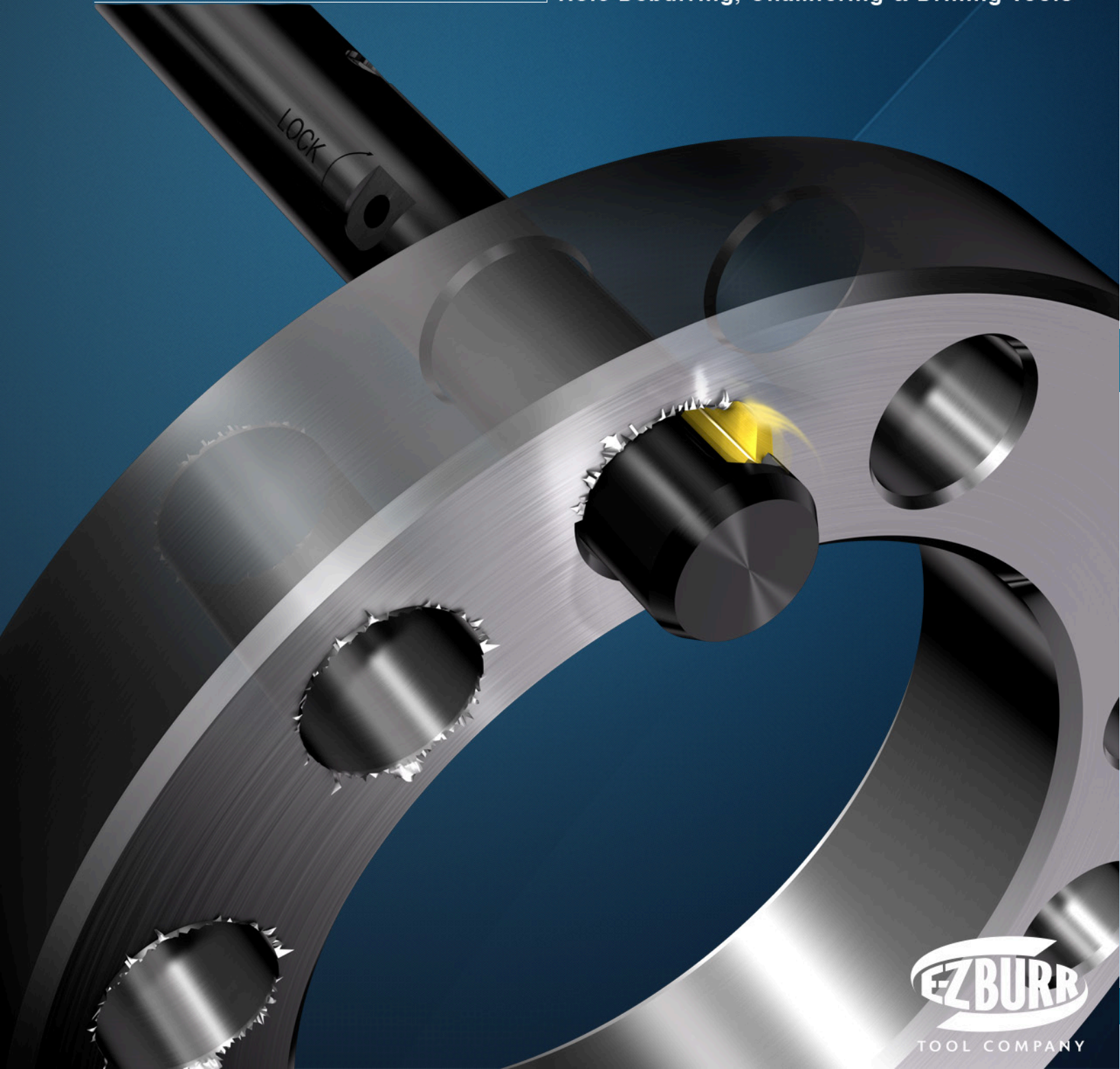


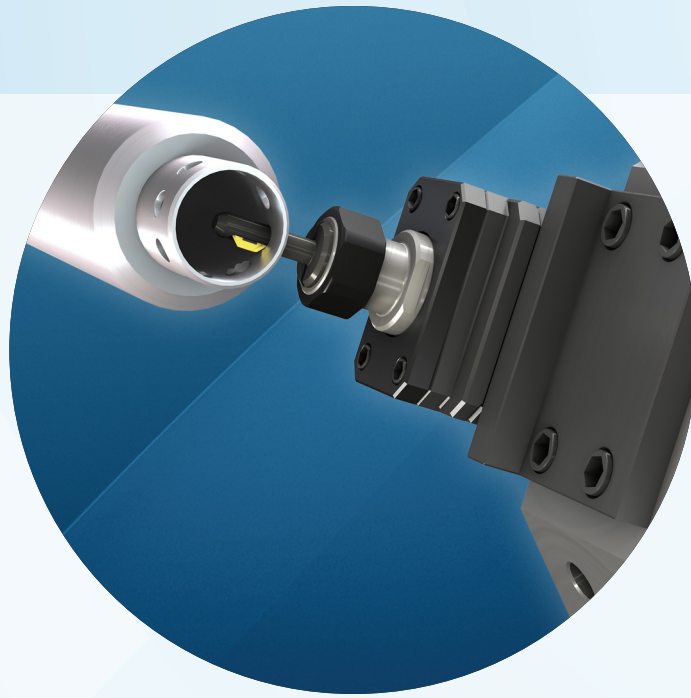
# E-Z BURR TOOL COMPANY

Hole Deburring, Chamfering & Drilling Tools



TOOL COMPANY





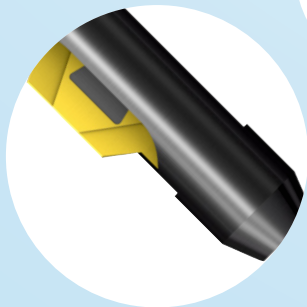
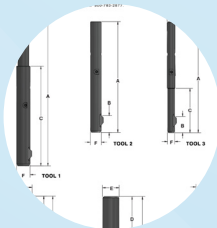
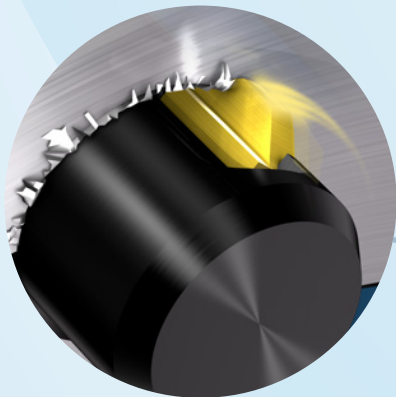
**Deburr the front and rear  
of a hole in a single pass. It's  
easy and only takes seconds.**

Easy Fast. Built to last.

EZburr.com  
800.783.2877  
41180 Joy Road Plymouth, Mi 48170

E-Z Burr Tool Company has been intensely focused on designing and manufacturing the highest quality deburring tools for over 50 years! We are located in Michigan and all of our deburring tools are 100% U.S.A. made. Over the years we've developed a line that we feel is absolutely the best in the world. As a part of our ongoing commitment to service, we've also developed a strong worldwide network of distributors and manufacturers' reps, ready to assist you in every way possible. We are confident that you will be completely satisfied with our responsiveness technical expertise and of course our deburring tools. In fact we guarantee it.

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# Introduction

## Deburring Innovation Since 1960

For more than five decades, E-Z Burr Tool Company has been building a solid reputation as an innovative manufacturer of high quality high speed steel (HSS) deburring and chamfering tools. We have expanded our line to include combination tools, industry specific tools, material specific tools, different lengths and different coatings to provide our customers with the best deburring and chamfering products on the market. From the very start, our goal has not only been to provide tools that are durable, dependable and easy to use and maintain, but also to offer them at a fair and affordable price. The fact that 95% of our customers are repeat customers is a testament that we have achieved and continue to uphold that goal.

All of our tools, starting with the original E-Z Burr deburring tool, have a patented design that enables you to deburr both the front and the rear of a hole in a single pass. Our patented locking system also allows you to change the blade or insert in seconds – without affecting the chamfer setting – while the tool is still in the machine. And, with the exception of the Micro Series, you can adjust the cutting pressure from extreme low to extreme high on all E-Z Burr Tools with a simple turn of the Allen screw on the side of the shank.

### Our line of high performance tools consist of:

**High Speed Steel** – standard sizes: .093” to 2.0” (2.38mm to 50.80mm)

**Carbide** – standard sizes: .125” to 1.00 (3.17mm to 25.40mm)

**Micro Series** – standard sizes: .040” to .092” (1.00mm to 2.33mm)

**Component Micro Series** – standard sizes: .0570” to .0920 (1.45mm – 2.34mm)

**Stubby Tool** – standard sizes: .093” to .236” (2.38mm – 3.90mm)

**BurrFree Drill** – standard sizes: .374” and up (9.5mm and up)

*We also offer custom tool and specialty tools. These are based on your specific deburring needs.*





### **In stock for immediate delivery.**

No other company anywhere offers you a greater selection of precision, in-stock HSS and carbide deburring tools. For example, while you've had to search far and wide to find a tool for a hole size smaller than .093, E-Z Burr has 16 standard sizes between .040 and .092 inches in stock. What's more, while other companies can take up to weeks to deliver, we ship our standards the very same day, or the next day.

In all, more than 150 different tool sizes are stocked for immediate delivery, including all fractional and metric sizes, designed for all types of machines and hand tools.

### **Custom orders filled fast.**

If you need a special tool, let us know. Our staff is easy to work with and takes great pride in their ability to solve problems. We'll design and build a specific tool for a specialized application. Such special orders can often be produced and delivered in as little as two weeks. Every tool we ship is designed and manufactured to extremely rigid quality standards. And our technical staff is always ready to help.



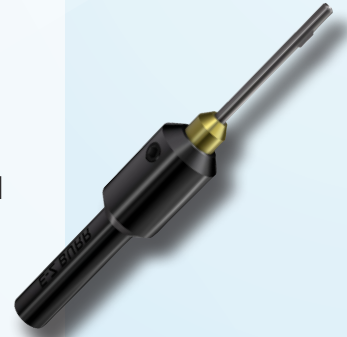


# The E-Z Burr Tool Line-Up

## Micro Series:

One millimeter. Four one-hundredths of an inch. That's how small a hole you can deburr with the E-Z Burr Micro Series, the world's smallest solid arbor style deburring tool. Economically priced, the E-Z Burr Micro Tool lets you deburr thousands of super-small holes before the cartridge needs replacing. Still more economy is provided by the two-piece construction, which lets you remove and replace the cartridge in seconds while the tool is still in the spindle. That also eliminates the need to handle and perhaps lose miniature parts.

All cartridges must be used with a cartridge holder. One size holder accommodates all cartridges



## High Speed Steel Series (HSS):

E-Z Burr Tools are the industry standard for quick, effective and consistent front and rear burr removal. They're the only deburring tools of their type that offer a flexible blade which operates independently of springs and plungers. The result is a solid shank – not hollow like the competition – and a more durable tool. Additionally, the patented E-Z Burr Tool lets you change chamfer settings and cutting blades without removal from the holder! And once you set the desired chamfer it won't change even from blade to blade. These features ensure less downtime, more production and higher profits.



## Carbide Series:

The patented E-Z Burr Carbide Tool lets you deburr and chamfer at speeds and feeds at least three times faster than regular HSS deburring tools. And the standard titanium nitrate-coated carbide insert lasts more than five times as long as HSS blades. The inserts are adjustable, replaceable and can be changed while the tool is in the machine. The E-Z Burr Carbide Series is ideal for large production runs, heavy burrs and tough materials.



## Stubby Tool:

A new industry standard for modern Swiss-style machines and live tooling, these shorter length tools are made for limited space availability with maximum flexibility and productivity in mind. The stubby series comes in both high speed steel and carbide and manufacturers can eliminate costly secondary operations by finishing parts completely in one set up.



## E-Z Burr Customs – Made for you

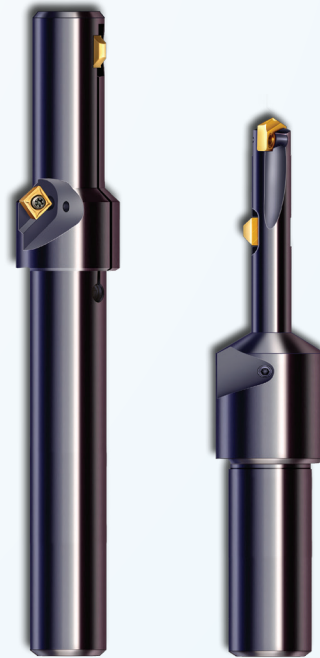
E-Z Burr is proud of our ability to produce custom deburring tools to meet even the most demanding and unique applications. Our capabilities include special lengths, diameters, pilots or shanks, flats, tangs or whistle notches. While we maintain a large inventory of standard tools for deburring holes from .040" (1.0mm) to 2.0" (50.8mm), we can produce special tools for larger holes or whatever your unique application may be. In fact, we stock a wide variety of blanks for quick turnaround on such special orders.

