

# Manual for Tungsten Carbide Burrs

Shank=1/4"(6.35mm) Head Dia.≤1/2", Max Rotation Speed:60000 RPM

Shank=1/8"(3.00mm) Head Dia.=6.00mm, Max Rotation Speed:70000 RPM

Shank=1/8"(3.00mm) Head Dia.=3.00mm, Max Rotation Speed:140000 RPM

- Always wear ear, eye and face protection as well as protective safety gloves.
- In general, for rough work, move the burrs across the workpiece in an opposite direction to the rotation of the tool.
- Rapidly and lightly in the direction of tool rotation to achieve fine finishes or to achieve very smooth chamfers.
- Avoid impact loads, otherwise parts teeth will break off. Do not sink the burr for more than 1/3 of its periphery.
- Soft materials, such as aluminum, use a grinding oil to reduce debris clogging. Grind glass, use water as lubricant.
- Signs of wear, such as rough running, strong vibrations and increased flying sparks, please use a new burr instead.
- Elongate holes, grip tool firmly with two hands and use a swinging motion, which prevents chatter, result in a safer cut.
- Min Clamping depth is 2/3 of the shank length, if you have to clamp less shank length, please low the rotation speed.
- Do not apply too much pressure, multiple light passes are better than a single deep one. Let the speed do the work. Smaller burrs require faster speeds.
- In exceptional cases, it is possible to work at less than 3000 RPM. This is preferable for stationary use or when countersinking with 360°

**use of the burr surface.**

- **As a rule, the bur must remain in contact with the workpiece as long as the machine is running. Failure to observe this procedure may result in shank bending and hence an increased risk of accidents.**
- **If pronounced discoloration can be seen in the transition between the toothed section and the shank, if the toothed section detaches from the shank, please reduce the contact pressure and surface contact angle.**
- **Power recommendation for tool drives: -shank diameter of 1/8": 75 to 300 watts -Shank diameter of 1/4": from 300 watts, When using burrs with coarse cuts, even higher tool drive outputs above 500 watts are advantageous.**
- **Materials Applications: Hard Wood, Balsa, Wax, Soapstone, Slate, Marble, Granite, Concrete, Steel, Hardened Steel, Weld-Seam, Stainless Steel, Brass, Copper, Bronze, Aluminum, Cast Iron, Cobalt, Nickel, Titanium, Zinc, Plastic, Earthenware, Terracotta, Porcelain, Fiberglass, Rubber, Fiber-Reinforced Plastics and so on.**

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