

High Speed Steel Inside Deburring Cutters

Teeth as regularly furnished on these cutters are for quick light chamfering only. Stocked in 30° C/L and 45° C/L. The Inside Deburring Cutter is designed so that one tool can deburr many different hole diameters. The multi-flute design is self-piloting. For heavier countersinking, special arbors, or special angles, submit details to our Engineering Department. Holding of parts by hand is not recommended.

High Speed Steel

30° C/L (60° Included) Solid

| Head Dia. | Nose Point or Flat Dia. | Overall Length | Severance Tool Name | EDP Order Number |
|-----------|-------------------------|----------------|---------------------|------------------|
| 1/4" | P | 2-1/4" | ID-1/4-30 | 20770 |
| 5/16" | 1/32" | 2-1/4" | ID-5/16-30 | 20771 |
| 3/8" | P | 2-1/4" | ID-3/8-30 | 20772 |
| 1/2" | 9/64" | 2-1/4" | IDS-1/2-30 | 20773 |
| 1/2" | P | 2-1/4" | IDL-1/2-30 | 20774 |
| 5/8" | 13/64" | 2-1/4" | IDS-5/8-30 | 20775 |

Tools above come with 1/4" shanks



High Speed Steel

45° C/L (90° Included) Solid

| Head Dia. | Nose Point or Flat Dia. | Overall Length | Severance Tool Name | EDP Order Number |
|-----------|-------------------------|----------------|---------------------|------------------|
| 1/4" | P | 2-1/4" | ID-1/4-45 | 20805 |
| 5/16" | 1/16" | 2-1/4" | ID-5/16-45 | 20806 |
| 3/8" | P | 2-1/4" | ID-3/8-45 | 20807 |
| 1/2" | 1/8" | 2-1/4" | IDS-1/2-45 | 20808 |
| 1/2" | P | 2-1/4" | IDL-1/2-45 | 20809 |
| 5/8" | 1/8" | 2-1/4" | IDS-5/8-45 | 20810 |

Tools are furnished without shanks.
See pages 78-80 for available shank styles and sizes.

High Speed Steel

30° C/L (60° Included) Threaded

| Head Dia. | Nose Point or Flat Dia. | Overall Length | Thread Size | Severance Tool Name | EDP Order Number |
|-----------|-------------------------|----------------|-------------|---------------------|------------------|
| 5/8" | 3/64" | 7/8" | 1/4"-28 | ID-5/8-30 | 20776 |
| 3/4" | 1/32" | 1" | 5/16"-24 | ID-3/4-30 | 20777 |
| 7/8" | 5/32" | 1" | 3/8"-24 | ID-7/8-30 | 20778 |
| 1" | 9/32" | 1-1/8" | 3/8"-24 | IDS-1-30 | 20779 |
| 1" | 1/8" | 1-1/8" | 3/8"-24 | IDL-1-30 | 20780 |
| 1-1/8" | 1/8" | 1-1/8" | 3/8"-24 | ID-1-1/8-30 | 20781 |
| 1-1/4" | 17/32" | 1" | 3/8"-24 | IDS-1-1/4-30 | 20782 |
| 1-1/4" | 3/32" | 1-1/4" | 3/8"-24 | IDL-1-1/4-30 | 20783 |
| 1-1/2" | 31/64" | 1-1/8" | 1/2"-20 | IDS-1-1/2-30 | 20784 |
| 1-1/2" | 13/64" | 1-1/2" | 1/2"-20 | IDL-1-1/2-30 | 20785 |
| 1-3/4" | 3/4" | 1-1/4" | 1/2"-20 | IDS-1-3/4-30 | 20786 |
| 1-3/4" | 5/16" | 1-1/2" | 1/2"-20 | IDL-1-3/4-30 | 20787 |
| 2" | 63/64" | 1-1/4" | 5/8"-18 | IDS-2-30 | 20788 |
| 2" | 27/32" | 1-1/4" | 5/8"-18 | IDL-2-30 | 20789 |
| 2-1/4" | 1-3/32" | 1-3/8" | 3/4"-16 | IDS-2-1/4-30 | 20790 |
| 2-1/4" | 33/64" | 1-7/8" | 3/4"-16 | IDL-2-1/4-30 | 20791 |
| 2-1/2" | 1-31/64" | 1-1/4" | 3/4"-16 | IDS-2-1/2-30 | 20792 |
| 2-1/2" | 29/32" | 1-3/4" | 3/4"-16 | IDL-2-1/2-30 | 20793 |
| 3" | 1-63/64" | 1-1/4" | 1"-14 | ID-3-30 | 20794 |

