



Dr. Beier-Entgrattechnik

Special Deburring Tools

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DEBURRING PROTOCOL FOR SYSTEM HIGH SPEED DEBURRING



Company/ contact person:

Verbal description of the deburring task:

Please note:

- Please try to answer in English.
- Deburring tool is constructed mainly for inside deburring.
- Burr should be situated in the main hole.
- Cross drills/ holes should be upright/vertical (90 degree) to the main hole.
- Expected tolerance of the main drill/ hole 0, + 0,2 mm.

Questions	Answers and remarks
Component part with details of the deburring task, dimensions of the working piece (the necessary part of the drawing or sketch is needed)	
Material of the work piece	
Condition/ Status of the material within the deburring process (thermal treating, etc.)	
Inside diameter of the main drill/hole <u>and</u> inside diameter of the cross drill/ hole	
Number of cross drills/holes; if there are more than one cross drill/hole please specify the angles and distance along the main bore of the cross/drill holes to one another (if not specified in the drawing)	
Expected profile of the burr (minimum / maximum)	
Which (deburring) procedure do you apply for this deburring task at present?	
Previous/present cycle time	
Deburring tool chuck: Diameter x fit + length	

<p>Machine-Tool:</p> <ul style="list-style-type: none">- Cooling medium available? (Pressure must be constant or programmable!) If air cooling is available air pressure must be at least 10 bar)- Clockwise rotation and left-hand motion of the machine tool is requested <p>Please specify cooling media and pressure or pressure range.</p>	
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<p>Please tell us your request for the following items:</p>	
<p>Your quality demand at the edge:</p> <p>What do you expect from the shape of the edge?</p>	
<p>What is the expected surface roughness?</p>	

Thank you for these information. We will try to develop the best solution for your deburring problem!

Date/ Customer Signature