## Combination Tools – BurrFree Drill:

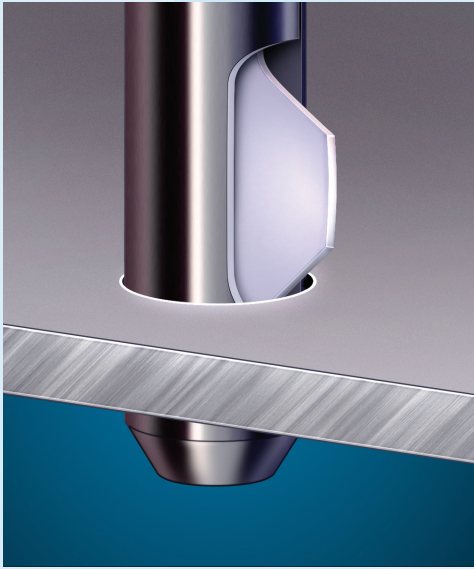
E-Z Burr has set the standard in innovating productive combination tools.

Our precision chamfer tool cuts a front chamfer or countersink on the top of the part and deburrs the backside of the hole all in one pass. And our BurrFree Drill can drill and deburr a hole in one movement. By incorporating a spade drill to the arbor of the carbide series tool, we have created the perfect one-step burr-free drill.

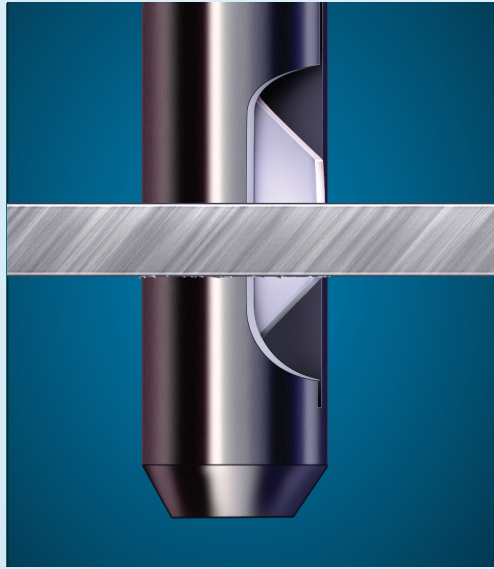
We can even combine the BurrFree Drill with the precision chamfering tool and have one tool that does three operations; drills the hole, puts a precision chamfer on the topside and deburrs the backside. All in one stroke! Now that's a practical, time and money saving concept.



# How the Tools Work



As the rotating tool is fed into the work piece, the extended blade / insert cuts and deburrs the front burr as the blade/insert is collapsing into the blade/insert slot.



When its completely collapsed, the tool continues through the hole. The top of the blade/insert has a polished crown so it does not mark the bore while being fed through.



Once the tool has cleared the back-side of the hole, the blade/insert springs back out of the arbor, the feed direction is reversed and the rear burr is cut as the tool is withdrawn

After the cutting blade has finished the operation and is completely collapsed in the bore on the return stroke, the tool may be rapid fed out of the part and begin the next hole.

## Easy to Use in All Machines

E-Z Burr Tools are easy to maintain, and set-up is quick and straight-forward. Used in metal working operation all over the world, the tools run on a variety of machines including Dial, Transfer and CNC machining centers, along with Bridgeports , drill presses and even hand drills. Because of the simples feed and retrieve action , no special skills are needed. These photos demonstrate two of the applications where E-Z Burr Tools are used.



In this CNC illustration , a round stainless steel tube with a 5/8" cross hole is being deburred on the O.D. and I.D. (top and bottom or even the front and rear side) of the hole. The customer is using a 5/8th diameter carbide tool. The carbide insert lasted over ten thousand parts before having to be changed.



This is a lower volume job being run on a Bridgeport. The 3/32" cross-holes-were breaking into the 1.0" bores and it was very difficult to removes the burrs until an E-Z Burr Tool was used. Now clean burr-free holes are achieved without any difficulty.



# Shared Product Features

All E-Z Burr product lines utilize the same exclusive E-Z Burr patents.\* That's why they share the following common features: solid arbor design, easy blade adjustment, quick blade/insert exchange and the unique spring-type blade and flex arm. These patented features not only make our products extremely durable but also insure outstanding part-to-part consistency.

\*With the exception of the Micro Series

## Solid Arbor

Unlike the hollow arbor or the tuning fork styles of some competitors, the E-Z Burr Deburring Tool has a solid arbor. This not only makes it tough and rigid, it also maximizes cutting power and lengthens the life of the tool, especially in rugged machining conditions where weaker tools might break



## Easy Adjustability



With the E-Z Burr Tool, Cutting pressure adjusts with a simple turn of the Allen screw conveniently exposed on the side of the shank.

This provides a range of cutting pressures from the extreme low to extreme high, depending on the nature of the burr size, the amount of material to be removed and the composition of the work piece.

Once the tension is set, Low-break Loctite seals the adjusting screw to maintain torque tension so part-to-part consistency is assured.

# Patented Locking System

## For Quick Blade Replacement

E-Z Burr's patented blade locking system lets you change blades in seconds, with the tool still in the machine. All it takes is a one-eighth turn.

### To Remove the HSS Blade



Unlock the blade with a simple 1/8 counterclockwise turn of the locking screw.



Once in the unlocked position the blade can be pulled up and out of the holder.

### To Replace the HSS Blade



Insert the tab at the end of the blade into the groove of the adjusting screw. Lower the slot of the blade over the lock screw.



Lock the flex arm into place with a simple 1/8 clockwise turn of the locking screw.



## And Quick Insert Replacement

The carbide system uses the same patented locking system as the HSS series, enabling you to change inserts in just seconds with the tool still in the machine. All it takes is one-eighth turn. Just follow these four steps for easy replacement.

### To Remove the Carbide Insert



Unlock the flex arm with a simple 1/8 counterclockwise turn of the locking system.



Once in the unlocked position the insert can be pulled up and out of the holder.

### To Replace the Carbide Insert

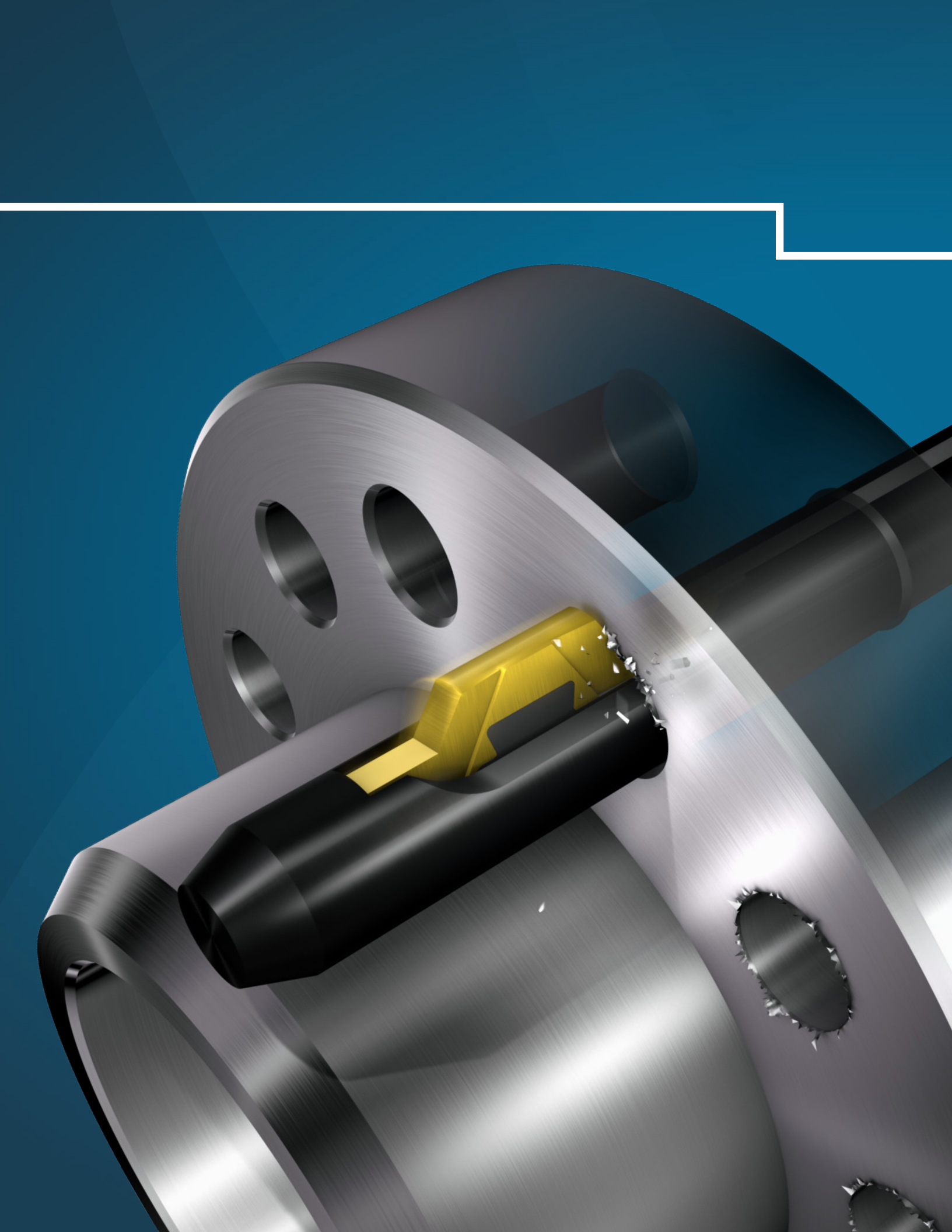


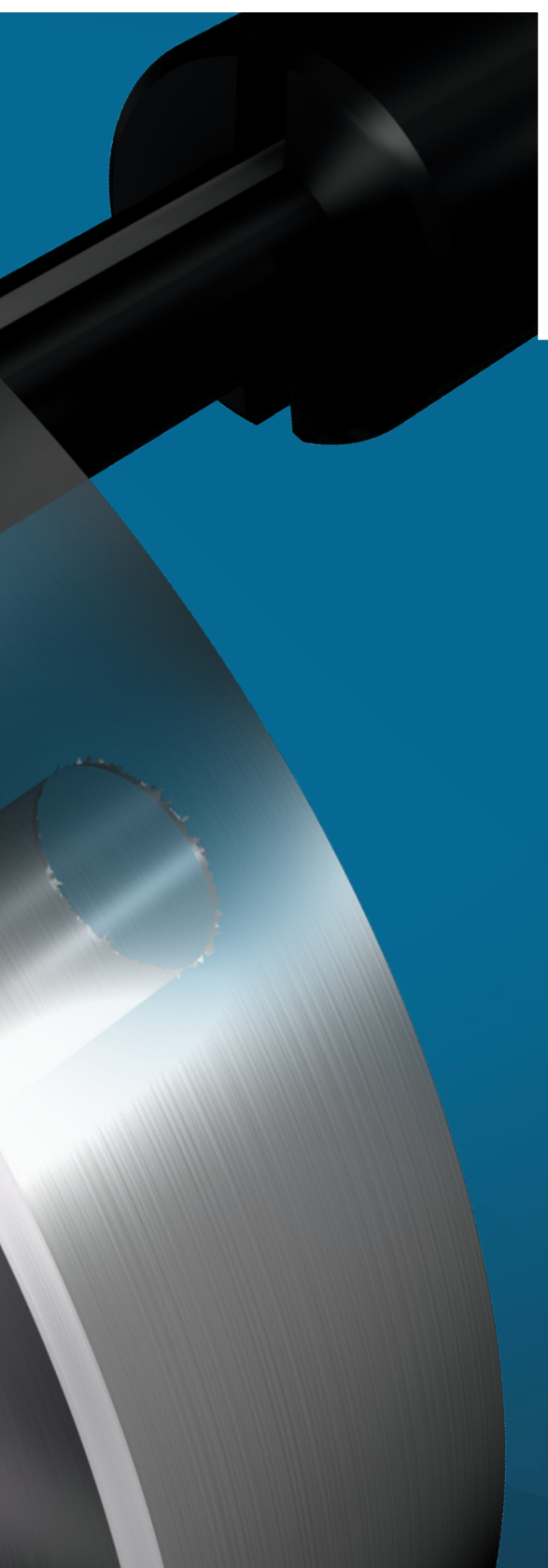
With the flex arm at its most extended position, engage the slot of the insert over the tip of the flex arm.



Carefully slide the end of the insert back into the arbor slot until the flex arm is lowered into position. Lock the flex arm back into place with a simple 1/8 clockwise turn of the locking screw.







