

Solid carbide de-burring spiral EW 100 S

For internal de-burring through the central hole, Guhring has developed the solid carbide de-burring spiral EW 100 S. The slotted tool is available as a semi-standard tool with immediate effect, i. e. inside the diameter ranges specified in the adjacent table tools can be supplied in one-hundredth increments with the respective shank and length dimensions as well as number of cutting edges with short delivery times and at favourable prices. In addition, at any time other customer specific solutions as special tools, for example, with further reach or other shank diameters.

The principle of function of the de-burring spiral EW 100 S is based on the pre-tension of the grooved cutting portion. In the area of the cutting portion, the de-burring spiral has a fractionally larger diameter than the bore to be machined. Through the run-on, the grooved cutting portion is pressed together on entry into the hole to be machined and thereby pre-tensioned. The pre-tension ensures that inside the bore and especially in the area of the cross-hole to be de-burred there is a perfect fit of the cutting spiral at the wall of the bore or the edges of the cross-hole respectively. The burr

in the cross-hole is subsequently accurately and cleanly peeled off at the root. Thereby very small chips are created that can be evacuated problem-free from the hole.

Pre-requisite for the development of the de-burring spiral EW 100 S was a carbide as tool material that possesses an accordingly low rigidity and permits the necessary deformation in the cutting edge area. Thanks to Guhring's carbide expertise in development and production, then a carbide with such special attributes is available.

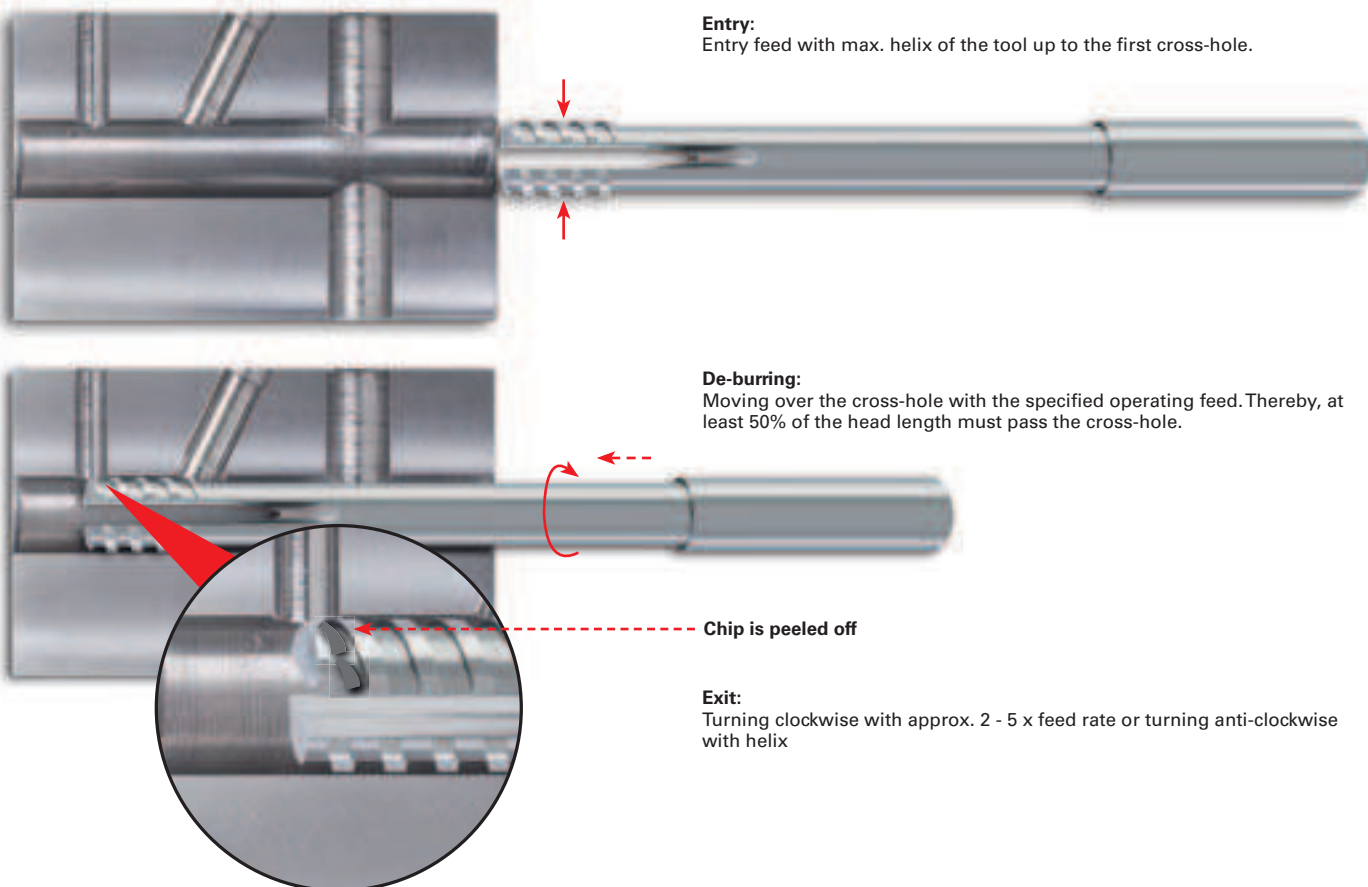
Cutting parameters de-burring spiral

Ø range (mm)	Vc m/min	fu (mm)
< Ø 8	15 - 25	0.2 - 0.3
≥ Ø 8	15 - 25	0.4 - 0.8

Important:

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

Die Funktionsweise



Entry:

Entry feed with max. helix of the tool up to the first cross-hole.

De-burring:

Moving over the cross-hole with the specified operating feed. Thereby, at least 50% of the head length must pass the cross-hole.

Chip is peeled off

Exit:

Turning clockwise with approx. 2 - 5 x feed rate or turning anti-clockwise with helix