High Speed Steel

45° C/L (90° Included) Threaded

| Head Dia. | Nose Point or Flat Dia. | Overall Length | Thread Size | Severance Tool Name | EDP Order Number |
|-----------|-------------------------|----------------|-------------|---------------------|------------------|
| 5/8" | 1/8" | 11/16" | 1/4"-28 | ID-5/8-45 | 20811 |
| 3/4" | P | 13/16" | 5/16"-24 | ID-3/4-45 | 20812 |
| 7/8" | 5/32" | 1" | 3/8"-24 | ID-7/8-45 | 20813 |
| 1" | 1/4" | 7/8" | 3/8"-24 | IDS-1-45 | 20814 |
| 1" | P | 7/8" | 3/8"-24 | IDL-1-45 | 20815 |
| 1-1/4" | 3/8" | 3/4" | 3/8"-24 | IDS-1-1/4-45 | 20816 |
| 1-1/4" | P | 1" | 3/8"-24 | IDL-1-1/4-45 | 20817 |
| 1-1/2" | 1/2" | 7/8" | 1/2"-20 | IDS-1-1/2-45 | 20818 |
| 1-1/2" | 1/4" | 1-1/16" | 1/2"-20 | IDL-1-1/2-45 | 20819 |
| 1-3/4" | 5/8" | 7/8" | 1/2"-20 | ID-1-3/4-45 | 20820 |
| 2" | 1" | 1" | 5/8"-18 | IDS-2-45 | 20821 |
| 2" | 1/4" | 1-1/2" | 5/8"-18 | IDL-2-45 | 20822 |
| 2-1/4" | 1" | 1" | 5/8"-18 | IDS-2-1/4-45 | 20823 |
| 2-1/4" | 1/4" | 1-3/8" | 5/8"-18 | IDL-2-1/4-45 | 20824 |
| 2-1/2" | 3/4" | 1-3/8" | 3/4"-16 | IDS-2-1/2-45 | 20825 |
| 2-1/2" | 1/4" | 1-5/8" | 3/4"-16 | IDL-2-1/2-45 | 20826 |
| 3" | 3/4" | 1-3/4" | 1"-14 | IDS-3-45 | 20827 |
| 3" | 1/4" | 1-7/8" | 1"-14 | IDL-3-45 | 20828 |

Carbide

Inside Deburring Cutters

All carbide Inside Deburring Cutters are designed with a pointed nose. Tools with a head diameter measuring 3/32" thru. 1/4" are made of solid carbide and are double ended. Inside Deburring Cutters with a head diameter measuring 5/16" thru. 2" have solid carbide heads brazed to hardened alloy precision ground shanks. Holding of parts by hand is not recommended.



Carbide

30° C/L (60° Included)

| Head Dia. | Shank Dia. | Overall Length |
|-----------|------------|----------------|
| 3/32" | 3/32" | 1-1/2" |
| 1/8" | 1/8" | 1-1/2" |
| 3/16" | 3/16" | 2" |
| 1/4" | 1/4" | 2" |
| 5/16" | 1/4" | 2-1/4" |
| 3/8" | 1/4" | 2-1/4" |
| 1/2" | 1/4" | 2-1/4" |
| 1/2" | 3/8" | 2-1/8" |
| 5/8" | 1/4" | 2-3/8" |
| 5/8" | 3/8" | 2-3/8" |
| 3/4" | 1/2" | 2-11/16" |
| 7/8" | 1/2" | 2-13/16" |
| 1" | 1/2" | 2-13/16" |

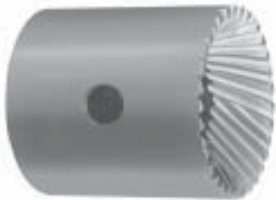
| ANSI Number | Severance Tool Name | EDP Order Number |
|-------------|---------------------|------------------|
| SJ-61 | 3Z-W-DE | 20620 |
| SJ-42 | 4Z-W-DE | 22250 |
| SJ-81 | 6Z-W-DE | 20622 |
| SJ-1 | 8Z-W-DE | 22411 |
| SJ-2 | ID-5/16-30-W | 20628 |
| SJ-3 | ID-3/8-30-W | 20629 |
| SJ-5 | ID-1/2-30-W | 20633 |
| - | ID-1/2-30-W-3/8 | 20634 |
| SJ-6 | ID-5/8-30-W | 20639 |
| - | ID-5/8-30-W-3/8 | 20640 |
| SJ-7 | ID-3/4-30-W | 20644 |
| SJ-8 | ID-7/8-30-W | 20649 |
| SJ-9 | ID-1-30-W | 20650 |

Carbide

45° C/L (90° Included)

| ANSI Number | Severance Tool Name | EDP Order Number |
|-------------|---------------------|------------------|
| SK-61 | 3Y-W-DE | 20680 |
| SK-42 | 4Y-W-DE | 22249 |
| SK-81 | 6Y-W-DE | 20682 |
| SK-1 | 8Y-W-DE | 22412 |
| SK-2 | ID-5/16-45-W | 20688 |
| SK-3 | ID-3/8-45-W | 20689 |
| SK-5 | ID-1/2-45-W | 20693 |
| - | ID-1/2-45-W-3/8 | 20694 |
| SK-6 | ID-5/8-45-W | 20699 |
| - | ID-5/8-45-W-3/8 | 20700 |
| SK-7 | ID-3/4-45-W | 20704 |
| SK-8 | ID-7/8-45-W | 20709 |
| SJK-9 | ID-1-45-W | 20710 |

Tools are furnished without shanks.
See pages 78-80 for available shank styles and sizes.



