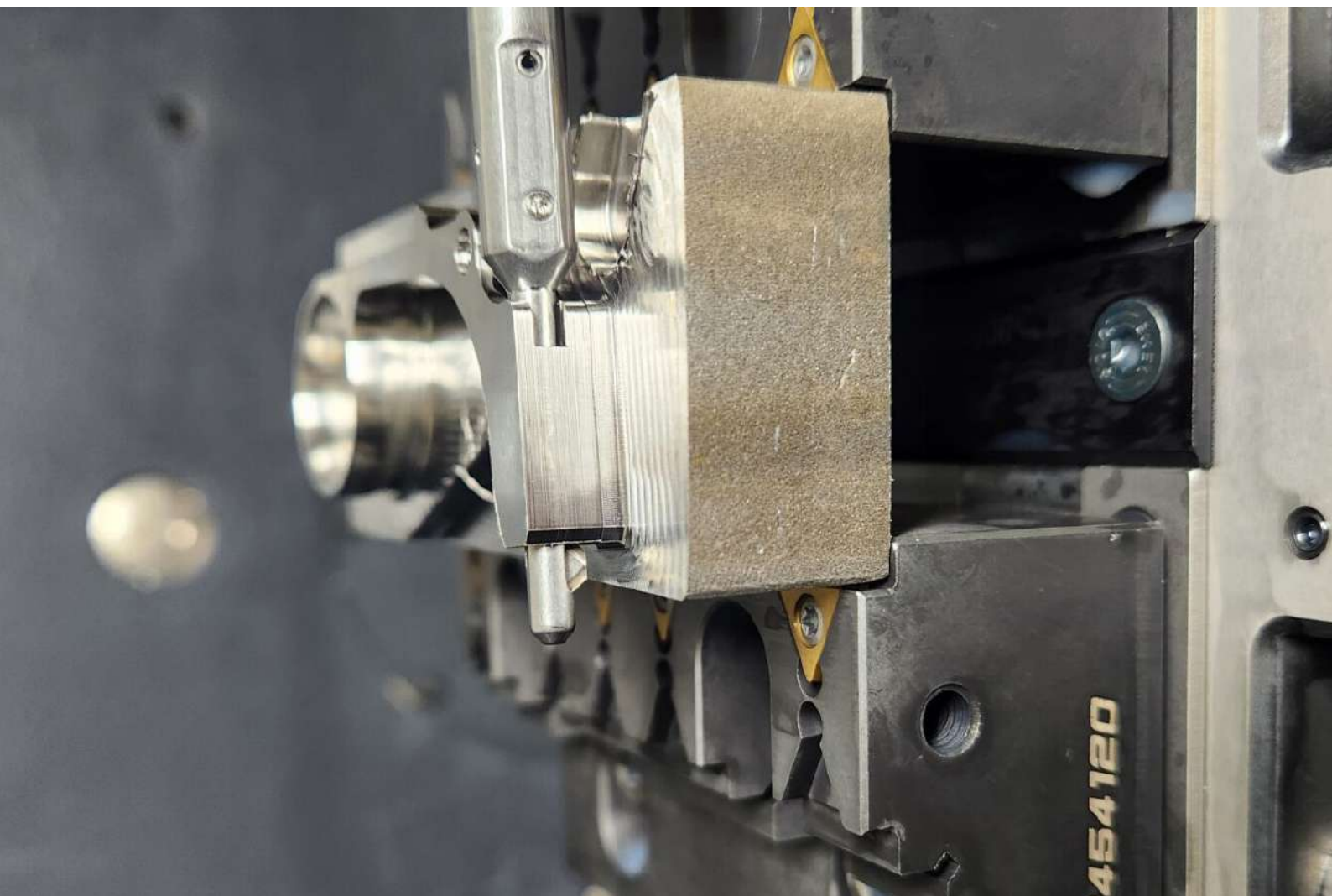


ULTIMATE **UBURR!** TOOLS

A MARK OF EXCELLENCE



At NOGA MT, our vision is clear: to deliver unparalleled excellence through top-quality products engineered by skilled professionals and crafted from the finest materials our world has to offer. Join us as we redefine deburring with **UBURR**.

ULTIMATE **UBURR!** TOOLS

UBURR SETS NEW STANDARDS

Enter NOGA MT **UBURR** – a family of deburring tools designed to streamline the automatic deburring process, comprising two essential components.