# Tool Specifications & Ordering information

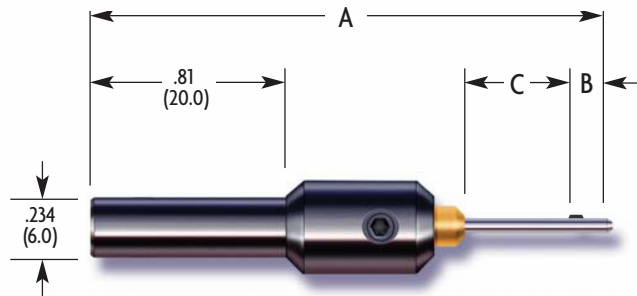
# E-Z Burr Tool Specifications: Micro Series

## E-Z Micro Series Tools

For holes .040" to .092" (1.00mm to 2.33mm).

Tool #	Hole Range	Hole Range	A	B	C
	Inches	mm			
CAR0400	.0400 - .0410	1.00 - 1.06	1.90	.15	.25
CAR0420	.0420 - .0440	1.07 - 1.13	1.90	.15	.25
CAR0450	.0450 - .0480	1.14 - 1.22	1.90	.15	.25
CAR0485	.0485 - .0510	1.23 - 1.31	1.97	.16	.31
CAR0520	.0520 - .0530	1.32 - 1.36	1.97	.16	.31
CAR0540	.0540 - .0560	1.37 - 1.44	1.97	.16	.31
CAR0570	.0570 - .0610	1.45 - 1.55	2.06	.19	.38
CAR0615	.0615 - .0650	1.56 - 1.65	2.10	.19	.41
CAR0655	.0655 - .0680	1.66 - 1.74	2.13	.19	.44
CAR0690	.0690 - .0710	1.75 - 1.82	2.21	.21	.50
CAR0720	.0720 - .0740	1.83 - 1.89	2.21	.21	.50
CAR0750	.0750 - .0770	1.90 - 1.97	2.21	.21	.50
CAR0780	.0780 - .0800	1.98 - 2.00	2.24	.24	.50
CAR0805	.0805 - .0830	2.04 - 2.10	2.24	.24	.50
CAR0840	.0840 - .0870	2.13 - 2.20	2.24	.24	.50
CAR0880	.0880 - .0920	2.23 - 2.34	2.24	.24	.50

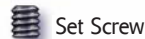
All cartridges must be used with a Cartridge Holder (part# CAR-HOLDER) featured below.



Cartridge Holder



Cartridge  
(includes blade & arbor)



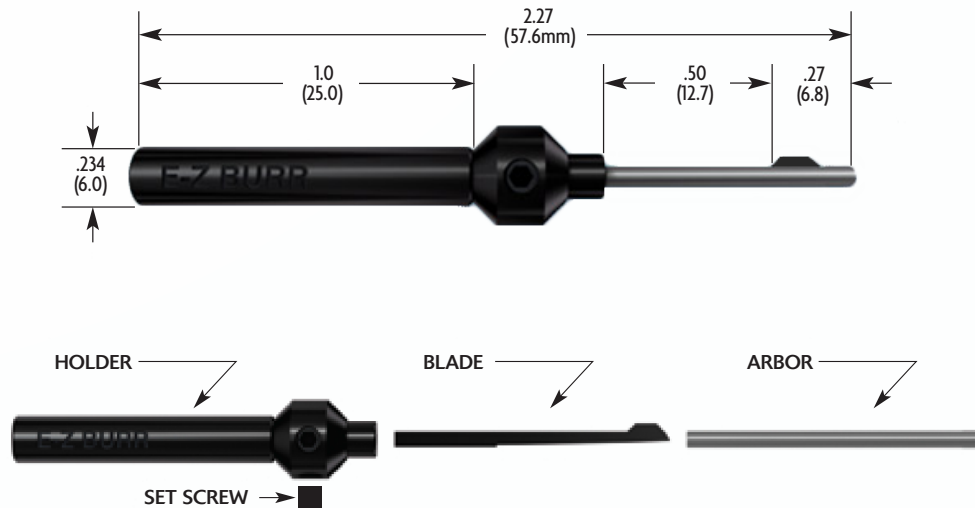
Set Screw



## Component Micro Series

For Holes .057" through .02" (1.45 mm through 2.34mm)

Tool #	Hole Range	
	Inches	mm
MS53	.0570 - .0610	1.45 - 1.55
MS52	.0615 - .0650	1.56 - 1.65
MS51	.0655 - .0685	1.66 - 1.74
MS50	.0690 - .0715	1.75 - 1.82
MS49	.0720 - .0745	1.83 - 1.89
MS48	.0750 - .0775	1.90 - 1.97
MS47	.0780 - .0800	1.98 - 2.03
MS46	.0805 - .0835	2.04 - 2.12
MS44	.0840 - .0875	2.13 - 2.22
MS43	.0880 - .0920	2.23 - 2.34



### COMPONENTS LIST/ORDERING INFORMATION

Extension Suffix	Description
H	Holder with Locking Ring - Designed for quick and simple replacement of blade and / or arbor
A	Arbor - Extremely durable / precision machined
B	Style B Blade - Deburrs both front and rear sides of the hole
R	Style R Blade - Deburrs rear side of hole only
T	Complete Tool Assembly

\*To Order: Add "-B" for "Both" front and rear hole deburring. EX: MS49-B Add "-R" for "Rear only" hole deburring. EX: MS49-R

When ordering components or replacement parts, list the micro series tool number, then the appropriate Suffix (-H, -A, -T) and blade extension (-B, -R). EX: MS49-TR.

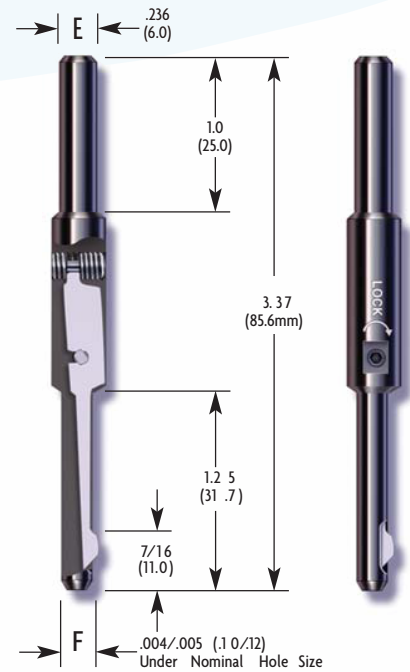
# E-Z Burr Tool Specifications – High Speed Steel Series (HSS)

## E-Z Burr Series L1A-L1B

For holes .093" through .153" (2.38mm to 3.90mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
EZL 0093	3/32	0.0937	2.38	.236	6.00	L1A
EZL 0098		0.0984	2.50	.236	6.00	L1A
EZL 0102		0.1023	2.60	.236	6.00	L1A
EZL 0106		0.1062	2.70	.236	6.00	L1A
EZL 0109	7/64	0.1093	2.77	.236	6.00	L1A
EZL 0114		0.1141	2.90	.236	6.00	L1A
EZL 0118		0.1181	3.00	.236	6.00	L1A
EZL 0122		0.1220	3.10	.236	6.00	L1B
EZL 0125	1/8	0.1250	3.17	.236	6.00	L1B
EZL 0129		0.1299	3.30	.236	6.00	L1B
EZL 0133		0.1338	3.40	.236	6.00	L1B
EZL 0137		0.1378	3.50	.236	6.00	L1B
EZL 0140	9/64	0.1406	3.57	.236	6.00	L1B
EZL 0145		0.1456	3.70	.236	6.00	L1B
EZL 0149		0.1496	3.80	.236	6.00	L1B
EZL 0153		0.1535	3.90	.236	6.00	L1B

Note: Series L1A and L1B tools have a working range of -0.0+.006 inches and -.03+.15mm.

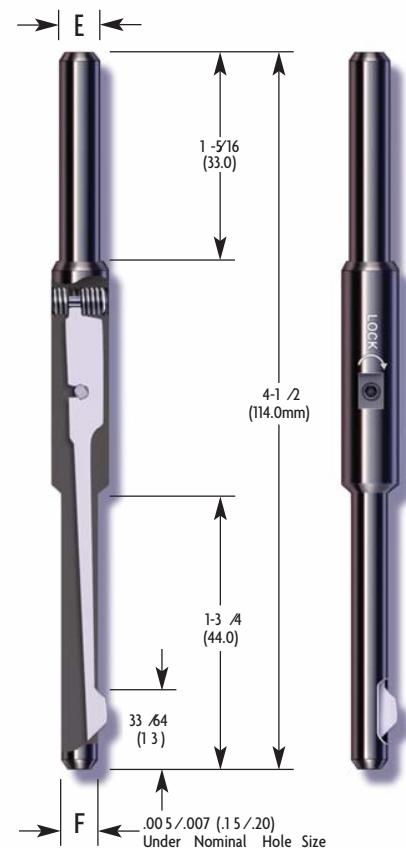


## E-Z Burr Series L2A-L2B

For holes .156" through .236" (3.96mm to 6.0mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
EZL 0156	5/32	0.1562	3.96	.250	6.35	L2A
EZL 0157		0.1574	4.00	.236	6.00	L2A
EZL 0165		0.1653	4.20	.236	6.00	L2A
EZL 0171	11/64	0.1718	4.36	.250	6.35	L2A
EZL 0177		0.1771	4.50	.236	6.00	L2A
EZL 0187	3/16	0.1875	4.76	.250	6.35	L2B
EZL 0196		0.1968	5.00	.236	6.00	L2B
EZL 0203	13/64	0.2031	5.15	.250	6.35	L2B
EZL 0208		0.2086	5.30	.236	6.00	L2B
EZL 0216		0.2165	5.50	.236	6.00	L2B
EZL 0218	7/32	0.2185	5.55	.250	6.35	L2B
EZL 0228		0.2283	5.80	.236	6.00	L2B
EZL 0234	15/64	0.2343	5.95	.250	6.35	L2B
EZL 0236		0.2362	6.00	.236	6.00	L2B

Note: Series L2A and L2B tools have a working range of -0.0+.016 inches and -.10+.40mm.



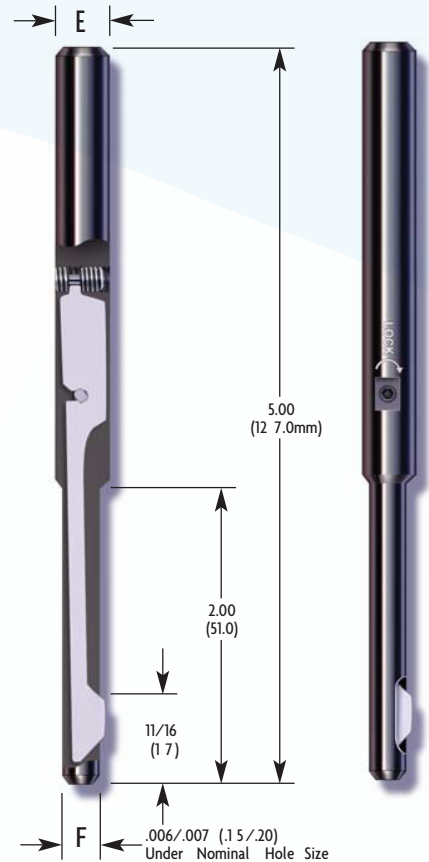
# E-Z Burr Tool Specifications – HSS Series

## E-Z Burr Series L3A

For holes .250" through .334" (6.35mm to 8.50mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
EZL 0250	1/4	0.2500	6.35	.359	9.10	L3A
EZL 0255		0.2559	6.50	.354	9.00	L3A
EZL 0265	17/64	0.2656	6.74	.359	9.10	L3A
EZL 0275		0.2755	7.00	.354	9.00	L3A
EZL 0281	9/32	0.2812	7.14	.359	9.10	L3A
EZL 0287		0.2874	7.30	.354	9.00	L3A
EZL 0295		0.2953	7.50	.354	9.00	L3A
EZL 0296	19/64	0.2968	7.54	.359	9.10	L3A
EZL 0305		0.3051	7.75	.354	9.00	L3A
EZL 0312	5/16	0.3125	7.93	.359	9.10	L3A
EZL 0314		0.3149	8.00	.354	9.00	L3A
EZL 0328	21/64	0.3281	8.33	.359	9.10	L3A
EZL 0334		0.3346	8.50	.354	9.00	L3A

Note: Series L3A and L3B tools have a working range of -0.004+.015 inches and -.10+.40mm.

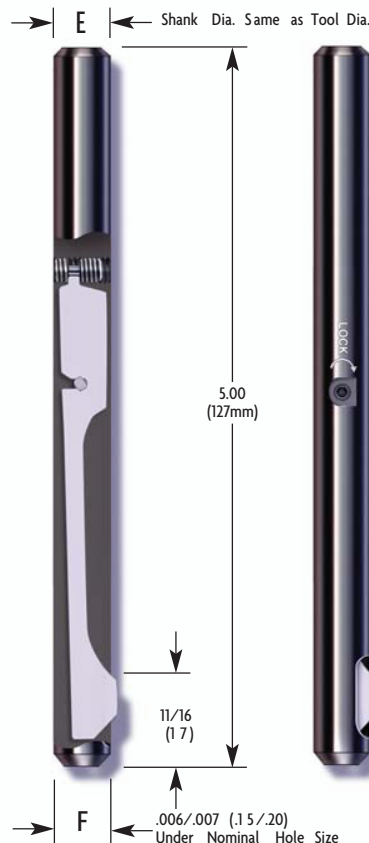


## E-Z Burr Series L3B

For holes .343" through .500" (8.73mm to 12.70mm).

