

Types of Cuts and Recommended Applications

Following are general guidelines for selecting the correct bur based upon material being machined.

Single (Standard)



A general-purpose right hand flute style is recommended when rapid stock removal and good workpiece finish are the parameters.

Fine



A general-purpose right hand flute style designed for producing higher quality finishes, when removing less stock, with more operator control.

Shear



A right hand flute style bur is recommended for rapid stock removal on softer, non-ferrous and non-metallic materials.

Double (Alternate Diamond Grind)



M.A. Ford® Carbide Burs are available in a Standard Alternate Diamond (Double Cut) and Fine Alternate Diamond style. An alternate diamond grind has left hand fluting added to standard or fine cut fluting. This additional fluting helps break up chips when working steel weldments or other materials that can produce small or sliver-type chips. A slight left hand cutting action typically provides the operator more control of the bur and grinder.

Optional Diamond Grind Available Upon Request



Diamond grind is left hand fluting added to single or fine cut burs. Like an alternate diamond grind, a diamond grind will also break up bothersome chips into an almost granular powder. More precise deburring is possible because of a more balanced left and right hand cutting action. The most rapid penetration achieved with a carbide bur is with diamond grind. A diamond grind will, however, reduce tool life. Recommended for ferrous and stainless steel materials.

Bur Application Chart				
Material	Type of Cut			
	Single	Double	Fine	Shear
Steel, Carbon & Alloys	x	x		
Steel, Nickel Chrome	x	x		
Steel, Stainless	x	x	x	
Steel, Weldments	x	x		
Cast Iron	x			
Titanium	x	x		
Steel, 40-60 Rc	x	x	x	
Wood				x
Aluminum	x	x		x
Brass, Bronze, Copper	x	x		
Carbon	x			
Fiberglass	x			
Hard Rubber	x			x
Magnesium				x
Masonite	x			x
Plastics	x			x
Zinc				x

All burs available with coating.

See page 485 for our coating options.

**Contact M.A. Ford® at
800-553-8024 / 563-391-6220
for all your application questions.**

Specify type of cut when ordering.

Order by Tool No. / EDP or SCTI No.

SCTI No. - D Double Cut

SCTI No. - F Fine Cut

Example:

SA-41.....Single Cut

SA-41-D.....Double Cut

SA-41-F.....Fine Cut