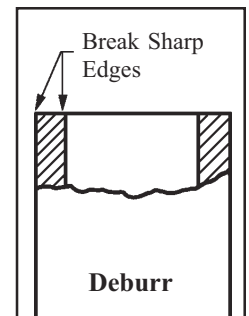


Caution: holding of tubing by hand is not recommended.

## Tube End Deburring Cutters

The cutting teeth are designed to give a shearing cut. They'll curl the fine chips away from the cutter to avoid loading. The inside member produces a chamfer of 30° angle with C/L and the outside member 45°. The tube end deburring cutters, are intended for light deburring only, and will quickly deburr tubes of most any machinable material. They are available in high speed steel and carbide for the tougher and harder materials. The tooth arrangement on these cutters has been adopted to cover the widest possible range of most commonly encountered materials. Any special material found not to be responsive to our Tube End Deburring Cutters should be given special consideration by our engineers. Simple guides such as V-blocks correctly positioned are recommended. The Ring or outside member is adjustable for more or less relative chamfer on the outside edge, and is secured after adjustment by socket screws. Operating speeds range from 50 to 200 R.P.M. depending on the size of the cutter, material and work condition. For heavier deburring, see the Severance Tube End Chamfering Mills listed on pages 37-38. Holding of parts by hand is not recommended.



### High Speed Steel

Tubing O.D. Size	Tubing I.D. Size	Hole Dia. OF Ring	Shank Dia.
1/8"	1/16"	.093"	1/4"
3/16"	1/8"	.156"	1/4"
1/4"	3/16"	.218"	1/4"
5/16"	1/4"	.281"	5/16"
3/8"	5/16"	.343"	3/8"
7/16"	3/8"	.406"	7/16"
1/2"	7/16"	.468"	1/2"
9/16"	1/2"	.531"	1/2"
5/8"	9/16"	.595"	1/2"
3/4"	5/8"	.685"	1/2"
7/8"	3/4"	.805"	1/2"
1"	7/8"	.930"	1/2"
1-1/8"	1"	1.063"	1/2"-20
1-1/4"	1-1/8"	1.180"	1/2"-20
1-3/8"	1-1/4"	1.313"	1/2"-20
1-1/2"	1-3/8"	1.430"	5/8"-18
1-3/4"	1-5/8"	1.680"	5/8"-18
2"	1-3/4"	1.930"	3/4"-16
2-1/4"	2"	2.180"	3/4"-16

### Carbide

Severance Tool Name	EDP Order Number	Severance Tool Name	EDP Order Number
A-Tube	35060	A-Tube-W	35160
BA-Tube	35061	BA-Tube-W	35161
CB-Tube	35062	CB-Tube-W	35162
DC-Tube	35063	DC-Tube-W	35163
ED-Tube	35064	ED-Tube-W	35164
FE-Tube	35065	FE-Tube-W	35165
GF-Tube	35066	GF-Tube-W	35166
HG-Tube	35067	HG-Tube-W	35167
IH-Tube	35068	IH-Tube-W	35168
JL-Tube	35069	JL-Tube-W	35169
KJ-Tube	35070	KJ-Tube-W	35170
LK-Tube	35071	LK-Tube-W	35171
ML-Tube	35072	-	-
NM-Tube	35073	-	-
ON-Tube	35074	-	-
PO-Tube	35075	-	-
RQ-Tube	35076	-	-
SR-Tube	35077	-	-
TS-Tube	35078	-	-

High Speed Steel Tube End Deburring tools ML-Tube through TS-Tube require threaded shanks, priced separately.

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