Tool #	Hole Diameter (F)		Blade Series	
	Inches	mm		
EZL 0343	11/32	0.3437	8.73	L3B
EZL 0354		0.3543	9.00	L3B
EZL 0359	23/64	0.3593	9.12	L3B
EZL 0366		0.3661	9.30	L3B
EZL 0374		0.3740	9.50	L3B
EZL 0375	3/8	0.3750	9.52	L3B
EZL 0381		0.3818	9.70	L3B
EZL 0390	25/64	0.3906	9.92	L3B
EZL 0393		0.3937	10.00	L3B
EZL 0406	13/32	0.4062	10.31	L3B
EZL 0413		0.7133	10.50	L3B
EZL 0421	27/64	0.4218	10.71	L3B
EZL 0433		0.4218	11.00	L3B
EZL 0437	7/16	0.4375	11.11	L3B
EZL 0444		0.4448	11.30	L3B
EZL 0453	29/64	0.4531	11.50	L3B
EZL 0460		0.6406	11.70	L3B
EZL 0468	15/32	0.4687	11.90	L3B
EZL 0472		0.4724	12.00	L3B
EZL 0484	31/64	0.4843	12.30	L3B
EZL 0492		0.4921	12.50	L3B
EZL 0500	1/2	0.5000	12.70	L3B

Note: Series L3A and L3B tools have a working range of -0.004+.04 inches and -.10+.10mm.



\*To determine the blade that will best suit your application, please reference pages 22-23.



# E-Z Burr Tool Specifications – HSS Series

## E-Z Burr Series L3B

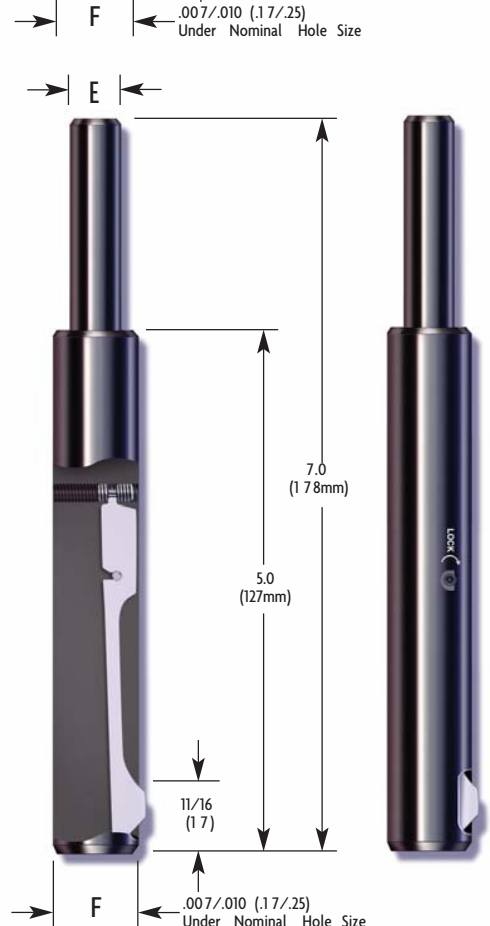
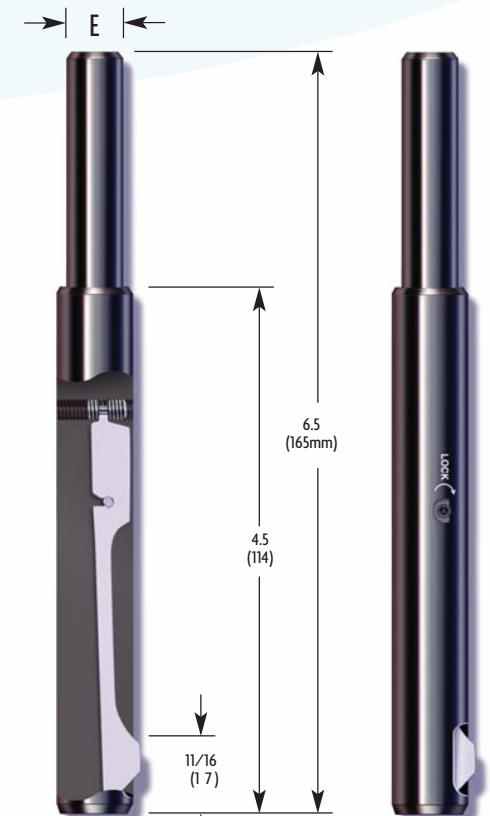
For holes .511" through .671" (13.00mm to 17.06mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
EZL 0511		0.5118	13.00	.477	12.0	L3B
EZL 0515	33/64	0.5156	13.09	.500	12.7	L3B
EZL 0531	17/32	0.5312	13.49	.500	12.7	L3B
EZL 0546	35/64	0.5468	13.89	.500	12.7	L3B
EZL 0551		0.5511	14.00	.472	12.0	L3B
EZL 0562	9/16	0.5625	14.28	.500	12.7	L3B
EZL 0570		0.5708	14.50	.472	12.0	L3B
EZL 0578	37/64	0.5781	14.68	.500	12.7	L3B
EZL 0590		0.5905	15.00	.472	12.0	L3B
EZL 0593	19/32	0.5937	15.08	.500	12.7	L3B
EZL 0600		0.6003	15.25	.472	12.0	L3B
EZL 0610	39/64	0.6098	15.47	.500	12.7	L3B
EZL 0625	5/8	0.6250	15.87	.500	12.7	L3B
EZL 0629		0.6299	16.00	.472	12.0	L3B
EZL 0640	41/64	0.6406	16.27	.500	12.7	L3B
EZL 0649		0.6496	16.50	.472	12.0	L3B
EZL 0656	21/32	0.6562	16.66	.500	12.7	L3B
EZL 0669		0.6692	17.00	.472	12.0	L3B
EZL 0671	43/64	0.6718	17.06	.500	12.7	L3B

For holes .687" through 1.00" (17.46mm to 24.00mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
EZL 0687	11/16	0.6875	17.46	.500	12.7	L3B
EZL 0703	45/64	0.7031	17.85	.500	12.7	L3B
EZL 0708		0.7086	18.00	.472	12.0	L3B
EZL 0718	23/32	0.7187	18.25	.500	12.7	L3B
EZL 0731	47/64	0.7343	18.65	.500	12.7	L3B
EZL 0748		0.7480	19.00	.472	12.0	L3B
EZL 0750	3/4	0.7500	19.05	.500	12.7	L3B
EZL 0763	49/64	0.7656	19.44	.500	12.7	L3B
EZL 0781	25/32	0.7812	19.84	.500	12.0	L3B
EZL 0787		0.7874	20.00	.472	12.0	L3B
EZL 0796	51/64	0.7968	20.24	.500	12.7	L3B
EZL 0812	13/16	0.8125	20.63	.500	12.7	L3B
EZL 0843		0.8267	21.00	.472	12.0	L3B
EZL 0859	27/32	0.8437	21.43	.500	12.7	L3B
EZL 0866	55/64	0.8593	21.82	.500	12.7	L3B
EZL 0857		0.8661	22.00	.472	12.0	L3B
EZL 0875	7/8	0.8750	22.22	.500	12.7	L3B
EZL 0890	57/64	0.8906	22.62	.500	12.0	L3B
EZL 0905		0.9055	23.00	.472	12.7	L3B
EZL 0906	29/32	0.9062	23.01	.500	12.7	L3B
EZL 0921	59/64	0.9218	23.41	.500	12.7	L3B
EZL 0937	15/16	0.9375	23.81	.500	12.7	L3B
EZL 0944		0.9448	24.00	.472	12.0	L3B
EZL 0953	61/64	0.9531	24.20	.500	12.7	L3B
EZL 0968	31/32	0.9687	24.60	.500	12.7	L3B
EZL 0984		0.9842	25.00	.472	12.0	L3B
EZL 1000	1.0	1.000	25.40	.500	12.7	L3B

Note: Series L3B tools for these hole ranges have a working range of  $-0.004+0.04$  inches and  $-10+10$  mm.



# E-Z Burr Tool Specifications – HSS Series

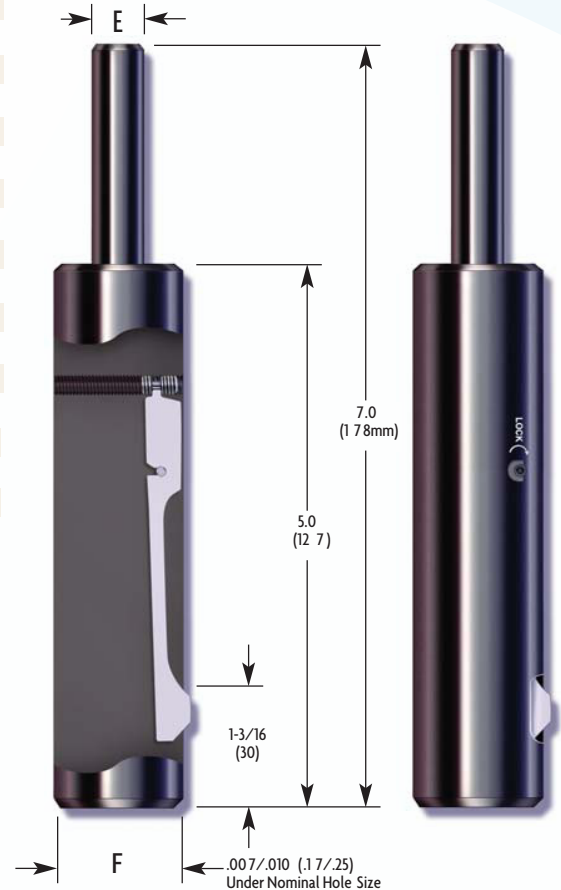
## E-Z Burr Series L3B

For holes 1.023" through 2.0" (26.00mm to 50.80mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade	
	Inches	mm	Inches	mm	Series	
EZL 1026		1.0236	26.00	.472	12.0	L3B
EZL 1062	1 1/16	1.0625	26.98	.500	12.7	L3B
EZL 1063		1.0629	27.00	.472	12.0	L3B
EZL 1102		1.1023	28.00	.472	12.0	L3B
EZL 1125	1 1/8	1.1250	28.57	.500	12.7	L3B
EZL 1141		1.1417	29.00	.472	12.0	L3B
EZL 1181		1.1811	30.00	.472	12.0	L3B
EZL 1187	1 3/16	1.1875	30.16	.500	12.7	L3B
EZL 1220		1.2204	31.00	.472	12.0	L3B
EZL 1250	1 1/4	1.2500	31.75	.500	12.7	L3B
EZL 1259		1.2598	32.00	.472	12.0	L3B
EZL 1299		1.2992	33.00	.472	12.0	L3B
EZL 1312	1 5/16	1.3125	33.33	.500	12.7	L3B
EZL 1338		1.3385	34.00	.472	12.0	L3B
EZL 1375	1 3/8	1.3750	34.92	1.000	25.4	L3B
EZL 1377		1.3779	35.00	.984	25.0	L3B
EZL 1417		1.4173	36.00	.984	25.0	L3B
EZL 1437	1 7/16	1.4375	36.51	1.000	25.4	L3B
EZL 1456		1.4566	37.00	.984	25.0	L3B
EZL 1496		1.4960	38.00	.984	25.0	L3B
EZL 1500	1 1/2	1.5000	38.10	1.000	25.4	L3B
EZL 1535		1.5354	39.00	.984	25.0	L3B
EZL 1562	1 9/16	1.5625	39.68	1.000	25.4	L3B
EZL 1574		1.5748	40.00	.984	25.0	L3B
EZL 1614		1.6141	41.00	.984	25.0	L3B
EZL 1625	1 5/8	1.6250	41.27	1.000	25.4	L3B
EZL 1653		1.6535	42.00	.984	25.0	L3B
EZL 1692		1.6929	43.00	.984	25.0	L3B
EZL 1732		1.7322	44.00	.984	25.0	L3B
EZL 1750	1 3/4	1.7500	44.45	1.000	25.4	L3B
EZL 1771		1.7716	45.00	.984	25.0	L3B
EZL 1811		1.8110	46.00	.984	25.0	L3B
EZL 1850		1.8503	47.00	.984	25.0	L3B
EZL 1875	1 7/8	1.8750	47.62	1.000	25.4	L3B
EZL 1889		1.8897	48.00	.984	25.0	L3B
EZL 1929		1.9291	49.00	.984	25.0	L3B
EZL 1968		1.9685	50.00	.984	25.0	L3B
EZL 2000	2.00	2.000	50.80	1.000	25.4	L3B

\*Larger tools available upon request.

