9/16 - 1-3/16	-	-	3-piece quick-mounting adapter set	29043	1
5/8-18	1-1/4 - 6	-	-	3-piece quick-mounting adapter set	29044	1

Example combination

1-3/4" hole saw EDP 29119

Adapters from adapter set EDP 29044

Quick-mounting system EDP 29042

Bi-metal hole saw 1-3/4" with adapter EDP 29044 and quick-mounting system EDP 29042

Bi-metal pilot drill

Bi-metal pilot drills for bi-metal hole saw arbors and quick-mounting systems for hole saws.

Ordering notes:
- Hole saw arbors EDP 29033 and EDP 29034 are supplied with the bi-metal pilot drill EDP 29040.
- Hole saw arbors 29036 are supplied with the bi-metal pilot drill EDP 29039.
- The bi-metal pilot drill EDP 29039 can be used for the quick-mounting system EDP 29042.

EDP 29040

EDP 29039

Shank dia. [Inches]	Shank dia. [mm]	Shank type	d_2 [Inches]	Suitable for hole saw diameters [Inches]	Suitable for arbors	EDP number	
1/4	6.35	Round	1/4	9/16 to 6	EDP 29033, EDP 29034	29040	1
	6.35	Round	1/4	9/16 to 6	EDP 29036	29039	1

Bi-metal hole saws
Accessories

EDP 29033

EDP 29034

EDP 29036

Hole saw arbors

Hole saw arbors are designed for mounting the hole saw and the pilot drill.

Purpose of the ejection spring
It prevents the sawn-out material from becoming jammed between the inner walls of the hole saw and the drill. The spring force ejects the material. Should this effect not be required for a particular application, e.g. pipes that are already installed, the spring can easily be removed manually without the help of tools.

Ordering notes:
- Available in three sizes.
- Select the appropriate arbor, taking into account the hole saw diameter and available power tool.
- Hole saw arbors EDP 29033 and EDP 29034 are supplied with the bi-metal pilot drill EDP 29040 and an ejection spring.
- Hole saw arbors EDP 29036 are supplied with the bi-metal pilot drill EDP 29039 and an ejection spring.

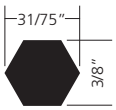
d_2 [Inches]	d_2 [mm]	Thread	Shank type	Suitable for hole saw diameters [Inches]	EDP number	
3/8	9.53	1/2"-20	hexagonal	9/16 to 1-3/16	29033	1
	9.53	5/8"-18	hexagonal	1-1/4 to 6	29034	1
1/4	6.35	1/2"-20	round	9/16 to 1-3/16	29036	1

Shank shapes

The adjacent tables provide information on the arbor shapes and dimensions for the hole saw arbors and pilot drills. The matching hole saws and hole saw arbors are indicated.

Shank dimensions [mm]

Hexagonal



Round

PFERD hole saw arbor EDP	Shank dia. [Inches]	Shank dia. [mm]	Shank shape	for PFERD hole saw dia. [Inches]
29033	3/8	9.53	⬢	9/16 to 1-3/16
29034	3/8	9.53	⬢	1-1/4 to 6
29036	1/4	6.35	◢	9/16 to 1-3/16

PFERD pilot drill EDP	Shank dia. [Inches]	Shank dia. [mm]	Shank shape	For PFERD hole saw arbors
29040	1/4	6.35	◢	EDP 29033, EDP 29034
29039	1/4	6.35	◢	EDP 29036

Ejection spring

All hole saw arbors are delivered with an ejection spring for better ejection of the sawn cut material.

Before using the hole saw, this ejection spring can be installed/removed without additional tools if required. Screw the ejection spring onto the drill from the side with the smaller diameter up to its limit. It is also possible to use the ejection spring with the adapter and washer (see diagram).

Bi-metal hole saw | Ejection spring | Washer | Adapter | Hole saw arbor

Arbor extension for hole saws

The bi-metal hole saw arbors EDP 29033 and EDP 29034 can be extended using this arbor extension.

Advantages:
- Suitable for work on hard-to-reach components.
- Particularly suitable for work on hollow walls.
- Deep holes can be accessed easily.
- Achieves the required distance between the power tool and the work area.
- Avoids damage to the workpiece and machine.
- Dust is not drawn into the power tool during sawing.

Hexagon socket d_1 [Inches]	Hexagon socket d_1 [mm]	l_1 [Inches]	l_1 [mm]	Shank type	Width across flats (AF) d_2 [Inches]	Width across flats (AF) d_2 [mm]	Suitable for arbors	EDP number	
3/8	9.53	12	300	hexagonal	7/16	11	EDP 29033, 29034	29071	1

Repair set for hole saw arbors

With the repair set for hole saw arbors, the most common parts can be replaced in case of loss or damage.

Contents:
- 2 ejection springs
- 2 hexagon socket head screws
- 1 hexagon socket wrench

EDP number	
29072	1

LSA adapter

1-1/4" to 1-1/2" diameter hole saws can be used with the adapter, a washer and the hole saw arbors EDP 29033 and EDP 29036.

Suitable for hole saw diameters [Inches]	Suitable for arbors	EDP number	
1-1/4 – 1-1/2	EDP 29033, EDP 29036	29070	1

Quality tools from a single source

Catalogue section 1

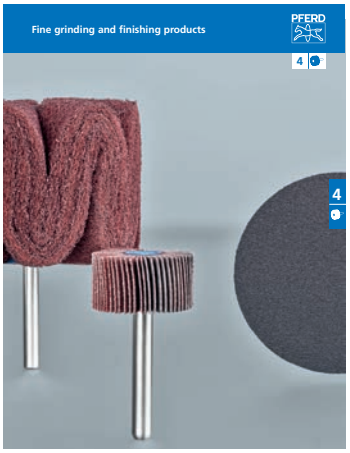
Files

Catalogue section 2

Carbide burs and bi-metal hole saws

Catalogue section 3

Mounted points, cones and plugs, bench grinding wheels



Catalogue section 4

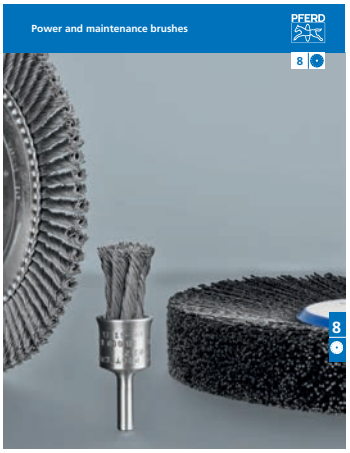
Fine grinding and polishing tools

Catalogue section 6

Cut-off wheels, flap discs and grinding wheels

Catalogue section 7

Cut-off wheels for stationary applications



Catalogue section 8

Power and maintenance brushes

Catalogue section 9

Power tools

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