- 1** Precision cutting blade with unique geometry with different chip-formers and sizes.
- 2** MT DURASHIELD state-of-the-art tool-holder as never seen before in the industry for the metal cutting tools.



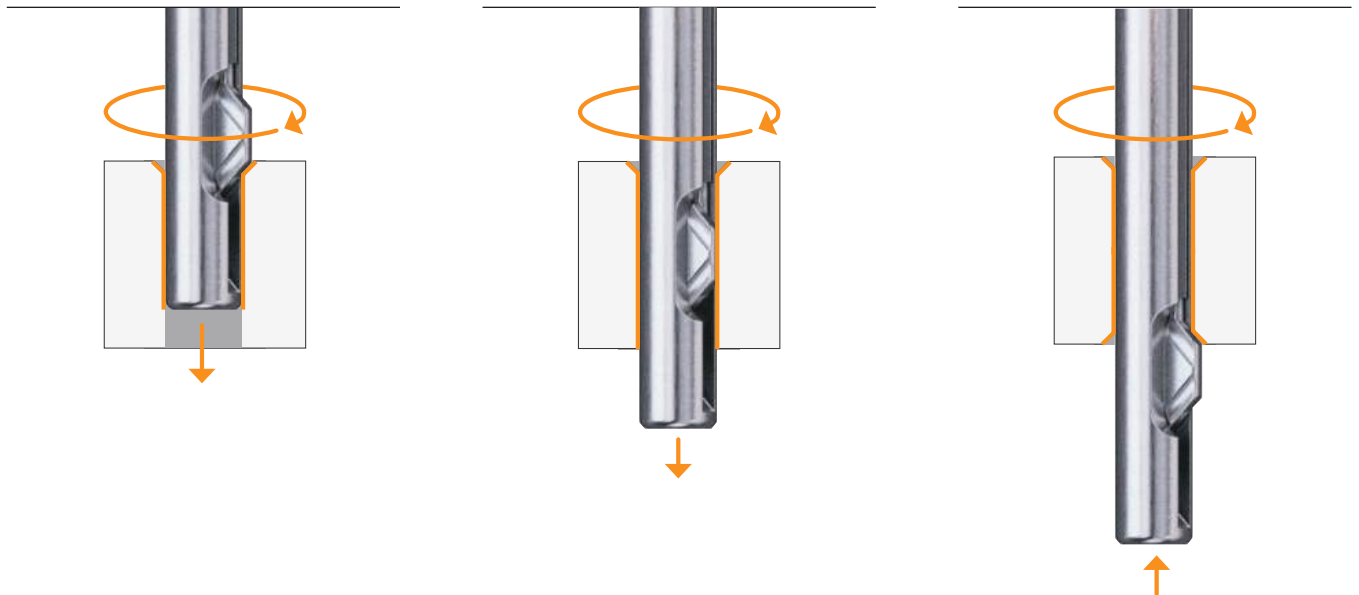
UBURR sets a new standard in deburring efficiency and excellence.

In the realm of machining and manufacturing, deburring tools play a crucial role, ensuring that drilled holes are clean, smooth, and free from any unwanted burrs that could affect performance or aesthetics.

UBURR

HOW DOES THE UBURR WORK?

- 1** Upon insertion, the replaceable cutting blade is initially held in the extended position, effectively eliminating the burr on the front side of the hole.
- 2** As the cutting tool encounters increased feed pressure, surpassing the preset spring tension, the blade automatically retracts while passing through the pilot-hole. The unique geometry of the blade ensures no scratches occurs on the inner surface of the pilot-hole threaded or drilled.
- 3** Upon exiting the pilot-hole, spring tension once again triggers the blade to extend, effectively removing the burr on the back side of the hole during the return stroke.



UBURR MAIN BENEFITS

OPERATIONAL EXCELLENCE

AUTOMATED EFFICIENCY:

- Achieve seamless production with single-pass automatic deburring of both front and rear hole edges, eliminating the need for manual intervention.

PRECISION PERFORMANCE:

- Consistently deliver high-quality deburring results at any production volume.

PREMIUM CONSTRUCTION:

- Manufactured from Precipitation Hardened AISI 17-4 PH for outstanding durability and dependable performance.

UBURR

MAIN BENEFITS

VERSATILE APPLICATION

UNIVERSAL COMPATIBILITY:

- Operates effectively with both CNC machines and electric hand drills.

ADAPTIVE DESIGN:

- A single holder supports multiple pilot diameters, reducing the need for extensive tool inventory.