Note: Series L3B tools for these hole ranges have a working range of -.0004+.04inches and -.10+.10mm.



# How to Order our HSS Tools

The following pages consist of E-Z Burr's standard tool specifications. When you determine which E-Z Burr tool is the right one for your application you can either call us, email us or fax us.

When ordering High Speed Steel deburring tools whether it is a Micro Series Tool, Standard HSS tool or Stubby Tool you will need to add a blade suffix to the tool number.



Please reference page 23 to determine the correct blade suffix for your application. These tool extension numbers are based on your desired hole size, material and whether you need front and rear hole deburring or rear-only.

Example: EZL 0250 both Front and Rear Cutting = EZL0250-02  
 EZL 0250 Rear Only Cutting = EZL0250-08.

## Recommended Speeds and Feeds

Material	HSS Series	
	SFM	Feed (IPR)
Free Machining	75 - 126	.003 - .010
Aluminum	90 - 150	.003 - .008
Cast Iron	40 - 60	.003 - .010
Low Carbon	60 - 100	.004 - .011
Med Carbon	45 - 80	.003 - .010
Stainless	20 - 40	.003 - .010
High Alloy Steel	25 - 50	.003 - .010

The speeds and feeds above are intended as guidelines only.

## Formula

Inches (decimal)	mm (metric)
$RPM = \frac{SFM \times 3.82}{DIA}$	$RPM = \frac{M/min \times 318.47}{DIA}$
$IPM = RPM \times IPR$	$mm/min = RPM \times mm/REV$
$SFM = \frac{RPM \times DIA}{3.82}$	$M/min = \frac{RPM \times DIA}{318.47}$

## Terms

IPM = Inches Per Minute  
 IPR = Inches Per Revolution  
 RPM = Revolutions Per Minute  
 SFM = Surface Feet Per Minute  
 DIA = Tool Diameter



# High Speed Steel Cutting Blades

E-Z Burr has a unique spring-type high speed steel blade has set the standard for durability and reliability in the tooling industry. These precision blades assure part-to-part consistency.

To determine the best HSS blade for your application, use this chart. You will need to know the following:

1. Determine your tool range (for assistance with this go to [ezburr.com](http://ezburr.com) and click on E-Z Tool Calculator)
2. Determine the material group you are cutting

Material Type:	Cast Iron: Grey Ductile Nodular		Aluminum Free Machining: 1118, 1215,12L14 Medium Carbon: 1030, 1040, 1050 Alloy: 4140, 5140, 8640, 4340, 4330		Stainless: 303, 416, 420 Low Carbon: 1008, 1010, 1018, 1020, 1025, 1522 Structural Steel: A36, A285, A516		High Temp Alloys: Hastelloy Inconel Rene	
Material Machinability:	STANDARD		GOOD		TOUGH (-T)		DIFFICULT (-D)	
Tool Range	Cutting Styles		Cutting Styles		Cutting Styles		Cutting Styles	
	Front & Rear	Rear Only	Front & Rear	Rear Only	Front & Rear	Rear Only	Front & Rear	Rear Only
CAR0400 - CAR0880 (W/Suffix) Replacement Blade #	-B N/A	-R N/A	-B N/A	-R N/A	-B N/A	-R N/A	-B N/A	-R N/A
EZL0093 - EZL0118 (W/Suffix) Replacement Blade #	-01 L1A-01	-07 L1A-07	-02 L1A-02	-08 L1A-08	-05 L1A-05	-11 L1A-11	-05 L1A-05	-11 L1A-11
EZL0122 - EZL0153 (W/Suffix) Replacement Blade #	-01 L1B-01	-07 L1B-07	-02 L1B-02	-08 L1B-08	-05 L1B-05	-11 L1B-11	-05 L1B-05	-11 L1B-11
EZL0156 - EZL0177 (W/Suffix) Replacement Blade #	-01 L2A-01	-07 L2A-07	-02 L2A-02	-08 L2A-08	-05 L2A-05	-11 L2A-11	-05 L2A-05	-11 L2A-11
EZL0187 - EZL0236 (W/Suffix) Replacement Blade #	-01 L2B-01	-07 L2B-07	-02 L2B-02	-08 L2B-08	-05 L2B-05	-11 L2B-11	-05 L2B-05	-11 L2B-11
EZL0250 - EZL0334 (W/Suffix) Replacement Blade #	-01 L3A-01	-07 L3A-07	-02 L3A-02	-08 L3A-08	-05 L3A-05	-11 L3A-11	-05 L3A-05	-11 L3A-11
EZL0343 - EZL2000 (W/Suffix) Replacement Blade #	-01 L3B-01	-07 L3B-07	-02 L3B-02	-08 L3B-08	-05 L3B-05	-11 L3B-11	-05 L3B-05	-11 L3B-11



B Style



R Style

# E-Z Burr Tool Specifications – Carbide Series

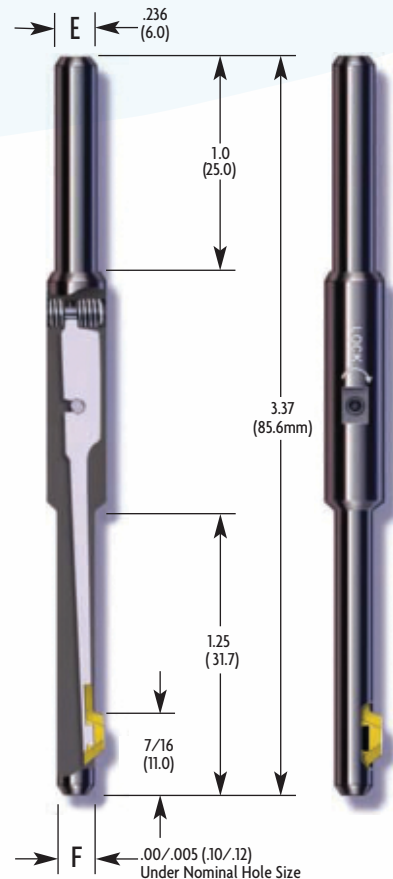
## E-Z Burr Series C4B

For Holes .125" through .153" ( 3.17mm to 3.9mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
CDT 0125		.1250	3.17	0.236	6.00	C4B
CDT 0129	1/8	.1299	3.30	0.236	6.00	C4B
CDT 0133		.1338	3.40	0.236	6.00	C4B
CDT 0137		.1378	3.50	0.236	6.00	C4B
CDT 0140	9/64	.1406	3.57	0.236	6.00	C4B
CDT 0145		.1456	3.70	0.236	6.00	C4B
CDT 0149		.1496	3.80	0.236	6.00	C4B
CDT 0153		.1535	3.90	0.236	6.00	C4B

Note: Select tool to match hole diameter that you are deburring. For in-between hole diameter select next smaller tool number.

Note: Insert and flex arm is a one piece replaceable component.



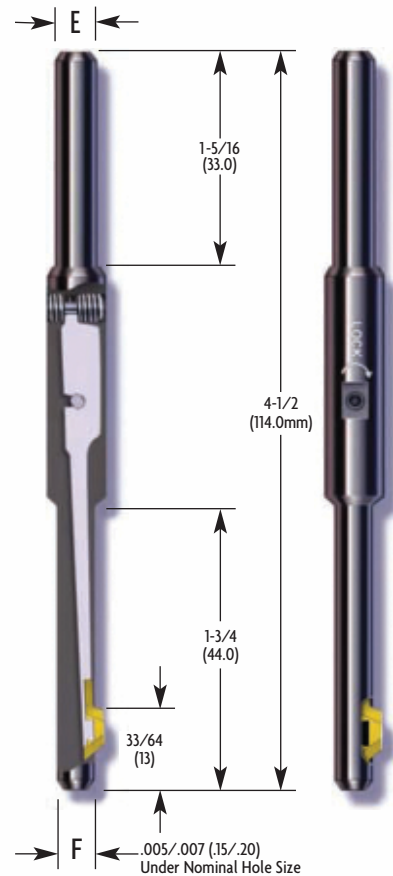
## E-Z Burr Series C5B

For Holes .156" through .236" ( 3.96mm to 6.00mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
CDT 0156	5/34	0.1562	3.96	.250	6.35	C5B
CDT 0157		0.1574	4.00	.236	6.00	C5B
CDT 0165		0.1653	4.30	.236	6.00	C5B
CDT 0171	11/64	0.1718	4.40	.250	6.35	C5B
CDT 0177		0.1771	4.50	.236	6.00	C5B
CDT 0187	3/16	0.1875	4.76	.250	6.35	C5B
CDT 0196		0.1968	5.00	.236	6.00	C5B
CDT 0203	13/64	0.2031	5.15	.250	6.35	C5B
CDT 0208		0.2086	5.30	.236	6.00	C5B
CDT 0216		0.2165	5.50	.236	6.00	C5B
CDT 0218	7/32	0.2185	5.55	.250	6.35	C5B
CDT 0228		0.2283	5.80	.236	6.00	C5B
CDT 0234	15/64	0.2343	5.95	.250	6.35	C5B
CDT 0236		0.2362	6.00	.236	6.00	C5B

Note: Select tool to match hole diameter that you are deburring. For in-between hole diameter select next smaller tool number.

Note: Insert and flex arm is a one piece replaceable component.



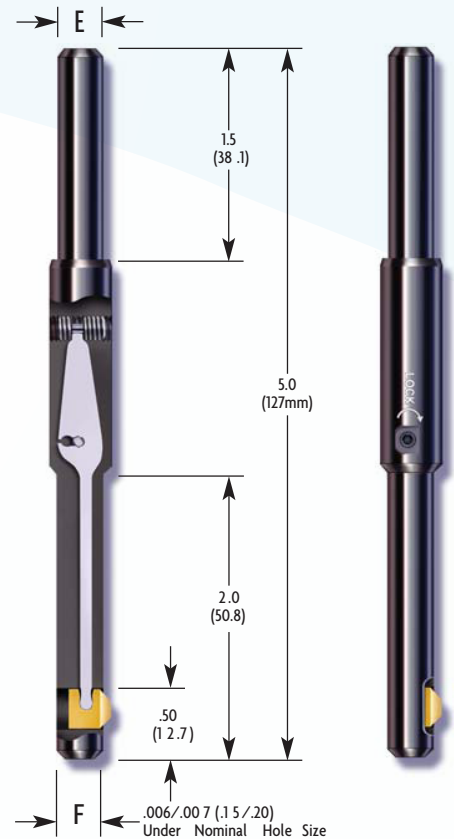
# E-Z Burr Tool Specifications – Carbide Series

## E-Z Burr Series V6A-V6C

For holes .250" through .334" (6.35mm to 8.50mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
CVP 0250	1/4	0.2500	6.35	.312	7.92	V6A
CVP 0255		0.2559	6.50	.314	8.00	V6A
CVP 0265	17/64	0.2656	6.74	.312	7.92	V6A
CVP 0275		0.2755	7.00	.314	8.00	V6A
CVP 0281	9/32	0.2812	7.14	.312	7.92	V6B
CVP 0287		0.2874	7.30	.314	8.00	V6B
CVP 0295		0.2953	7.50	.314	8.00	V6B
CVP 0296	19/64	0.2968	7.54	.312	7.92	V6B
CVP 0305		0.3051	7.75	.314	8.00	V6B
CVP 0312	5/16	0.3125	7.93	.312	7.92	V6C
CVP 0314		0.3149	8.00	.314	8.00	V6C
CVP 0328	21/64	0.3281	8.33	.314	7.92	V6C
CVP 0334		0.3346	8.50	.314	8.00	V6C

Note: Series C6A, C6B & C6C tools have a working range of  $-0.004 \pm 0.015$  inches and  $-10 \pm 40$ mm.