High Speed Steel Outside Deburring Cutters

Outside Deburring Cutters are designed with shear-type cutting teeth to eliminate burrs on diameters of tubes and rods. One tool can handle various parts, may be reground, and can be provided in carbide.



NOTE: Tools O-0, O-1, O-2, O-3, O-20, O-21, and O-22 have the tooth pattern illustrated above.

| Max. Head Dia. | "H" Recess Hole Dia. | "D" Mouth Dia. | "B" Body Dia. | "L" Body Length | "C" Coolant Hole | "T" I.D. Thread Size | Incl. Inside Angle | Severance Tool Name | EDP Order Number |
|----------------|----------------------|----------------|---------------|-----------------|------------------|----------------------|--------------------|---------------------|------------------|
| 1/8" | 1/16" | 5/32" | 1/2" | 7/8" | - | 1/4"-28 | 30° | O-0 | 25430 |
| 3/16" | 5/32" | 7/32" | 1/2" | 7/8" | - | 1/4"-28 | 30° | O-1 | 25431 |
| 1/4" | 13/64" | 19/64" | 1/2" | 7/8" | - | 1/4"-28 | 30° | O-2 | 25432 |
| 5/16" | .242" | 23/64" | 1/2" | 7/8" | - | 1/4"-28 | 30° | O-3 | 25433 |
| 3/8" | 9/32" | 7/16" | 5/8" | 7/8" | 1/8" | 1/4"-28 | 30° | O-4 | 25434 |
| 1/2" | .332" | 9/16" | 3/4" | 1" | 3/16" | 3/8"-24 | 30° | O-5 | 25435 |
| 5/8" | 7/16" | 11/16" | 7/8" | 1" | 3/16" | 3/8"-24 | 30° | O-6 | 25436 |
| 3/4" | 17/32" | 53/64" | 1" | 1" | 3/16" | 3/8"-24 | 30° | O-7 | 25437 |
| 1" | 45/64" | 1-5/64" | 1-1/4" | 1-3/8" | 1/4" | 1/2"-20 | 30° | O-8 | 25438 |
| 1-1/4" | 7/8" | 1-21/64" | 1-1/2" | 1-3/8" | 1/4" | 1/2"-20 | 30° | O-9 | 25439 |
| 1-1/2" | 1-3/64" | 1-19/32" | 1-3/4" | 1-5/8" | 1/4" | 5/8"-18 | 30° | O-10 | 25440 |
| 2" | 1-13/32" | 2-7/64" | 2-3/8" | 1-7/8" | 5/16" | 3/4"-16 | 30° | O-11 | 25441 |
| 2-1/2" | 1-3/4" | 2-39/64" | 2-7/8" | 2-1/8" | 5/16" | 3/4"-16 | 30° | O-12 | 25442 |
| 3" | 2-3/32" | 3-1/8" | 3-3/8" | 2-1/2" | 7/16" | 3/4"-16 | 30° | O-13 | 25443 |
| 4" | 2-13/16" | 4-1/8" | 4-3/8" | 3" | 7/16" | 1"-14 | 30° | O-14 | 25444 |
| 1/8" | 5/64" | 3/16" | 1/2" | 7/8" | - | 1/4"-28 | 45° | O-20 | 25460 |
| 3/16" | 7/64" | 7/32" | 1/2" | 7/8" | - | 1/4"-28 | 45° | O-21 | 25461 |
| 1/4" | 9/64" | 23/64" | 1/2" | 7/8" | - | 1/4"-28 | 45° | O-22 | 25462 |
| 3/8" | 3/16" | 7/16" | 5/8" | 7/8" | 1/8" | 1/4"-28 | 45° | O-23 | 25463 |
| 1/2" | 1/4" | 9/16" | 3/4" | 1" | 3/16" | 3/8"-24 | 45° | O-24 | 25464 |
| 3/4" | 3/8" | 13/16" | 1" | 1" | 3/16" | 3/8"-24 | 45° | O-25 | 25465 |
| 1" | 1/2" | 1-5/64" | 1-1/4" | 1-3/8" | 1/4" | 1/2"-20 | 45° | O-26 | 25466 |
| 1-1/2" | 3/4" | 1-19/32" | 1-3/4" | 1-1/2" | 1/4" | 5/8"-18 | 45° | O-27 | 25467 |
| 2" | 15/16" | 2-7/64" | 2-3/8" | 1-3/4" | 5/16" | 3/4"-16 | 45° | O-28 | 25468 |
| 3" | 1-7/16" | 3-1/8" | 3-1/2" | 2-1/4" | 7/16" | 3/4"-16 | 45° | O-29 | 25469 |
| 4" | 1-15/16" | 4-1/8" | 4-3/8" | 2-5/8" | 7/16" | 1"-14 | 45° | O-30 | 25470 |