COMPREHENSIVE MATERIAL AND GEOMETRICAL SUPPORT:

- The blades are available in HSS or Solid Carbide, with TiAlN PVD coated or uncoated blades and 3 types of chip formers, for efficient processing of various materials.



SMART DESIGN FEATURES

PLUG-AND-PLAY CONVENIENCE:

- No blade adjustments required, saving time and ensuring consistent, repeatable results.

PROTECTIVE GEOMETRY:

- Specialized blade design prevents scratches on drilled or threaded surfaces.

SIMPLIFIED MAINTENANCE:

- Quick and intuitive blade replacement minimizes downtime.

EFFICIENT INVENTORY MANAGEMENT:

- Only three blade types needed for all hole diameters.

CUSTOMIZABLE SOLUTIONS:

- Tailored configurations available to meet specific production needs.

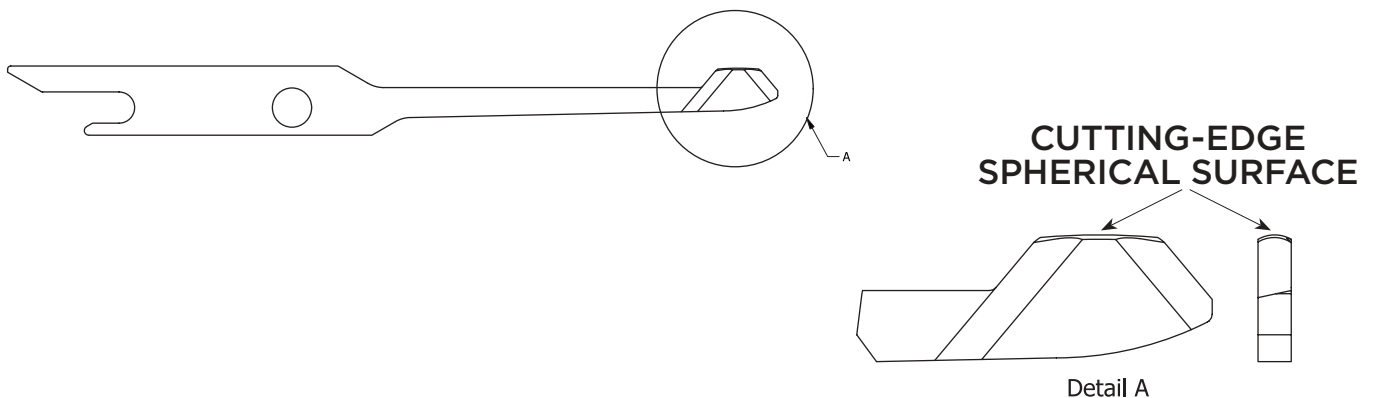
UBURR

BLADE FEATURES:

Our high-precision blades, made of High-Speed Steel (HSS) and Solid-Carbide, offer toughness and durability, enabling them to withstand high impact loads and shock during machining processes. This enhances tool reliability and minimizes the risk of tool breakage or chipping, while also exhibiting excellent resistance to wear and abrasion. They can withstand prolonged use without significant deterioration in cutting performance, extending tool life and reducing the frequency of tool replacements.

The blade's unique geometry is engineered to prevent damage to the inner surfaces of the hole while entering it, maintaining the integrity of the workpiece with every pass, and featuring a unique spherical surface.

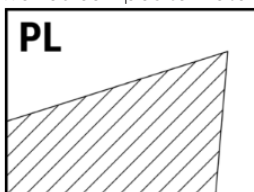
UBURR BLADE CUTTING-EDGE GEOMETRY



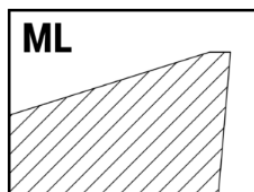
UBURR blades are available in Type 2.5, 3 and Type 5 sizes, with each type offering PL, ML or HL chip-formers, coated with TiAlN or uncoated.