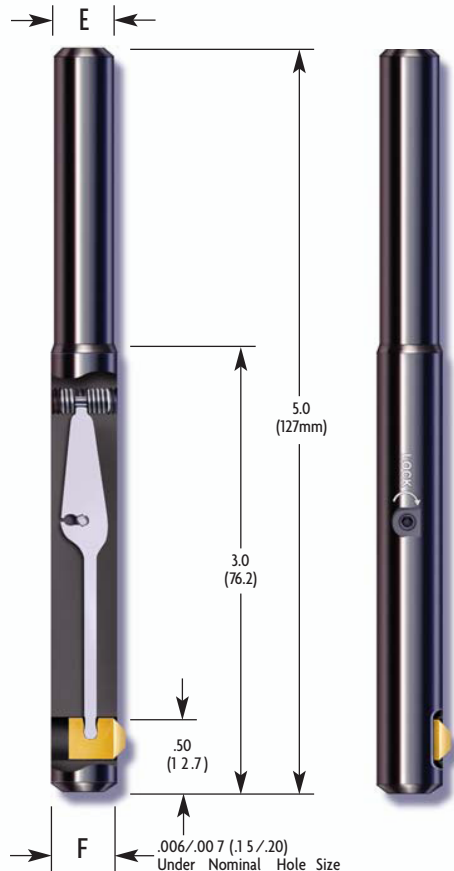


## E-Z Burr Series C7A-C7B

For holes .343 through .500" (8.73mm to 12.70mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
CRB 0343	11/32	0.3437	8.73	.312	7.92	C7A
CRB 0354		0.3543	9.00	.314	8.00	C7A
CRB 0359	23/64	0.3593	9.12	.312	7.92	C7A
CRB 0366		0.3661	9.30	.314	8.00	C7A
CRB 0374		0.3740	9.50	.314	8.00	C7A
CRB 0375	3/8	0.3750	9.52	.312	7.92	C7A
CRB 0381		0.3818	9.70	.314	8.00	C7A
CRB 0390	25/64	0.3906	9.72	.312	7.92	C7A
CRB 0393		0.3937	10.00	.314	8.00	C7A
CRB 0406	13/32	0.4062	10.31	.312	7.92	C7A
CRB 0413		0.4133	10.50	.393	10.00	C7B
CRB 0421	27/64	0.4218	10.71	.375	9.52	C7B
CRB 0433		0.4330	11.00	.393	10.00	C7B
CRB 0437	7/16	0.4375	11.11	.375	9.52	C7B
CRB 0444		0.4448	11.30	.393	10.00	C7B
CRB 0453	29/64	0.4531	11.50	.375	9.52	C7B
CRB 0460		0.4606	11.70	.393	10.00	C7B
CRB 0468	15/32	0.4687	11.90	.375	9.52	C7B
CRB 0472		0.4724	12.00	.393	10.00	C7B
CRB 0484	31/64	0.4843	12.30	.375	9.52	C7B
CRB 0492		0.4921	12.50	.393	10.00	C7B
CRB 0500	1/2	0.5000	12.70	.375	9.52	C7B

Note: Series C7A & C7B tools have a working range of  $-0.004 \pm 0.015$  inches and  $-10 \pm 40$ mm.



\*To determine the blade that will best suit your application, please reference pages 28-29.



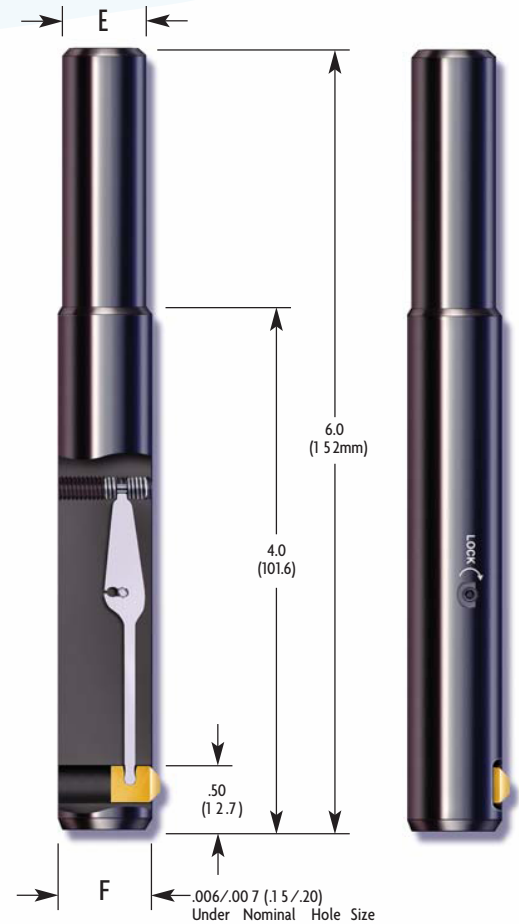
# E-Z Burr Tool Specifications – Carbide Series

## E-Z Burr Series C8A

For holes .511" through 1.00 (13.0mm to 25.40mm)

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	
	Inches	mm	Inches	mm		
CRB 0511		0.5118	13.00	.472	12.00	C8A
CRB 0515	33/64	0.5156	13.09	.500	12.70	C8A
CRB 0531	17/32	0.5312	13.49	.500	12.70	C8A
CRB 0546	35/64	0.5468	13.89	.500	12.70	C8A
CRB 0551		0.5511	14.00	.472	12.00	C8A
CRB 0562	9/16	0.5625	14.28	.500	12.70	C8A
CRB 0570		0.5708	14.50	.472	12.00	C8A
CRB 0578	37/64	0.5781	14.68	.500	12.70	C8A
CRB 0590		0.5905	15.00	.472	12.00	C8A
CRB 0593	19/32	0.5937	15.08	.500	12.70	C8A
CRB 0600		0.6003	15.25	.472	12.00	C8A
CRB 0610	39/64	0.6093	15.47	.500	12.70	C8A
CRB 0625	5/8	0.6250	15.87	.500	12.70	C8A
CRB 0629		0.6299	16.00	.472	12.00	C8A
CRB 0640	41/64	0.6406	16.27	.500	12.70	C8A
CRB 0649		0.6496	16.50	.472	12.00	C8A
CRB 0656	21/32	0.6562	16.66	.500	12.70	C8A
CRB 0669		0.6692	17.00	.472	12.00	C8A
CRB 0671	43/64	0.6718	17.06	.500	12.70	C8A
CRB 0687	11/16	0.6875	17.46	.500	12.70	C8A
CRB 0703	45/64	0.7031	17.85	.625	15.87	C8A
CRB 0708		0.7086	18.00	.629	16.00	C8A
CRB 0718	23/32	0.7187	18.25	.625	15.87	C8A
CRB 0734	47/64	0.7343	18.65	.625	15.87	C8A
CRB 0748		0.7480	19.00	.629	16.00	C8A
CRB 0750	3/4	0.7500	19.05	.625	15.87	C8A
CRB 0763	49/64	0.7656	19.44	.625	15.87	C8A
CRB 0781	25/32	0.7812	19.84	.625	15.87	C8A
CRB 0787		0.7874	20.00	.629	16.00	C8A
CRB 0796	51/64	0.7968	20.24	.625	15.87	C8A
CRB 0812	13/16	0.8125	20.63	.625	15.87	C8A
CRB 0826		0.8267	21.00	.629	16.00	C8A
CRB 0843	27/32	0.8437	21.43	.625	15.87	C8A
CRB 0859	55/64	0.8593	21.82	.625	15.87	C8A
CRB 0866		0.8661	22.00	.629	16.00	C8A
CRB 0875	7/8	0.8750	22.22	.625	15.87	C8A
CRB 0890	57/64	0.8906	22.62	.625	15.87	C8A
CRB 0905		0.9055	23.00	.629	16.00	C8A
CRB 0906	29/32	0.9062	23.01	.625	15.87	C8A
CRB 0921	59/64	0.9218	23.41	.625	15.87	C8A
CRB 0937	15/16	0.9375	23.81	.625	15.87	C8A
CRB 0944		0.9448	24.00	.629	16.00	C8A
CRB 0953	61/64	0.9531	24.20	.625	15.87	C8A
CRB 0968	31/32	0.9687	24.06	.625	15.87	C8A
CRB 0984		0.9842	25.00	.629	16.00	C8A
CRB 1000	1.00	1.0000	25.40	.625	15.87	C8A

Note: Series C8A tools have a working range of -0.004+0.015 decimal and -.10+.40mm.



# E-Z Burr Tool Specifications – Carbide Series

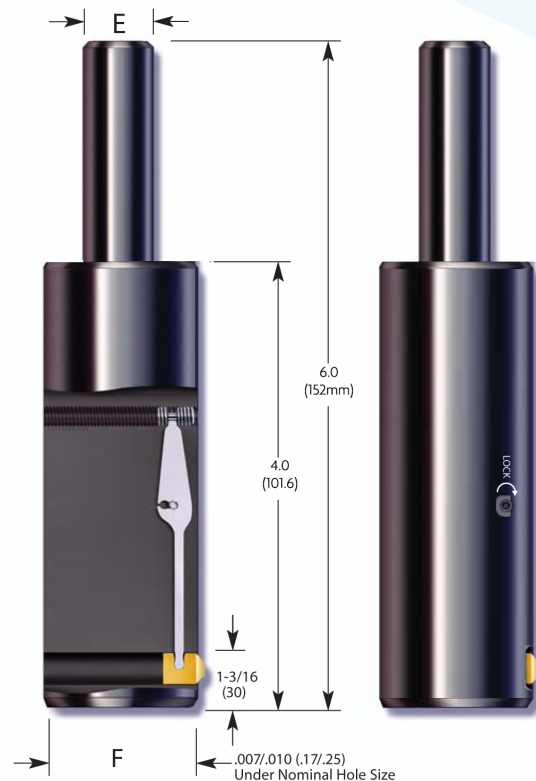
## E-Z Burr Series C8A

For holes 1.023" through 2.0" (26.00mm to 50.80mm).

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade	
	Inches	mm	Inches	mm	Series	
CRB 1023		1.0236	26.00	.629	16.00	C8A
CRB 1062	1 1/16	1.0625	26.98	.625	15.87	C8A
CRB 1063		1.0629	27.00	.629	16.00	C8A
CRB 1102		1.1023	28.00	.629	16.00	C8A
CRB 1125	1 1/8	1.1250	28.57	.625	15.87	C8A
CRB 1141		1.1417	29.00	.629	16.00	C8A
CRB 1181		1.1811	30.00	.629	16.00	C8A
CRB 1187	1 3/16	1.1875	30.16	.625	15.87	C8A
CRB 1220		1.2204	31.00	.629	16.00	C8A
CRB 1250	1 1/4	1.2500	31.75	.625	15.87	C8A
CRB 1259		1.2598	32.00	.629	16.00	C8A
CRB 1299		1.2992	33.00	.629	16.00	C8A
CRB 1312	1 5/16	1.3125	33.33	.625	15.87	C8A
CRB 1338		1.3385	34.00	.629	16.00	C8A
CRB 1375	1 3/8	1.3750	34.92	1.000	25.40	C8A
CRB 1377		1.3779	35.00	.984	25.00	C8A
CRB 1417		1.4173	36.00	.984	25.00	C8A
CRB 1437	1 7/16	1.4375	36.51	1.000	25.40	C8A
CRB 1456		1.4566	37.00	.984	25.00	C8A
CRB 1496		1.4960	38.00	.984	25.00	C8A
CRB 1500	1 1/2	1.5000	38.10	1.000	25.40	C8A
CRB 1535		1.5354	39.00	.984	25.00	C8A
CRB 1562	1 9/16	1.5625	39.68	1.000	25.40	C8A
CRB 1574		1.5748	40.00	.984	25.00	C8A
CRB 1614		1.6141	41.00	.984	25.00	C8A
CRB 1625	1 5/8	1.6250	41.27	1.000	25.40	C8A
CRB 1653		1.6535	42.00	.984	25.00	C8A
CRB 1692		1.6929	43.00	.984	25.00	C8A
CRB 1732		1.7322	44.00	.984	25.00	C8A
CRB 1750	1 3/4	1.7500	44.45	1.000	25.40	C8A
CRB 1771		1.7716	45.00	.984	25.00	C8A
CRB 1811		1.8110	46.00	.984	25.00	C8A
CRB 1850		1.8503	47.00	.984	25.00	C8A
CRB 1875	1 7/8	1.8750	47.62	1.000	25.40	C8A
CRB 1889		1.8897	48.00	.984	25.00	C8A
CRB 1929		1.9291	49.00	.984	25.00	C8A
CRB 1968		1.9685	50.00	.984	25.00	C8A
CRB 2000	2.00	2.0000	50.80	1.000	25.40	C8A

*Larger tools available upon request.*

Note: Select tool to match hole diameter that you are deburring. For in-between hole diameter select next smaller tool number.



\*To determine the blade that will best suit your application, please reference pages 28-29.

# How to Order Carbide Tools

The following pages consist of E-Z Burr's standard tool specifications. When you determine which E-Z Burr tool is the right one for your application you can either call us, email us or fax us.

When ordering carbide tool whether it is a standard carbide tool, Stubby tool, or BurrFree Drill you will need to add a blade suffix to the tool.

B-Style = Front and Rear cutting



B-Style

R-Style = Rear only cutting



R-Style

When ordering Carbide deburring tools whether it is a BurrFree Drill, Standard Carbide tool or Stubby Tool you will need to add a blade suffix to the tool number.

Please reference page 29 to determine the correct blade suffix for your application. These tool extension numbers are based on your desired hole size, material and whether you need front and rear hole deburring or rear-only.

Example: CRB 0250 both Front and Rear Cutting = CRB0250-B  
 CRB 0250 Rear Only Cutting = CRB0250-R

## Recommended Speeds and Feeds

Material	Carbide Series	
	SFM	Feed (IPR)
Free Machining	230 - 260	0.008 - 0.015
Aluminum	230 - 260	0.008 - 0.015
Cast Iron	230 - 260	0.008 - 0.015
Low Carbon	230 - 260	0.008 - 0.015
Med Carbon	200 - 230	0.006 - 0.012
Stainless	180 - 220	0.004 - 0.008
High Alloy Steel	180 - 220	0.006 - 0.012

The speeds and feeds above are intended as guidelines only.

