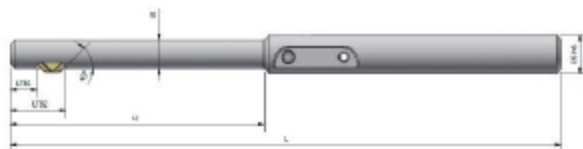
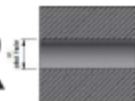


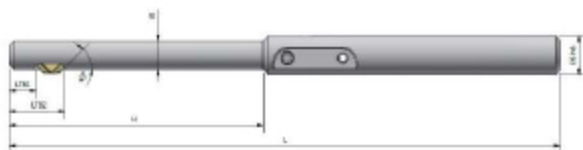
UBURR



UBURR Houder - (SKU TOOLHOLDER)

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	SKU BLADE	ØDS h6	LTB1 ⁽²⁾	LTB2 ⁽²⁾	H	L
2.50-3.00	UB1025	UB2020 ⁽¹⁾	8	N/A	7	29	69
3.00-3.50	UB1030	UB2030	8	4	10	29	85
3.50-4.00	UB1035	UB2030	8	4	10	29	85
4.00-4.50	UB1040	UB2030	8	4	10	29	85
4.50-5.00	UB1045	UB2030	8	4	10	29	85
5.00-5.50	UB1050	UB2060	8	4	12	53	115
5.50-6.00	UB1055	UB2060	8	4	12	53	115
6.00-6.50	UB1060	UB2060	8	4	12	53	115
6.50-7.00	UB1065	UB2060	8	4	12	53	115
7.00-7.50	UB1070	UB2060	8	4	12	53	115
7.50-8.00	UB1075	UB2060	8	4	12	53	115
8.00-8.50	UB1080	UB2060	10	4	12	53	115
8.50-9.00	UB1085	UB2060	10	4	12	53	115
9.00-9.50	UB1090	UB2060	10	4	12	53	115
9.50-10.00	UB1095	UB2060	10	4	12	53	115
10.00-10.50	UB1100	UB2060	10	4	12	80	125
10.50-11.00	UB1105	UB2060	10	4	12	80	125
11.00-11.50	UB1110	UB2060	10	4	12	80	125
11.50-12.00	UB1115	UB2060	12	4	12	80	125
12.00-12.50	UB1120	UB2060	12	4	12	80	125
12.50-13.00	UB1125	UB2060	12	4	12	80	125
13.00-13.50	UB1130	UB2060	12	4	12	80	125
13.50-14.00	UB1135	UB2060	12	4	12	80	125
14.00-14.50	UB1140	UB2060	12	4	12	80	125
14.50-15.00	UB1145	UB2060	12	4	12	80	125
15.00-15.50	UB1150	UB2060	12	4	12	80	125
15.50-16.00	UB1155	UB2060	12	4	12	80	125
16.00-16.50	UB1160	UB2060	16	4	12	80	125
16.50-17.00	UB1165	UB2060	16	4	12	80	125
17.00-17.50	UB1170	UB2060	16	4	12	80	125
17.50-18.00	UB1175	UB2060	16	4	12	80	125
18.00-18.50	UB1180	UB2060	16	4	12	80	125
18.50-19.00	UB1185	UB2060	16	4	12	80	125
19.00-19.50	UB1190	UB2060	16	4	12	80	125
19.50-20.00	UB1195	UB2060	20	4	12	80	125
20.00-20.50	UB1200	UB2060	20	4	12	80	125
20.50-21.00	UB1205	UB2060	20	4	12	80	125
21.00-21.50	UB1210	UB2060	20	4	12	80	125

UBURR



UBURR Houder - (SKU TOOLHOLDER)

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	SKU BLADE	ØDS h6	LTB1 ⁽¹⁾	LTB2 ⁽²⁾	H	L
21.50-22.00	UB1215	UB2060	20	4	12	80	125
22.00-22.50	UB1220	UB2060	20	4	12	80	125
22.50-23.00	UB1225	UB2060	20	4	12	80	125
23.00-23.50	UB1230	UB2060	20	4	12	80	125
23.50-24.00	UB1235	UB2060	20	4	12	80	125
24.00-24.50	UB1240	UB2060	20	4	12	80	125
24.50-25.00	UB1245	UB2060	20	4	12	80	125
25.00-25.50	UB1250	UB2060	20	4	12	80	125

(1) The UB2020 blade is designed only for back deburring.

