

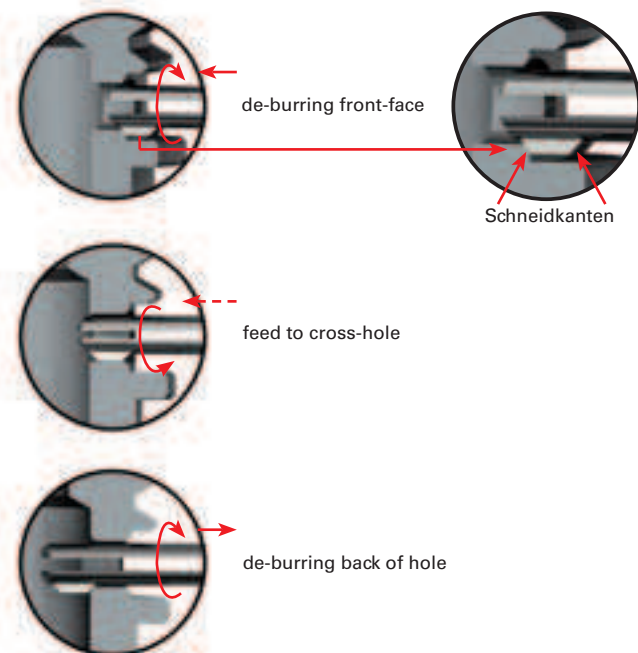
De-burring fork EW 100 G

At EMO 2003 Guhring presented their new solid carbide de-burring tools for internal and external de-burring operations. The de-burring fork EW 100 G has now become firmly established as a standard tool!

Advantages

- cost saving. The standard tool offers outstanding price advantages in comparison with special tooling.
- universal tooling for milling, turning and robotic applications. The range of 0.25 mm enables the application of our de-burring fork in holes with large tolerances. Reducing set-up time and cost!
- increased production. De-burring fork EW 100 G de-burrs automatically with one set-up and short cycle times. Expensive and extensive manual operations are no longer required.

Operation



Step by step:

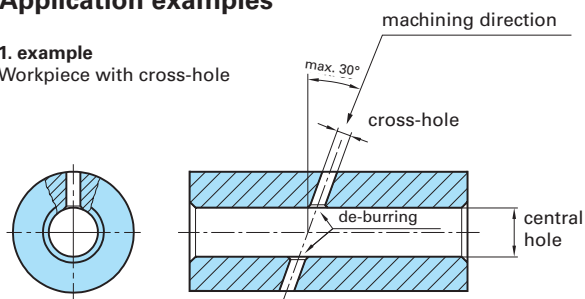
The automatically internal and external de-burring with de-burring fork EW 100 G is an easy and cost saving alternative to common, extensive manual operations. Just one tool is required for all machining steps.

Ø range (mm)	Vc m/min	fu (mm)
< Ø 4	8 - 10	0.1 - 0.2
Ø 4 - < Ø 6	10 - 14	0.1 - 0.2
6 - Ø 8	14 - 20	0.1 - 0.2

Application examples

1. example

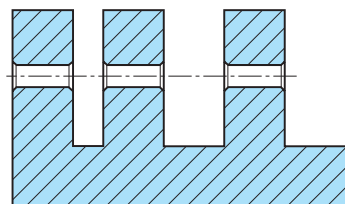
Workpiece with cross-hole



Please note when machining workpieces with cross-holes:
 – the cross-hole must be 3.5 to 4 times smaller than the central hole
 – the diameter of the cross-hole must be 40% larger than the cutting length l_6

2. example

Workpiece with multi-interrupted cut



Universal application:

The new ex-stock de-burring fork machines workpieces with one cross-hole as well as workpieces with multi-interrupted cut and produces high quality de-burred faces and ends of the hole.

Important:

Please note, that the cutting parameters are recommendations. They can be adapted to higher and lower cutting parameters.