## Formula

Inches (decimal)	mm (metric)
$RPM = \frac{SFM \times 3.82}{DIA}$	$RPM = \frac{M/min \times 318.47}{DIA}$
$IPM = RPM \times IPR$	$mm/min = RPM \times mm/REV$
$SFM = \frac{RPM \times DIA}{3.82}$	$M/min = \frac{RPM \times DIA}{318.47}$

## Terms

IPM = Inches Per Minute  
 IPR = Inches Per Revolution  
 RPM = Revolutions Per Minute  
 SFM = Surface Feet Per Minute  
 DIA = Tool Diameter



# Performance Carbide Inserts

The High Performance Carbide Series uses the same spring-type flex concept that is used in the high speed steel blade, except it has a replaceable carbide insert that is independent from the flex arm.

To determine the best Carbide blade for your application, use this chart. You will need to know the following :

1. Determine your tool range (for assistance with this go to [ezburr.com](http://ezburr.com) and click on E-Z Tool Calculator)
2. Determine the material group you are cutting
3. Choose from Both Front and Rear Cutting (-B) or Rear Cutting Only (-R)

Material Type:	Cast Iron: Grey, Ductile, Nodular, Aluminum Free Machining: 1118, 1215, 12L14 Medium Carbon: 1030, 1040, 1050 Alloy: 4140, 5140, 8640, 4340, 4330		Stainless: 303, 304, 416, 420 Low Carbon: 1010, 1020, 1025, 1522 Structural Steel: A36, A285, A516		High Temp Alloy:: Hastelloy, Inconel, Rene	
Material Machinability:	GOOD		TOUGH (-T)		DIFFICULT (-D)	
Tool Range	Cutting Styles		Cutting Styles		Cutting Styles	
	Front & Rear	Rear Only	Front & Rear	Rear Only	Front & Rear	Rear Only
CVP0250 - CVP0275 (W/Suffix) Replacement Insert #	V6A-B	V6A-R	V6A-BT	V6A-RT	V6A-BD	V6A-RD
CVP0281 - CVP0305 (W/Suffix) Replacement Insert #	V6B-B	V6B-R	V6B-BT	V6B-RT	V6B-BD	V6B-RD
CVP0312 - CVP0334 (W/Suffix) Replacement Insert #	V6C-B	V6C-R	V6C-BT	V6C-RT	V6C-BD	V6C-RD
CRB0343 - CRB0406 (W/Suffix) Replacement Insert #	C7A-B	C7A-R	C7A-BT	C7A-RT	C7A-BD	C7A-RD
CRB0413 - CRB0500 (W/Suffix) Replacement Insert #	C7B-B	C7B-R	C7B-BT	C7B-RT	C7B-BD	C7B-RD
CRB0511 - CRB2000 (W/Suffix) Replacement Insert #	C8A-B	C8A-R	C8A-BT	C8A-RT	C8A-BD	C8A-RD

The two styles of carbide inserts:

B-Style = Front and Rear cutting



B-Style

R-Style = Rear only cutting



R-Style

# E-Z Burr Tool Specifications: Stubby Tool: High Speed Steel

## E-Z Burr Series STH 1A-1B

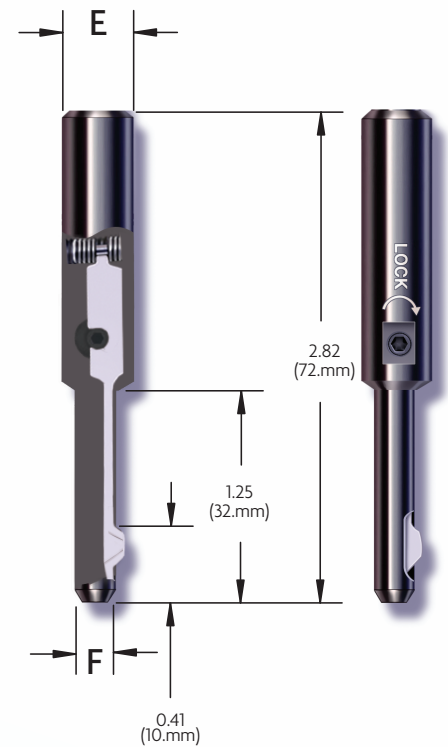
For Holes .093" through .153" ( 2.38mm to 3.90mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	O.A.L.		
	Inches	mm	Inches	mm		Inches	mm	
STH0093	3/32	.0937	2.38	0.393	10.0	STH1A	2.82	71.6
STH0098		.0984	2.50	0.393	10.0	STH1A	2.82	71.6
STH0102		.1023	2.60	0.393	10.0	STH1A	2.82	71.6
STH0106		.1062	2.70	0.393	10.0	STH1A	2.82	71.6
STH0109	7/16	.1093	2.77	0.393	10.0	STH1A	2.82	71.6
STH0114	7/64	.1141	2.90	0.393	10.0	STH1A	2.82	71.6
STH0118		.1181	3.00	0.393	10.0	STH1A	2.82	71.6
STH0122		.1220	3.10	0.393	10.0	STH1B	2.82	71.6
STH0125	1/8	.1250	3.17	0.393	10.0	STH1B	2.82	71.6
STH0129		.1299	3.30	0.393	10.0	STH1B	2.82	71.6
STH0133		.1338	3.40	0.393	10.0	STH1B	2.82	71.6
STH0137		.1378	3.50	0.393	10.0	STH1B	2.82	71.6
STH0140	9/64	.1406	3.57	0.393	10.0	STH1B	2.82	71.6
STH0145		.1456	3.70	0.393	10.0	STH1B	2.82	71.6
STH0149		.1496	3.80	0.393	10.0	STH1B	2.82	71.6
STH0153		.1535	3.90	0.393	10.0	STH1B	2.82	71.6

## E-Z Burr Series STH 2A-2B

For Holes .157" through .236" ( 4.00mm to 6.00mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Blade Series	O.A.L.		
	Inches	mm	Inches	mm		Inches	mm	
STH0157		.1574	4.00	0.393	10.0	STH2A	2.82	71.6
STH0165		.1653	4.20	0.393	10.0	STH2A	2.82	71.6
STH0171	11/64	.1718	4.36	0.393	10.0	STH2A	2.82	71.6
STH0177		.1771	4.50	0.393	10.0	STH2A	2.82	71.6
STH0187	3/16	.1875	4.76	0.393	10.0	STH2A	2.82	71.6
STH0196		.1968	5.00	0.393	10.0	STH2A	2.82	71.6
STH0203	13/64	.2031	5.15	0.393	10.0	STH2B	2.82	71.6
STH0208		.2086	5.30	0.393	10.0	STH2B	2.82	71.6
STH0216		.2165	5.50	0.393	10.0	STH2B	2.82	71.6
STH0218	7/32	.2185	5.55	0.393	10.0	STH2B	2.82	71.6
STH0228		.2283	5.80	0.393	10.0	STH2B	2.82	71.6
STH0234	15/64	.2343	5.95	0.393	10.0	STH2B	2.82	71.6
STH0236		.2362	6.00	0.393	10.0	STH2B	2.82	71.6



# E-Z Burr Tool Specifications: Stubby Tool: Carbide

## E-Z Burr Series STC 4B

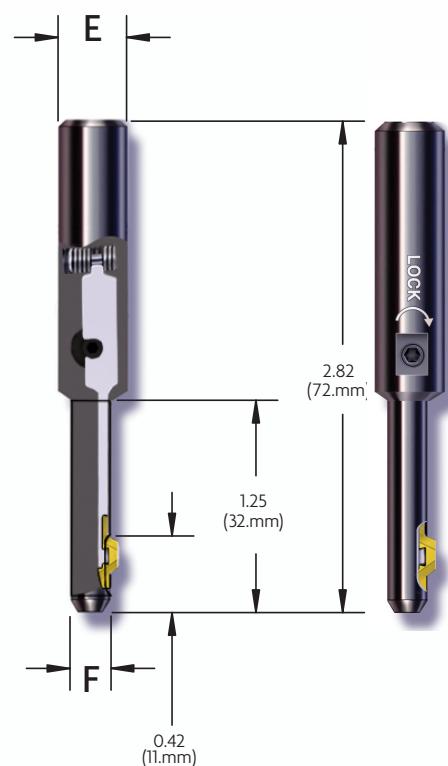
For Holes .122" through .153" ( 3.10mm to 3.90mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Insert	O.A.L.		
	Inches	mm	Inches	mm		Inches	mm	
STC0122	1/8	.1220	3.10	0.393	10.0	STC4B	2.82	71.6
STC0125		.1250	3.17	0.393	10.0	STC4B	2.82	71.6
STC0129		.1299	3.30	0.393	10.0	STC4B	2.82	71.6
STC0133		.1338	3.40	0.393	10.0	STC4B	2.82	71.6
STC0137		.1378	3.50	0.393	10.0	STC4B	2.82	71.6
STC0140	9/64	.1406	3.57	0.393	10.0	STC4B	2.82	71.6
STC0145		.1456	3.70	0.393	10.0	STC4B	2.82	71.6
STC0149		.1496	3.80	0.393	10.0	STC4B	2.82	71.6
STC0153		.1535	3.90	0.393	10.0	STC4B	2.82	71.6

## E-Z Burr Series STC 5A-5B

For Holes .157" through .236" ( 4.00mm to 6.00mm )

Tool #	Hole Diameter (F)		Shank Diameter (E)		Insert	O.A.L.		
	Inches	mm	Inches	mm		Inches	mm	
STC0157		.1574	4.00	0.393	10.0	STC5A	2.82	71.6
STC0165		.1653	4.20	0.393	10.0	STC5A	2.82	71.6
STC0171	11/64	.1718	4.36	0.393	10.0	STC5A	2.82	71.6
STC0177		.1771	4.50	0.393	10.0	STC5A	2.82	71.6
STC0187	3/16	.1875	4.76	0.393	10.0	STC5A	2.82	71.6
STC0196		.1968	5.00	0.393	10.0	STC5A	2.82	71.6
STC0203	13/64	.2031	5.15	0.393	10.0	STC5B	2.82	71.6
STC0208		.2086	5.30	0.393	10.0	STC5B	2.82	71.6
STC0216		.2165	5.50	0.393	10.0	STC5B	2.82	71.6
STC0218	7/32	.2185	5.55	0.393	10.0	STC5B	2.82	71.6
STC0228		.2283	5.80	0.393	10.0	STC5B	2.82	71.6
STC0234	15/64	.2343	5.95	0.393	10.0	STC5B	2.82	71.6
STC0236		.2362	6.00	0.393	10.0	STC5B	2.82	71.6



\*To determine the blade that will best suit your application, please reference pages 28-29.

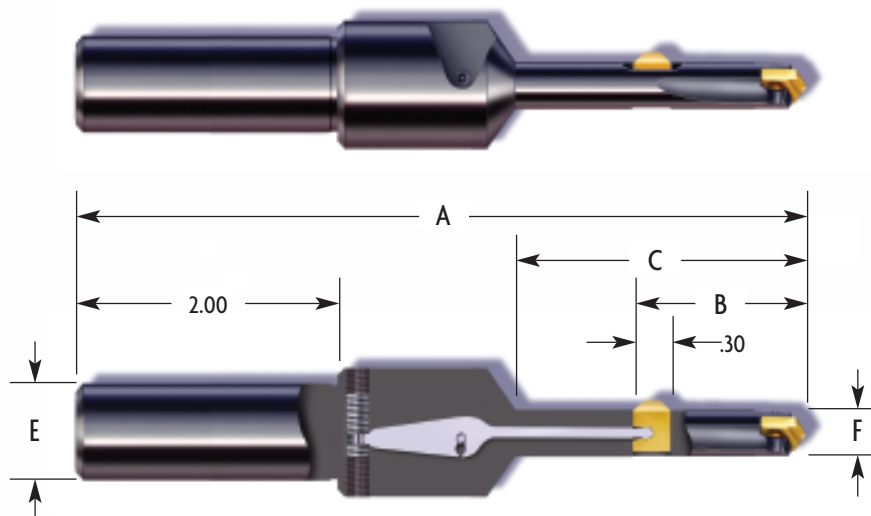
# E-Z Burr Tool Specifications: BurrFree Drill

## E-Z Burr Series

For holes .374" through 1.217 (9.50mm to 31.00mm).

