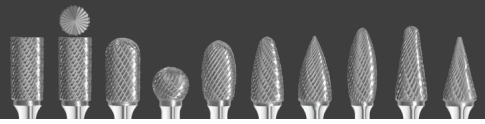
ROTARY BURR - IMPERIAL



FULLERTON®

SPEEDS / FEEDS

Carbide grinding tools should be used in a similar manner as mounted grinding wheels of the same diameters. For speed data, you may refer to any competent grinding wheel manufacturer's speed and feed chart. The following are some additional tips for using carbide grinding tools.

- Use same speed for mounted grinding wheels or points of same size.
- Reduce or eliminate feed marks by reducing feed.
- Heavily built spindles recommended in order to stand up under extra load, usually needed when using carbide grinding tools.
- Eliminate chatter with a rigid setup and ball bearing spindles. If chatter persists, reduce speed and increase feed or shorten the cutting surface of the carbide tool.
- The carbide grinding tool should be chucked true as excessive runout will cause vibrations rendering the tool useless.

Approximate suggested speeds for: Malleable Iron • Steel Welds • Cast Iron • Tool Steels • Die Steels • Non Ferrous

Cutting Diameter	Coarse	Standard	Fine	Cutting Diameter	Coarse	Standard	Fine
1/16"	65,000	50,000	30,000	7/16"	27,000	17,000	10,500
3/32"	55,000	40,000	25,000	1/2"	25,000	16,000	10,000
1/8"	45,000	35,000	20,000	5/8"	23,000*	15,000	9,500
3/16"	39,000	25,000	16,000	3/4"	20,000*	14,000	9,000
1/4"	35,000	22,000	14,000	7/8"	19,000*	13,000	8,500
5/16"	32,000	20,000	12,000	1"	18,000*	12,000	8,000
3/8"	29,000	18,000	11,000	-	-	-	-

* Maximum speeds recommended on burrs with 1/4" diameter shanks.

Approximate suggested speeds for: Stainless Steels

Cutting Diameter	Coarse	Standard	Fine	Cutting Diameter	Coarse	Standard	Fine
1/16"	98,000	75,000	45,000	7/16"	41,000	26,000	15,800
3/32"	83,000	60,000	38,000	1/2"	38,000	24,000	15,000
1/8"	68,000	53,000	30,000	5/8"	35,000**	23,000	14,300
3/16"	59,000	38,000	24,000	3/4"	30,000**	21,000	13,500
1/4"	53,000	33,000	21,000	7/8"	29,000**	20,000	12,700
5/16"	48,000	30,000	18,000	1"	27,000**	18,000	12,000
3/8"	44,000	27,000	17,000	-	-	-	-

**For maximum safety, 5/16" diameter shanks on 5/8" and 3/4" diameter files is recommended for speeds above 15,000 R.P.M. For maximum safety, 3/8" diameter shanks on 7/8" and 1" diameter files if speeds above 10,000 R.P.M. are being applied. DIAMOND CUT FILES: Reduce speed by 1/3 to 1/2 corresponding table and cuts shown. IMPORTANT: Recommended speeds apply only if file is chucked to full length of shank applied.

IPT (in/tooth)