Retracting blade deburring tool
ECO Series

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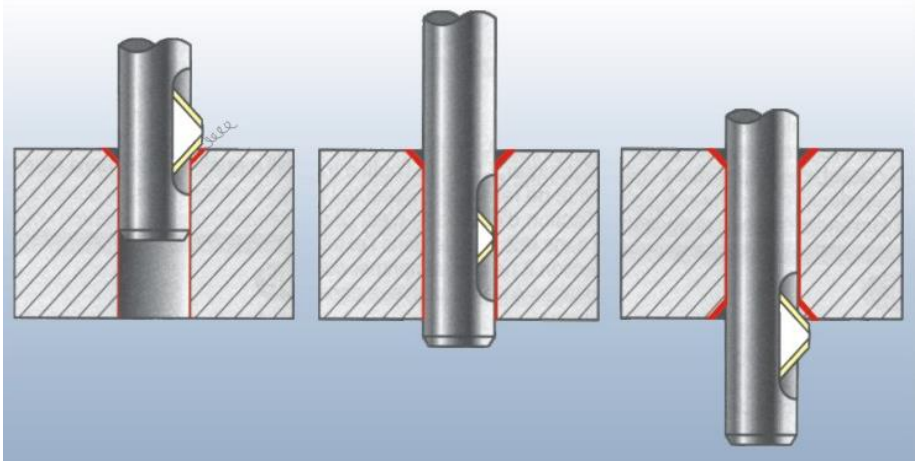
Deburring - Bevelling - Simple, fast, economical.
Works in both push and pull directions. Replaceable HSS blade.
Standard tools from Ø2 to 19mm



BLADE TYPE

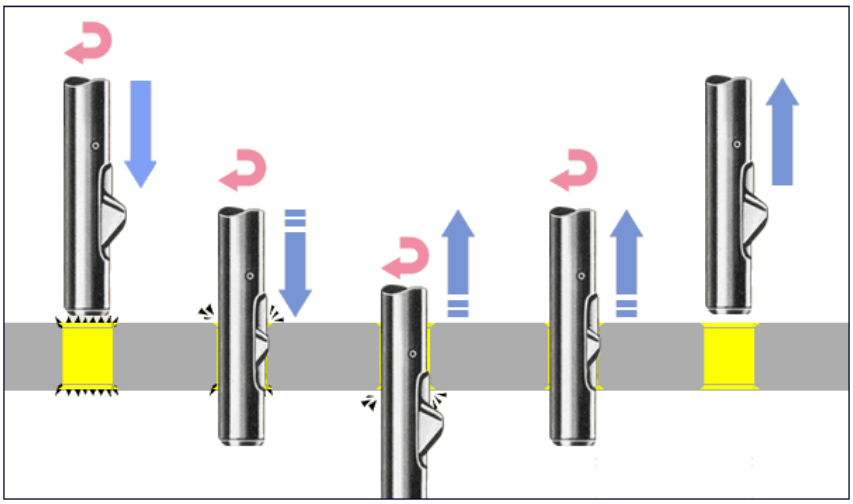
Each standard tool is supplied with a double-action HSS blade (DA) unless otherwise specified.
DA: double action, works in both push and pull directions
BA: backward action, only works in pull direction
Other available blades: 45° angle (for intersecting holes)

DA **BA**

OPERATING SPEED

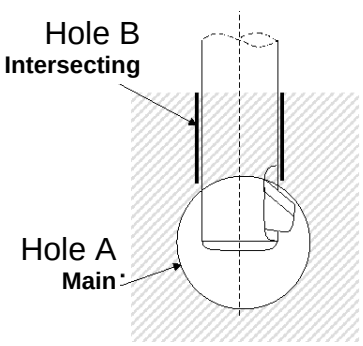
Hole Ø mm	Rotation rpm	Feed mm/rev
2 – 5	1500 – 1750	0.02 – 0.10
6 – 9	800 – 1000	0.02 – 0.15
10 +	600 – 650	0.05 – 0.20

1. Start – Rapid feed
2. Feed as per table above, or waiting time depending on material and desired chamfer size
3. Rapid feed
4. Feed as per table above, or waiting time depending on material and desired chamfer size
5. Rapid feed
6. End



DEBURRING INTERSECTING HOLES

When deburring intersecting holes, attention must be paid to the dimensional ratio between the main hole and the intersecting hole. The main hole A should be at least 3 times larger than the intersecting hole B to avoid damaging the tool. If the main hole A has a size ratio between 3 and 12 times the intersecting hole B, then it is necessary to use a 45° blade (available on order). The standard blade can be used if the main hole A is larger than 12 times the intersecting hole B.