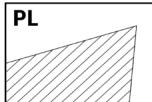
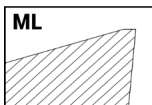
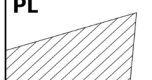
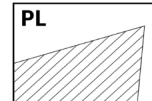
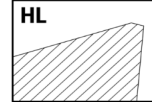
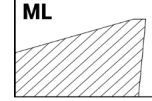
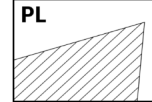
(2) LTB (Length to Blade)

UX Tool-holder Spare Parts:

-  Hex L-Key - SP0105 0.050" 1 + 1/16 / 1 + 9/16
-  Blade Clamping Screw - UB0021 M2.5 X 0.35

SIZE 2.5 ⁽¹⁾ BLADE for pilot hole Ø2.5 (0.098") ≤ d < Ø3.0 (0.118")		
SKU BLADE	DESIGNATION	DESCRIPTION
UB2020 ⁽¹⁾	UB-TSB-2.5-PL	HSS Blade size 2.5 without coating and type P chip-former
UB2022 ⁽¹⁾	UB-TSB-2.5-PL-NCT	HSS blade size 2.5 with TiAlN coating and type P chip-former
SIZE 3 BLADE for pilot hole Ø3.0 (0.118") < d < Ø5.0 (0.197")		
SKU BLADE	DESIGNATION	DESCRIPTION
UB2030	UB-TSB-3-PL	HSS blade size 3 without coating and type P chip-former
UB2032	UB-TSB-3-PL-NCT	HSS blade size 3 with TiAlN coating and type P chip-former
UB2034	UB-TSB-3-ML-NCT	HSS blade size 3 with TiAlN coating and type M chip-former
UB2036	UB-SCB-3-PL-NCT	Carbide blade size 3 with TiAlN coating and type P chip-former
UB2038	UB-SCB-3-ML-NCT	Carbide blade size 3 with TiAlN coating and type M chip-former
SIZE 5 BLADE for pilot hole d > Ø5.0 (0.197")		
SKU BLADE	DESIGNATION	DESCRIPTION
UB2060	UB-TSB-5-PL	HSS blade size 5 without coating and type P chip-former
UB2062	UB-TSB-5-PL-NCT	HSS blade size 5 with TiAlN coating and type P chip-former
UB2063	UB-TSB-5-ML-NCT	HSS blade size 5 with TiAlN coating and type M chip-former
UB2067	UB-SCB-5-PL-NCT	Carbide blade size 5 with TiAlN coating and type P chip-former
UB2069	UB-SCB-5-ML-NCT	Carbide blade size 5 with TiAlN coating and type M chip-former

⁽¹⁾ The UB2020 blade is designed only for back deburring

	HSS BLADE	CARBIDE BLADE	HSS or CARBIDE	HSS or CARBIDE		
	Vc cutting speed ⁽¹⁾	Vc cutting speed ⁽¹⁾	Vc cutting speed ⁽¹⁾	fr cutting speed ⁽¹⁾		
ISO	UNCOATED m/min. sfm	COATED m/min. sfm	COATED m/min. sfm	COATED/ UNCOATED m/min. ipr	RECOMMENDED CHIP-FORMER	COOLANT
P	25-45 80-150	45-65 100-165	60-120 200-390	0.08 - 0.20/ 0.003 - 0.008		AIR / WET
	20-45 80-150	35-65 115-165	50-120 165-395	0.08 - 0.20/ 0.003 - 0.008		
	20-40 65-130	35-55 115-180	50-100 165-330			
	15-35 50-115	30-50 100-165	45-90 150-295	0.08 - 0.15/ 0.003 - 0.006		
M	15-30 50-100	30-55 100-180	50-100 165-330	0.08 - 0.15/ 0.003 - 0.006		WET
K	20-35 65-115	35-55 115-180	60-120 200-395	0.08 - 0.25/ 0.003 - 0.012		AIR / WET
	30-70 100-230	40-90 130-295	50-100 165-330	0.08 - 0.20/ 0.005 - 0.008		
N	50-70 165-230	75-120 245-395	100-160 330-525	0.10 - 0.30/ 0.004 - 0.012		WET
	30-60 100-200	45-100 150-330	90-130 295-425			
	60-100 195-330	90-150 295-490	180-305 600-1000			
S	10-15 33-50	15-35 50-115	40-80 130-260	0.10 - 0.20/ 0.005 - 0.008		WET
	NOT RECOMMENDED	10-15 33-50	25-40 80-130			
	10-15 33-50	15-20 50-65	30-60 100-165			
H	NOT RECOMMENDED	10-20 10-20 30-65	30-50 100-165	0.04 - 0.06/ 0.0015 - 0.0024		AIR
		10-15 30-50	30-40 100-130			
		15-20 50-65	45-50 145-165			
		10-20 30-65	30-50 100-165			
C	NOT RECOMMENDED		90-140 295 - 460	0.05 - 0.25 / 0.002 - 0.010	 Recommended with special diamond coating or DLC	AIR/ WET
			90-350 295 - 1150			