AVAILABLE CHIP-FORMERS

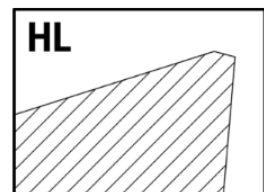
PL
POSITIVE CUTTING LAND
Suitable for all-round purpose and
ISO, P, M, K, N, S,
as well as composite materials



ML
MODERATE CUTTING LAND
Suitable for ISO, P, M, K, S, H.
materials



HL
NEGATIVE CUTTING LAND
Suitable for ISO, P, M, K, S, H.
materials



UBURR

BLADE FEATURES:

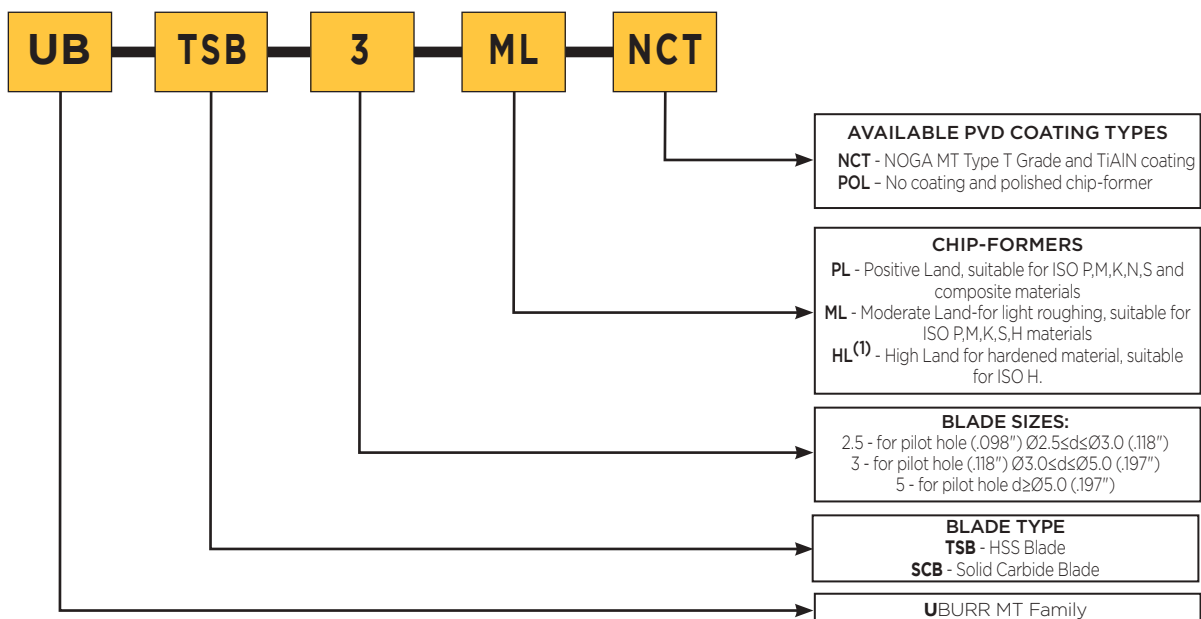
Each blade (except size 2.5) comes with an rMQR rectangular engraved laser code for technical information, including machining guidelines and cutting parameters.



Download the QRBOT app to scan the Rectangular Micro QR Code (rMQR) and access the UBURR machining guidelines.



UBURR BLADES CODING SYSTEM SPECIFICATIONS AND IDENTIFICATION:

