

## **Tungsten carbide burr pointed tree SPG dia. 12x25 mm shank dia. 6 mm Z3P universal medium cross cut**



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Cut 3 PLUS is cross cut and especially well-suited to machining of cast iron, steel, stainless steel (INOX), nickel-based alloys and titanium alloys. It is characterized by its high stock removal rate.

Tungsten carbide burrs for general applications 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.

Pointed tree-shaped burr according to DIN 8032 with cut conforming to DIN 8033, flattened tip.

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## Technical information

Cut	3 PLUS
Dia. external	12 mm
Dia. shank	6 mm
Length, cut	25 mm
Length, total	65 mm
RPM, grey cast iron, white cast iron	12.000 - 16.000 RPM
RPM, hardened, heat-treated steels over 1,200 N/mm <sup>2</sup>	7.000 - 9.000 RPM
RPM, high-temperature-resistant materials	7.000 - 12.000 RPM
RPM, rust and acid-resistant steels	7.000 - 8.000 RPM
RPM, steels up to 1,200 N/mm <sup>2</sup>	12.000 - 16.000 RPM

## Advantages

- ✔ Good stock removal rate through optimum matching of tungsten carbide, geometry, cut and available coating.
- ✔ Long tool life.
- ✔ The highly accurate concentricity enables impactfree working without creating chatter marks. This considerably reduces wear on the tool and tool drive.
- ✔ High surface quality.

## Recommendations for use

- ✔ If the smallest area of the burr diameter is being used, the recommended rotational speed can be increased accordingly.
  - ✔ To ensure costeffective use of burrs, use a higher rotational speed and cutting speed. Use burrs with a shank diameter of 6 mm with drives with a power output from 300 watts.
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## Materials that can be worked

- ✓ Annealed cast iron
  - ✓ Black annealed cast iron (GTS, GJMB)
  - ✓ Brass
  - ✓ Bronze
  - ✓ Case-hardened steels
  - ✓ Cast iron
  - ✓ Cast steel
  - ✓ Cobalt-based alloys
  - ✓ Grey/nodular cast iron (GG/GJL, GGG/GJS)
  - ✓ Hard aluminium alloys
  - ✓ Hardened, heat-treated steels over 1.200 N/mm<sup>2</sup> (< 38 HRC)
  - ✓ High-temperature-resistant materials
  - ✓ Nickel-based alloys (e.g. Inconell and Hastelloy)
  - ✓ Stainless steel (INOX)
  - ✓ Steel
  - ✓ Steel, cast steel
  - ✓ Steels over 700 N/mm<sup>2</sup> (> 220 HB)
  - ✓ Steels up to 1,200 N/mm<sup>2</sup> (< 38 HRC)
  - ✓ Steels up to 700 N/mm<sup>2</sup> (< 220 HB)
  - ✓ Tool steels
  - ✓ White annealed cast iron (GTW, GJMW)
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## Applications

- ✓ Cutting out holes
  - ✓ Deburring
  - ✓ Leveling
  - ✓ Milling
  - ✓ Milling out
  - ✓ Surface work
  - ✓ Work on weld seams
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## Drive types

- ✓ Automated centres
  - ✓ Drive spindle
  - ✓ Flexible shaft drive
  - ✓ Straight grinder
  - ✓ Tool machine
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