



TUNGSTEN CARBIDE BURRS

Recommendations for use

Do

- ✓ Always operate the burr within the recommended speed range (a "recommended Start Point" is given overleaf for guidance)
- ✓ Select the appropriate shape, diameter and cut style for the application
- ✓ Ensure the appropriate grinder is used and that it is regularly maintained
- ✓ Fix the maximum length of burr in the collet (*recommended max 10mm overhang*). See speed chart recommendations for extra long burrs
- ✓ Check that the burr is running true in the grinder before use
- ✓ Securely fix workpiece and hold the grinder firmly
- ✓ Use a smooth cutting action with constant movement in both directions. Use light pressure, letting the burr do the work
- ✓ For best finish, always end on a reverse stroke

Don't

- ✗ Run burr above the Maximum Operating Speed
- ✗ Run burr too slowly (*refer to recommended speed guide*)
- ✗ Allow burr to be exposed to excessive mechanical or thermal shock
- ✗ Sink the burr to more than one-third of its periphery
- ✗ Jam the burr into grooves, crevices, and cavities
- ✗ Allow burr to become too hot, causing braze to weaken (*applies to burrs where head diameter is greater than shank diameter*)

Always Wear Appropriate Safety Gear



For more detailed information refer to the ATI Garryson catalog

phone: (800) 404-5364 fax: (800) 404-5374

www.atigarryson.com

© ATI Engineered Products - Garryson 2009