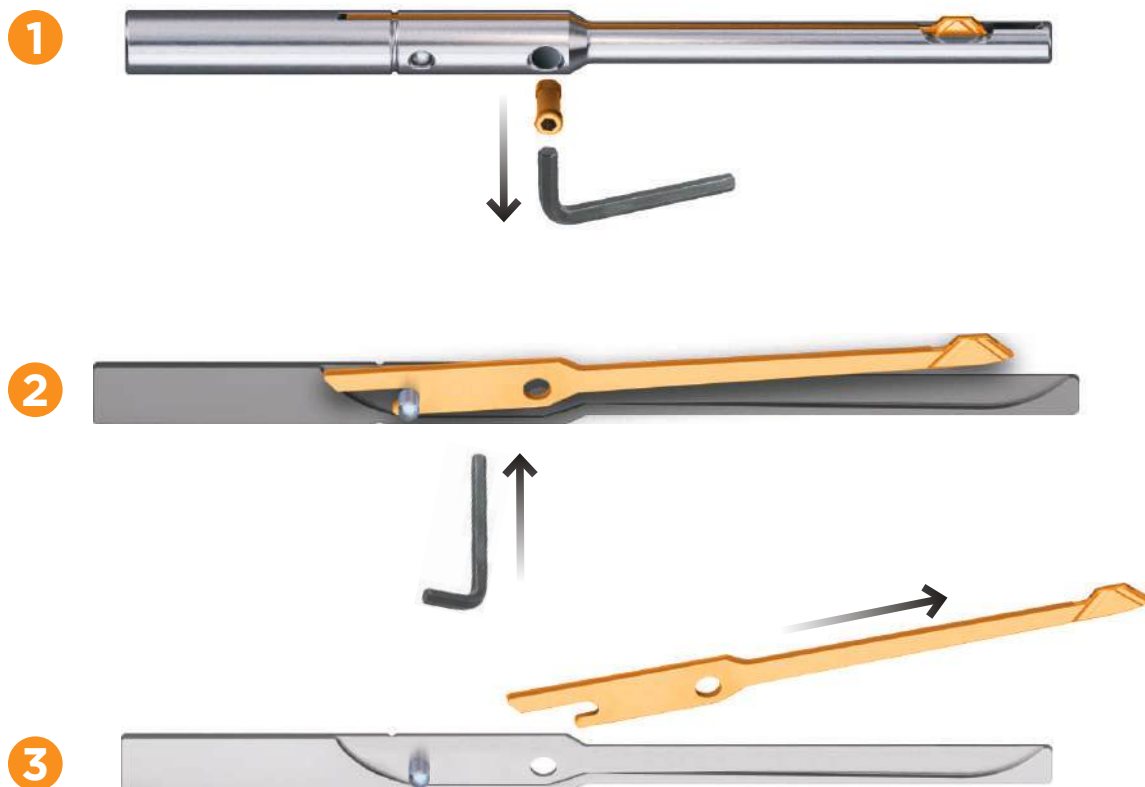


⁽¹⁾ Available only as special

UBURR

BLADE REMOVAL

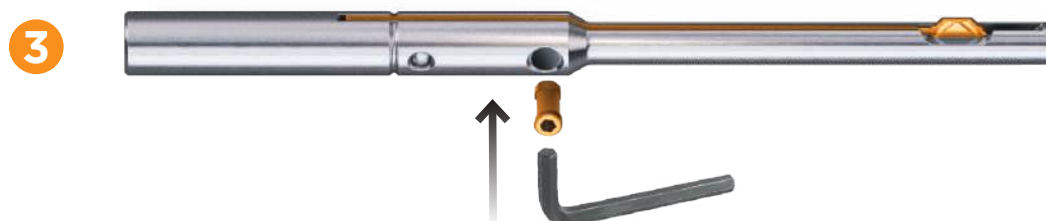
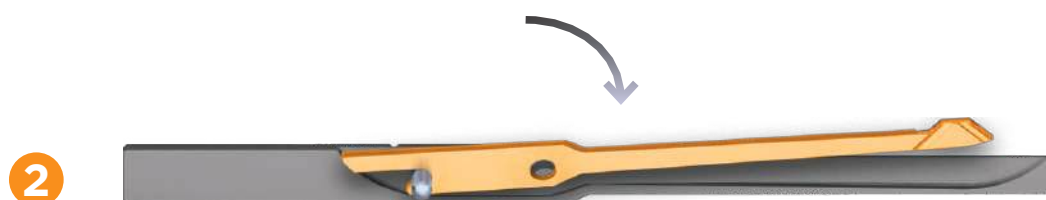
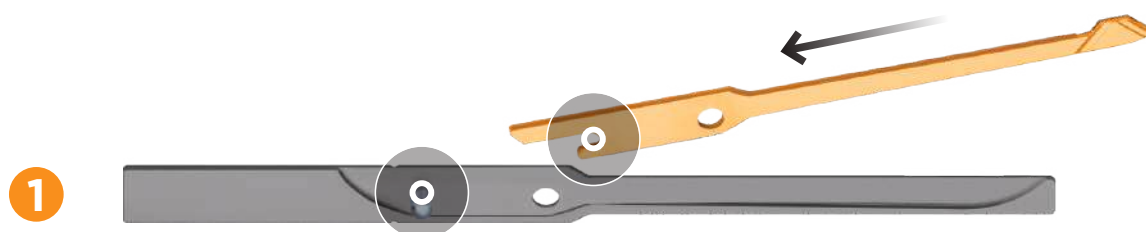
- 1 Remove the blade: Unlock the screw using an Allen key with a counterclockwise turn of the locking screw.
- 2 Push the blade by hexagon key through.
- 3 Pull up the blade from the holder.



