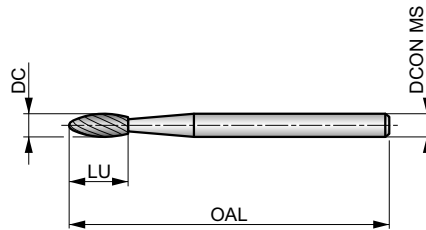


# P515



## Rotary Burr - Flame, Shape H

AS single cut flute style with light left-hand cross cut for round edge contouring and welding preparation. Solid carbide shank for rigidity. First choice for superalloys.



HM	H	Bright
AS	DORMER	



Workpiece material group suitability. Recommended operating speed (RPM) on page 6.

M3.1	M3.2	M3.3	M4.1	M4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
☑	☑	☑	☑	☑	■	■	■	■	■	■	■	■	■

DCON MS tolerance h6.

Products from this series are also available in set. Please see P880.

Product	DC [mm]	DCON MS [mm]	LU [mm]	OAL [mm]
P5153.0X3.0	3.00	3.00	6.00	38.0

## ROTARY BURRS – ICONS OVERVIEW














### General Icons

	Primary use
	Possible use

### Material Code (BMC)

<b>HM</b>	Hard Material (Solid Carbide)
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### Burr Shape

<b>A</b> 	Cylinder Shape without endcut	<b>F</b> 	Ball Nosed Tree Shape	<b>L</b> 	Ball Nosed Cone Shape
<b>B</b> 	Cylinder Shape with endcut	<b>G</b> 	Pointed Tree Shape	<b>M</b> 	Cone Shape
<b>C</b> 	Ball Nosed Cylinder Shape	<b>H</b> 	Flame Shape	<b>N</b> 	Inverted Cone Shape
<b>D</b> 	Ball Shape	<b>J</b> 	60° Countersink Shape		
<b>E</b> 	Oval Shape	<b>K</b> 	90° Countersink Shape		

### Burr End Shot

	Drill Point Burr End
	End Cut Burr End
	End Mill Burr End


### Coating

	Bright (uncoated)
	Titanium Aluminium Nitride Coating

## ROTARY BURRS – ICONS OVERVIEW

### Application Angle

	60° Countersink
	90° Countersink

	Drill Point 135°
	Drill Point 180°

	Spot Drill Point 150°
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### Burr Cut Flute Style (BTC)

<b>DC</b>	Double Cut Geometry
<b>ST</b>	Steel Cut Geometry
<b>VA</b>	Stainless Steel Cut Geometry





<b>AL</b>	Aluminium Cut Geometry
<b>GRP</b>	Fibreglass and Composite Materials Cut Geometry
<b>BR</b>	Bolt Removal Cut Geometry





<b>AS</b>	Superalloy Cut Geometry
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### Basic Standard Group (BSG)

	Dormer Standards
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### Operations Deburring

	Deburring - Bolt removal operation 1
	Deburring - Bolt removal operation 2
	Closed groove deburring and carving
	Composite fibre routing

	Curved surface deburring and carving
	Fillet radii deburring
	Free hand deburring and carving
	Chamfer deburring


	Inverted back deburring
	Plain surface deburring
	Shoulder deburring
	V-groove deburring

### Other Icons


	Bolt size
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## ROTARY BURRS – SURFACE AND TREATMENTS COATINGS NAVIGATOR

### Surface Treatments


<b>Bright (uncoated)</b>		Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials and maintains sharp cutting edges in abrasive materials.
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### Surface Coatings

<b>Titanium Aluminium Nitride Coating (TiAlN)</b>		Titanium Aluminium Nitride is a multi layer ceramic coating applied by PVD coating technology, which exhibits high toughness and oxidation stability. These properties make it ideal for higher speeds and feeds, while at the same time improving tool life. TiAlN is used in drilling, tapping, and milling applications and can be suitable for use when machining without coolant.
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## ROTARY BURRS – TOOL MATERIALS NAVIGATOR

### HM materials

<b>Carbide Materials (or Hard Materials)</b>		<p>A sintered powder metallurgy substrate, consisting of a metallic carbide composite with binder metal. The most central raw material is tungsten carbide (WC). Tungsten carbide contributes to the hardness of the material. Tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) complements WC and adjusts the properties to what is desired. These three materials are called cubic carbides. Cobalt (Co) acts as a binder and keeps the material together.</p> <p>Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.</p>
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## WMG (WORK MATERIAL GROUP)