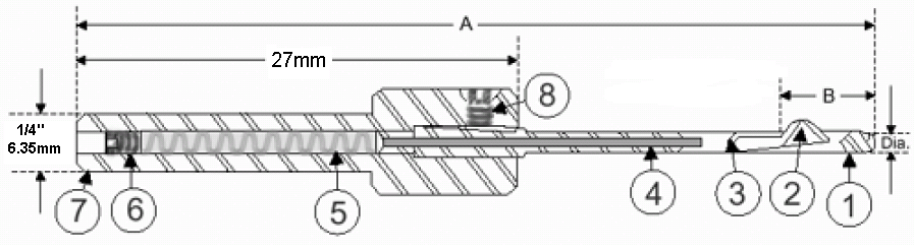


Dimensional ratio of intersecting holes A / B =	
>3	Not possible
3 – 12	45° blade
12 +	Standard blade

TYPE A *(TWO-PARTS CONSTRUCTION)*

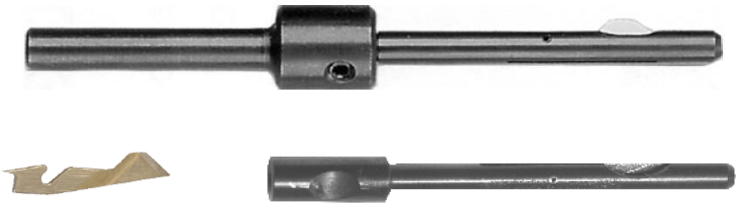
HOLE			DIMENSIONS		BLADE
CODE	Hole Ø inches	Hole Ø mm	A mm	B mm	
.0781	5/64”	2.0	86	11.5	3/32
.0938	3/32”	2.4*			
.0984		2.5			
.1094	7/64”	2.8*			
.1181		3.0			1/8
.1250	1/8”	3.2*			
.1378		3.5			
.1406	9/64”	3.6*			
.1562	5/32”	3.95*			5/32
.1575		4.0			
.1719	11/64”	4.35*			
.1772		4.5	105	18.3	3/16
.1875	3/16”	4.75*			
.1968		5.0			
.2031	13/64”	5.2*			

*** UPON REQUEST**



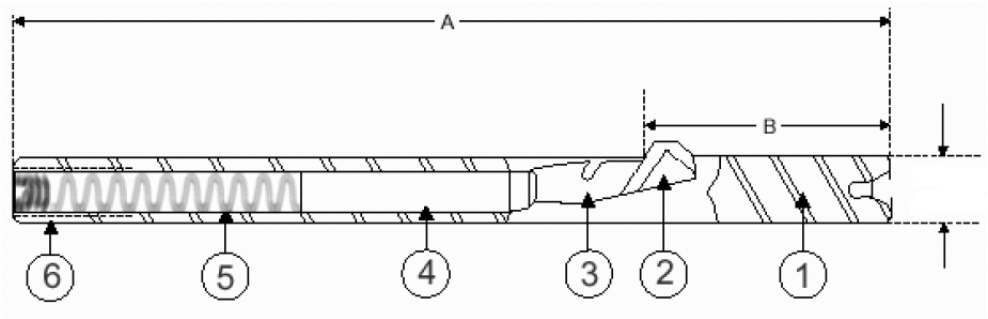
Dia: 0.075 – 0.13mm più piccolo del diametro nominale

1. Tip
2. Blade
3. Locking pin
4. Push rod
5. Push spring
6. Set screw
7. Body
8. Locking screw



TYPE B

1. Body
2. Blade
3. Locking pin
4. Push rod
5. Push spring
6. Set screw



Diameter: 0.15 – 0.2mm smaller than nominal diameter

HOLE			DIMENSIONs		BLADE
CODE	Hole Ø inches	Hole Ø mm	A mm	B mm	
.2165		5.5	114.5	22.0	#1
.2188	7/32”	5.56*			
.2344	15/64”	5.95*			
.2362		6.0			
.2500	1/4”	6.35*			
.2559		6.5			
.2656	17/64”	6.75*			
.2756		7.0			
.2812	9/32”	7.15*			
.2953		7.5		24.5	#2
.2969	19/64”	7.55*			
.3125	5/16”	7.95*			
.3150		8.0			
.3281	21/64”	8.35*			
.3346		8.5			
.3438	11/32”	8.75*			
.3543		9.0	127.0	25.5	#3
.3594	23/64”	9.15*			
.3740		9.5			
.3750	3/8”	9.55*			
.3906	25/64”	9.95*			
.3937		10.0			
.4062	13/32”	10.31*			
.4134		10.5	139.7	26.2	#3-1/2
.4219	27/64”	10.75*			
.4331		11.0			
.4375	7/16”	11.15*			
.4528		11.5			
.4531	29/64”	11.51*			

*** UPON REQUEST**

HOLE			DIMENSIONS		BLADE
CODE	Hole Ø inches	Hole Ø mm	A mm	B mm	
.4688	15/32”	11.85*	139.7	26.2	#3-1/2
.4724		12.0			
.4844	31/64”	12.3*			
.4921		12.5			
.5000	1/2”	12.7*			
.5118		13.0			
.5156	33/64”	13.1*			
.5313	17/32”	13.5			
.5469	35/64”	13.9*	163.6	33.3	#4
.5512		14.0			
.5625	9/16”	14.3*			
.5709		14.5			
.5781	37/64”	14.7*			
.5906		15.0			
.5938	19/32”	15.1*			
.6094	39/64”	15.5			
.6250	5/8”	15.9*			
.6299		16.0			
.6406	41/64”	16.3*			
.6496		16.5			
.6563	21/32”	16.7*			
.6693		17.0			
.6719	43/64”	17.1*			
.6875	11/16”	17.5			
.7087		18.0			
.7283		18.5			
.7480		19.0			
.7500	3/4”	19.1*			