UBURR

BLADE INSERTION

- 1 Insert the blade into the holder slot.
- 2 Push the blade into the tool pocket.
- 3 Lock the screw clockwise.



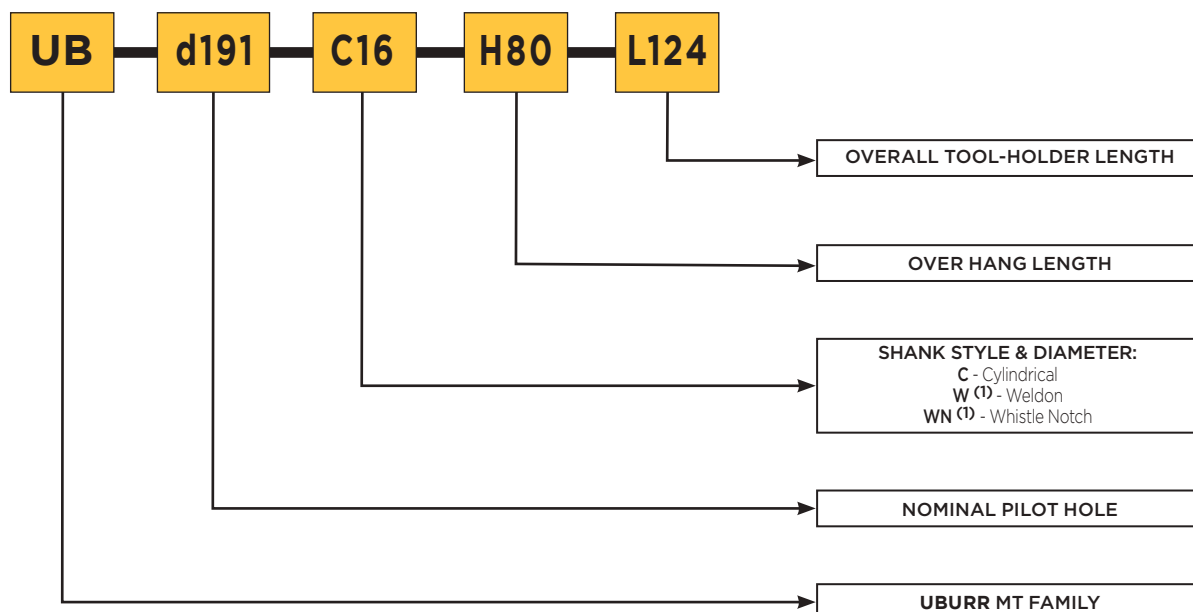
UBURR

UBURR BLADES SPECIFICATIONS TABLE

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

UBURR TOOL-HOLDERS CODING SYSTEM SPECIFICATIONS AND IDENTIFICATION:



⁽¹⁾ Available only as special

UBURR

TOOL-HOLDER FEATURES

UBURR tool-holders bearing the **DURASHIELD** mark deliver premium performance in demanding manufacturing environments. Each tool represents the pinnacle of precision engineering and reliability, manufactured from Precipitation Hardened AISI 17-4 PH for outstanding durability and performance.



UBURR TOOL-HOLDER RANGE

The **UBURR** standard tool series covers a wide range of pilot holes from Ø2.5 to Ø25mm (0.098 to 0.984”) with 0.5mm (.0197”) increments.

SUPERIOR STRENGTH: Engineered to handle heavy loads and demanding machining operations with consistent performance.

MAXIMUM TOUGHNESS: Maintains reliable operation under the most challenging industrial conditions.

ENHANCED WEAR RESISTANCE: Extended tool life significantly reduces operational costs and maintenance requirements.

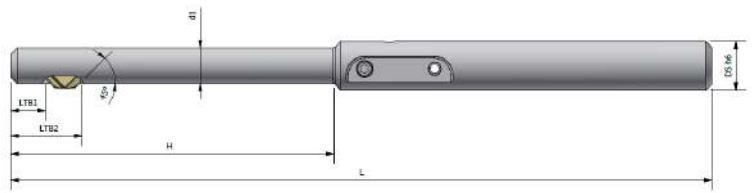
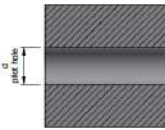
PRECISION MACHINABILITY: Designed for optimal accuracy and consistent performance.

THERMAL STABILITY: Maintains structural integrity and precision even at elevated temperatures.

ADVANCED CORROSION PROTECTION: Features a specialized passivation process that provides superior protection without additional coatings.