ISO group	WMG (Work Material Group)	Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)					
P	P1	P1.1	Sulfurized	< 240 HB	≤ 830			
		P1.2	Free machining steel	Sulfurized and phosphorized	< 180 HB	≤ 620		
		P1.3	(carbon steels with increased machinability)	Sulfurized/phosphorized and leaded	< 180 HB	≤ 620		
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620		
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830		
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030		
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620		
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900		
		P3.3			260 – 360 HB	> 900 ≤ 1240		
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900		
P4.2		Hardened and tempered		26 – 39 HRC	> 900 ≤ 1240			
P4.3				39 – 45 HRC	> 1240 ≤ 1450			
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)	< 160 HB	≤ 520			
				160 – 220 HB	> 520 ≤ 700			
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670		
				Quenched and tempered	200 – 280 HB	> 670 ≤ 950		
				Precipitation-hardened	280 – 360 HB	> 950 ≤ 1300		
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)	< 200 HB	≤ 750			
				200 – 260 HB	> 750 ≤ 870			
				260 – 300 HB	> 870 ≤ 1040			
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel	< 300 HB	≤ 990			
				M4.2	Precipitation hardening austenitic stainless steel	300 – 380 HB	≤ 1320	
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190		
				Ferritic-pearlitic or pearlitic	180 – 240 HB	> 190 ≤ 310		
				Pearlitic	240 – 280 HB	> 310 ≤ 390		
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400		
				Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550		
				Pearlitic	200 – 240 HB	> 550 ≤ 660		
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560		
				Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680		
				Pearlitic	220 – 260 HB	> 680 ≤ 800		
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)	< 180 HB	≤ 190			
K4.2				Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)	< 240 HB	≤ 740		
K4.3		Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)	< 280 HB	> 840 ≤ 980				
			280 – 320 HB	> 980 ≤ 1130				
			320 – 360 HB	> 1130 ≤ 1280				
K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400			
			Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450			
			Pearlitic	220 – 260 HB	> 450 ≤ 500			
N	N1	N1.1	Commercially pure wrought aluminium	< 60 HB	≤ 240			
				N1.2	Wrought aluminium alloys	Half hard tempered	60 – 100 HB	> 240 ≤ 400
						Full hard tempered	100 – 150 HB	> 400 ≤ 590
	N2	N2.1	Cast aluminium alloys	< 75 HB	≤ 240			
				75 – 90 HB	> 240 ≤ 270			
				90 – 140 HB	> 270 ≤ 440			
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties	–	–			
				N3.2	Short-chip copper-alloys with good to moderate machining properties	–	–	
						N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties	–
	N4	N4.1	Thermoplastic polymers	–	–			
N4.2				Thermosetting polymers	–	–		
					N4.3	Reinforced polymers or composites	–	–
N5	N5.1	Graphite	–	–				
S	S1	S1.1	Titanium or titanium alloys	< 200 HB	≤ 660			
				200 – 280 HB	> 660 ≤ 950			
				280 – 360 HB	> 950 ≤ 1200			
	S2	S2.1	Fe-based high-temperature alloys	< 200 HB	≤ 690			
				200 – 280 HB	> 690 ≤ 970			
	S3	S3.1	Ni-based high-temperature alloys	< 280 HB	≤ 940			
				280 – 360 HB	> 940 ≤ 1200			
	S4	S4.1	Co-based high-temperature alloys	< 240 HB	≤ 800			
240 – 320 HB				> 800 ≤ 1070				
H	H1	H1.1	Chilled cast iron	< 440 HB	–			
				H2	Hardened cast iron	< 55 HRC	–	
	H3	H3.1	Hardened steel <55 HRC	> 55 HRC	–			
				H3.2	< 51 HRC	–		
	H4	H4.1	Hardened steel >55 HRC	51 – 55 HRC	–			
				H4.2	55 – 59 HRC	–		
				> 59 HRC	–			

## RECOMMENDED OPERATING SPEED (RPM)

AL

DC

ISO		RPM						
		DC [mm]						
		3	6	8	10	12	16	20
<b>P</b>	min	64 000	32 000	24 000	20 000	16 000	12 000	10 000
	max	83 000	42 000	32 000	25 000	21 000	16 000	13 000
<b>M</b>	min	45 000	23 000	17 000	14 000	12 000	9 000	7 000
	max	64 000	32 000	24 000	20 000	16 000	12 000	10 000
<b>K</b>	min	58 000	29 000	22 000	19 000	15 000	11 000	9 000
	max	77 000	39 000	29 000	23 000	20 000	15 000	12 000
<b>N</b>	min	64 000	32 000	24 000	20 000	16 000	12 000	10 000
	max	96 000	48 000	36 000	29 000	24 000	18 000	15 000
<b>S</b>	min	45 000	23 000	17 000	14 000	12 000	9 000	7 000
	max	58 000	29 000	22 000	18 000	15 000	11 000	9 000
<b>H</b>	min	51 000	26 000	20 000	16 000	13 000	10 000	8 000
	max	71 000	36 000	27 000	22 000	18 000	14 000	11 000

ST

BR

ISO		RPM				
		DC [mm]				
		3	6	8	10	12
<b>P</b>	min	100 000	65 000	60 000	55 000	35 000
	max	60 000	45 000	35 000	30 000	20 000

VA

BR

ISO		RPM				
		DC [mm]				
		3	6	8	10	12
<b>M</b>	min	100 000	65 000	60 000	55 000	35 000
	max	60 000	30 000	25 000	20 000	15 000

GRP

ISO		RPM		
		DC [mm]		
		3	6	8
<b>N4</b>	min	25 000	20 000	18 000
	max	30 000	25 000	22 000

AS

ISO		RPM
		DC [mm]
		3
<b>S</b>	min	60 000
	max	80 000