

| S | Order No | Code                                                 | d1h9 | d2h6 | d3   | l1  | l3   |
|---|----------|------------------------------------------------------|------|------|------|-----|------|
|   | 66100    | DBRA.2.0080.0600.R0040.0050.0048.0000.00.S03B1A01.01 | 0,8  | 3    | 0,48 | 60  | 5    |
|   | 66102    | DBRA.2.0130.0600.R0065.0080.0078.0000.00.S03B1A01.01 | 1,3  | 3    | 0,78 | 60  | 8    |
|   | 66104    | DBRA.2.0180.0600.R0090.0100.0110.0000.00.S03B1A01.01 | 1,8  | 3    | 1,1  | 60  | 10   |
|   | 66106    | DBRA.2.0230.0750.R0115.0125.0140.0000.00.S03B1A01.01 | 2,3  | 3    | 1,4  | 75  | 12,5 |
|   | 66108    | DBRA.2.0280.0750.R0140.0150.0170.0000.00.S04B1A01.01 | 2,8  | 4    | 1,7  | 75  | 15   |
|   | 66110    | DBRA.2.0330.0750.R0165.0175.0200.0000.00.S04B1A01.01 | 3,3  | 4    | 2    | 75  | 17,5 |
|   | 66112    | DBRA.2.0380.0750.R0190.0200.0240.0000.00.S04B1A01.01 | 3,8  | 4    | 2,4  | 75  | 20   |
|   | 66114    | DBRA.2.0480.0750.R0240.0250.0300.0000.00.S06B1A01.01 | 4,8  | 6    | 3    | 75  | 25   |
|   | 66116    | DBRA.2.0580.0750.R0290.0300.0350.0000.00.S06B1A01.01 | 5,8  | 6    | 3,5  | 75  | 30   |
|   | 66118    | DBRA.2.0780.1000.R0390.0400.0470.0000.00.S08B1A01.01 | 7,8  | 8    | 4,7  | 100 | 40   |
|   | 66120    | DBRA.2.0980.1200.R0490.0500.0590.0000.00.S10B1A01.01 | 9,8  | 10   | 5,9  | 120 | 50   |

## Cutting Parameters

| Material             | Deburring |  |
|----------------------|-----------|--|
|                      | Vc (m/dk) |  |
| Unalloyed Steel      | 70-130    |  |
| Steel                | 70-120    |  |
| Reclamation steel    | 70-110    |  |
| Cold Work Tool Steel | 60-100    |  |
| Hot Work Tool Steel  | 60-100    |  |
| AISI 304 - 416 - 420 | 50-80     |  |
| AISI 316 - 440       | 50-80     |  |
| 17-4 PH 15-5 PH      | 50-70     |  |
| Chrome-Cobalt alloy  | 50-70     |  |
| Duplex F51           | 70-90     |  |
| Super Duplex F55     | 70-90     |  |
| Gray cast            | 80-130    |  |
| Alloyed cast         | 80-120    |  |
| Precision cast       | 80-120    |  |
| HRSA inconel 718     | 60-80     |  |
| Titanium             | 80-100    |  |
| Titanium alloys      | 80-100    |  |
| HRSA                 | 60-80     |  |

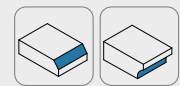
## Feed Per Tooth (mm/tooth)

| Ø (d1h6) | ap=3xØ    |
|----------|-----------|
| 0,8      | 0,04-0,08 |
| 1,3      | 0,05-0,08 |
| 1,8      | 0,06-0,09 |
| 2,3      | 0,09-0,1  |
| 2,8      | 0,1-0,15  |
| 3,3      | 0,15-0,18 |
| 3,8      | 0,15-0,19 |
| 4,8      | 0,15-0,20 |
| 5,8      | 0,16-0,21 |
| 7,8      | 0,17-0,22 |
| 9,8      | 0,18-0,23 |

ECO<sup>+</sup>PLUS

# DBRA

Deburring



|                        |   |
|------------------------|---|
| Steel                  | ● |
| Stainless Steel        | ● |
| Hardened Steel ≤54 HRC | ● |
| Hardened Steel >54 HRC | ● |
| Cast Iron              | ● |
| Graphite               | ● |
| Non Ferrous Material   | ● |
| HRSA                   | ● |
| Titanium               | ● |

● Recommended ● Acceptable ○ Not Recommended

\*Marked products can be delivered quickly from stock.

DBRA Eco-Plus