Tool#	Drill Range (F)		Max Mat'l Thickness	A Dim	B Dim	C Dim	Shank Dia "E"	Insert Series
	Inches	mm		Inches	Inches	Inches		
BDS 10037	0.374 - 0.40	9.50 - 10.2	3/8	5.7	1.2	1.9	0.62	C7A
BDS 11037	0.405 - 0.43	10.27 - 11.0	3/8"	5.7	1.29	1.9	0.625	C7B
BDS 12050	0.437 - 0.46	11.08 - 11.9	1/2"	5.7	1.44	2.1	0.625	C7B
BDS 13050	0.470 - 0.50	11.92 - 12.7	1/2"	5.7	1.44	2.1	0.625	C7B
BDS 14050	0.503 - 0.53	12.74 - 13.4	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 15050	0.531 - 0.56	13.47 - 14.2	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 16050	0.562 - 0.58	14.26 - 14.9	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 17050	0.590 - 0.62	14.97 - 15.8	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 18050	0.625 - 0.65	15.86 - 16.6	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 19050	0.656 - 0.69	16.65 - 17.6	1/2"	5.7	1.46	2.2	0.750	C8A
BDS 20075	0.696 - 0.71	17.66 - 18.2	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 21075	0.718 - 0.74	18.22 - 18.9	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 22075	0.748 - 0.78	18.98 - 19.8	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 23075	0.781 - 0.81	19.82 - 20.6	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 24075	0.812 - 0.84	20.61 - 21.3	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 25075	0.843 - 0.87	21.40 - 22.2	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 26075	0.875 - 0.90	22.21 - 22.9	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 27075	0.906 - 0.93	23.00 - 23.7	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 28075	0.937 - 0.96	23.78 - 24.3	3/4"	6.1	1.74	2.7	1.000	C8A
BDS 29100	0.961 - 0.99	24.39 - 25.2	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 30100	0.994 - 1.03	25.23 - 26.1	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 31100	1.032 - 1.06	26.20 - 26.9	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 32100	1.062 - 1.09	26.96 - 27.7	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 33100	1.093 - 1.12	27.75 - 28.5	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 34100	1.125 - 1.15	28.56 - 29.3	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 35100	1.156 - 1.18	29.35 - 30.1	1.0"	6.4	2.00	3.2	1.250	C8A
BDS 36100	1.187 - 1.21	30.13 - 31.0	1.0"	6.4	2.00	3.2	1.250	C8A

Larger diameters available upon request. Material thickness is not limited to standards maximum.  
E-Z Burr tools are proprietary and are protected by U.S. and international patents.



\*To determine the blade that will best suit your application, please reference pages 28-29.



# E-Z Burr Tool Specification: Custom/Specialty tools

## E-Z Burr Custom Tools

The bulk of our business is in high-production custom tools. Your job may require special lengths, diameters, pilots, shanks, or flats. Whatever your needs may be please fill out our custom template or make a copy of your drawing and fax or email it to us. An engineer at E- Z Burr will contact you to discuss the application in more detail. Remember, E-Z Burr can produce most custom tools in about two weeks.



# Recommended Speeds / Feeds

## Recommended Speeds and Feeds

Material	Carbide Series			HSS Series		
	SFM	Feed	(IPR)	SFM	Feed	(IPR)
Free Machining	230 - 260	0.008 - 0.015		75 - 126	.003 - .010	
Aluminum	230 - 260	0.008 - 0.015		90 - 150	.003 - .008	
Cast Iron	230 - 260	0.008 - 0.015		40 - 60	.003 - .010	
Low Carbon	230 - 260	0.008 - 0.015		60 - 100	.004 - .011	
Med Carbon	200 - 230	0.006 - 0.012		45 - 80	.003 - .010	
Stainless	180 - 220	0.004 - 0.008		20 - 40	.003 - .010	
High Alloy Steel	180 - 220	0.006 - 0.012		25 - 50	.003 - .010	

The speeds and feeds above are intended as guidelines only.

### Terms

IPM = Inches Per Minute  
 IPR = Inches Per Revolution  
 RPM = Revolutions Per Minute  
 SFM = Surface Feet Per Minute  
 DIA = Tool Diameter

### Formula

Inches (decimal)	mm (metric)
$RPM = \frac{SFM \times 3.82}{DIA}$	$RPM = \frac{M/min \times 318.47}{DIA}$
$IPM = RPM \times IPR$	$mm/min = RPM \times mm/REV$
$SFM = \frac{RPM \times DIA}{3.82}$	$M/min = \frac{RPM \times DIA}{318.47}$

**E-Z Burr tools are proprietary and are protected by U.S. and international patents.**

# How to Order: Custom/Specialty tools

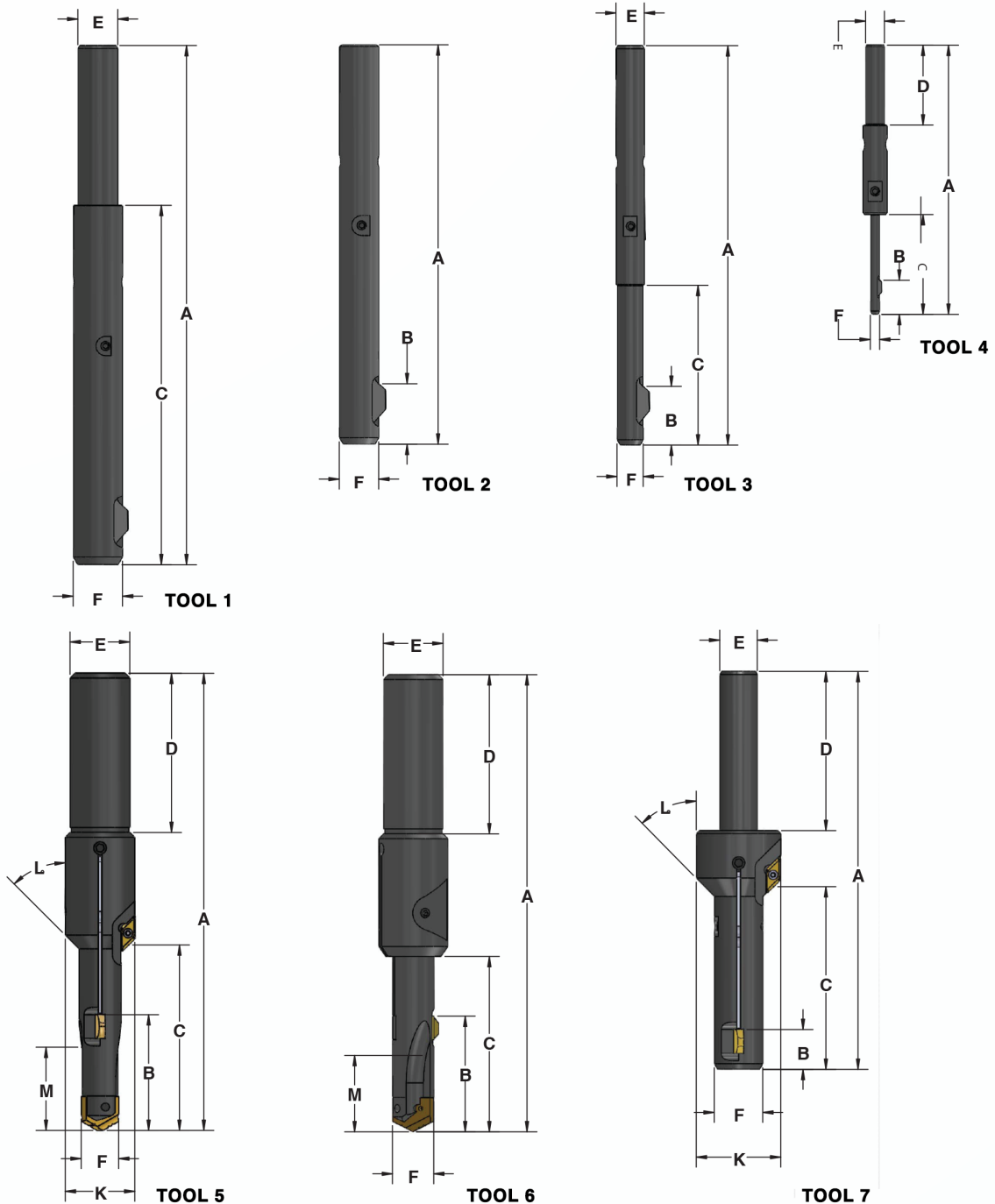
## ARBOR LAYOUT

TOOL LAYOUT #	OAL A	BLADE DEPTH B	PILOT LENGTH C	SHANK LENGTH D	SHANK DIA E	HOLE DIA F	CHAMFER DIA K	CHAMFER ANGLE L	MATERIAL THICKNESS M

## DEBURRING AND CHAMFERING INFORMATION

ANNUAL PART QTY	CARBIDE OR HSS SERIES TOOL	FRONT & REAR DEBURRING / CHAMFERING	REAR ONLY DEBURRING / CHAMFERING	MATERIAL TYPE	PART DESCRIPTION

For a custom tool design, please print this form, fill in the information, and fax or send the copy to E-Z Burr fax # 734-459-2427  
For technical assistance please contact E-Z Burr @ 800-783-2877.



# Spare Parts / Componets

## Locking Screws: Hex Key: 1/16"

Part #	Diameter Range					
	Inches	mm		Inches	mm	Hex Key
LSC-2	.093"	2.4	Through	.551"	14	1/16"
LSC-2M	For International Users					1.5mm
LSC-3	.562	14.3	And Larger			1/16"
LSC-3M	For International Users					1.5mm

## Flex Arms

Tool #	Diameter Range				
	Inches	mm		Inches	mm
FLX-6	.250"	6.4	Through	.334"	8.5
FLX-7	.343"	8.7	Through	.500"	12.7
FLX-8	.511"	13			

## Micro Series Set Screws

	Set Screw Size	Hex Key
Cartridge Holder	5-40x1/8"	1/16"
Micro Holder	8-32x1/8"	5/64"

## Adjusting Screws

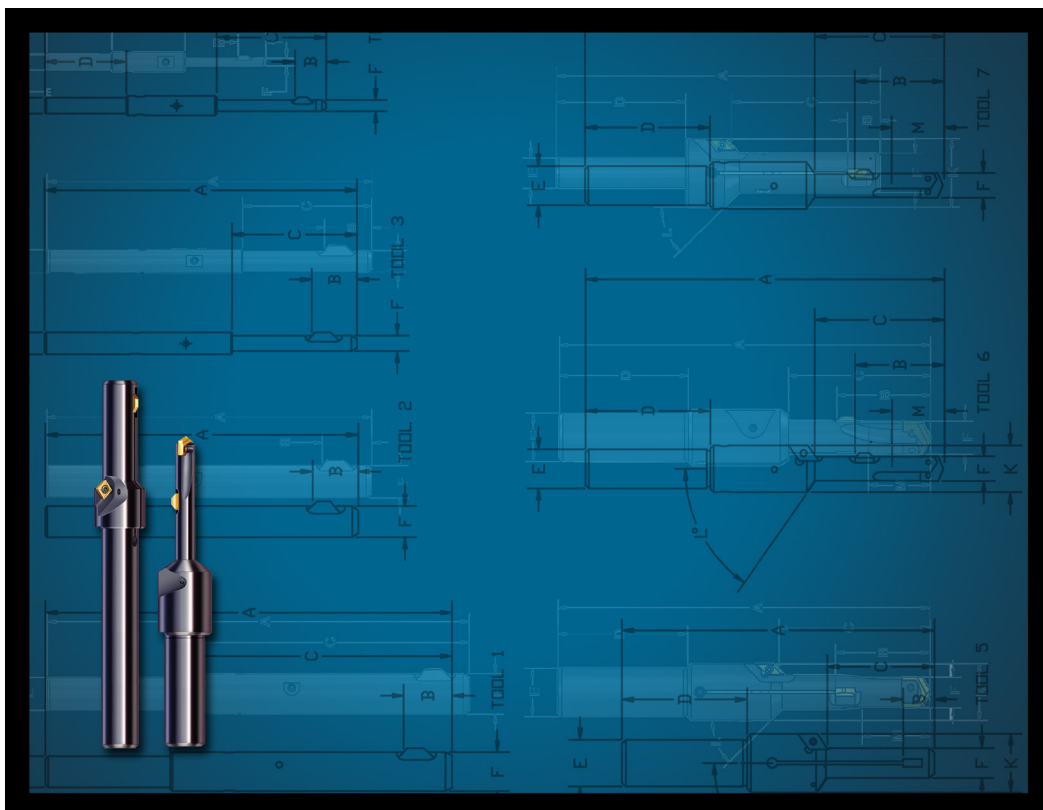
Tool #	Hex Key
A312SCR	5/64"
	2mm
For all tools from .093"/2.4mm and larger	



At E-Z Burr Tool Company, we believe we manufacture the absolute best deburring tools in the world. Is this a bold statement? Probably. But we are that confident in our quality and innovation.

Our deburring and chamfering tools are proprietary and protected by both U.S. and international patents.

- Patent # 4,086,018
- Patent # 4,147,4631
- Patent # 5,277,528
- Patent # 5,358,363
- Patent # 5,501,554
- Patent # 6,533,505
- Patent # 8,252,553





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