ENVIRONMENTAL INNOVATION: The eco-friendly manufacturing process eliminates the need for additional protective layers while delivering superior performance in all working conditions.

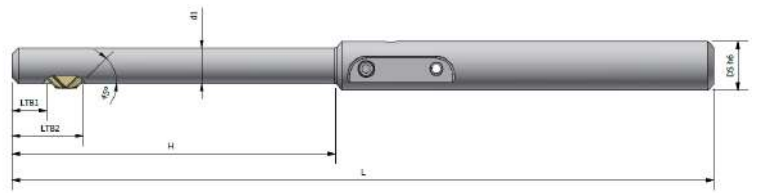
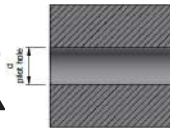
UBURR



UBURR TOOL-HOLDERS (mm)

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	DESCRIPTION TOOL-HOLDER	+	SKU BLADE	=	DESCRIPTION SET	SKU SET	ØDS h6	LTB1 ⁽²⁾	LTB2 ⁽²⁾	H	L
2.50-3.00	UB1025	UB-d025-C08-H29-L69	+	UB2020 ⁽¹⁾	=	UBS-d025-C08-H29-L69	UB2500	8	N/A	7	29	69
3.00-3.50	UB1030	UB-d030-C08-H29-L85	+	UB2030	=	UBS-d030-C08-H29-L85	UB3000	8	4	10	29	85
3.50-4.00	UB1035	UB-d035-C08-H29-L85	+	UB2030	=	UBS-d035-C08-H29-L85	UB3001	8	4	10	29	85
4.00-4.50	UB1040	UB-d040-C08-H29-L85	+	UB2030	=	UBS-d040-C08-H29-L85	UB3002	8	4	10	29	85
4.50-5.00	UB1045	UB-d045-C08-H29-L85	+	UB2030	=	UBS-d045-C08-H29-L85	UB3003	8	4	10	29	85
5.00-5.50	UB1050	UB-d050-C08-H53-L115	+	UB2060	=	UBS-d050-C08-H53-L115	UB3004	8	4	12	53	115
5.50-6.00	UB1055	UB-d055-C08-H53-L115	+	UB2060	=	UBS-d055-C08-H53-L115	UB3005	8	4	12	53	115
6.00-6.50	UB1060	UB-d060-C08-H53-L115	+	UB2060	=	UBS-d060-C08-H53-L115	UB3006	8	4	12	53	115
6.50-7.00	UB1065	UB-d065-C08-H53-L115	+	UB2060	=	UBS-d065-C08-H53-L115	UB3007	8	4	12	53	115
7.00-7.50	UB1070	UB-d070-C08-H53-L115	+	UB2060	=	UBS-d070-C08-H53-L115	UB3008	8	4	12	53	115
7.50-8.00	UB1075	UB-d075-C08-H53-L115	+	UB2060	=	UBS-d075-C08-H53-L115	UB3009	8	4	12	53	115
8.00-8.50	UB1080	UB-d080-C10-H53-L115	+	UB2060	=	UBS-d080-C10-H53-L115	UB3010	10	4	12	53	115
8.50-9.00	UB1085	UB-d085-C10-H53-L115	+	UB2060	=	UBS-d085-C10-H53-L115	UB3011	10	4	12	53	115
9.00-9.50	UB1090	UB-d090-C10-H53-L115	+	UB2060	=	UBS-d090-C10-H53-L115	UB3012	10	4	12	53	115
9.50-10.00	UB1095	UB-d095-C10-H53-L115	+	UB2060	=	UBS-d095-C10-H53-L115	UB3013	10	4	12	53	115
10.00-10.50	UB1100	UB-d100-C10-H80-L125	+	UB2060	=	UBS-d100-C10-H80-L125	UB3014	10	4	12	80	125
10.50-11.00	UB1105	UB-d105-C10-H80-L125	+	UB2060	=	UBS-d105-C10-H80-L125	UB3015	10	4	12	80	125
11.00-11.50	UB1110	UB-d110-C10-H80-L125	+	UB2060	=	UBS-d110-C10-H80-L125	UB3016	10	4	12	80	125
11.50-12.00	UB1115	UB-d115-C12-H80-L125	+	UB2060	=	UBS-d115-C12-H80-L125	UB3017	12	4	12	80	125
12.00-12.50	UB1120	UB-d120-C12-H80-L125	+	UB2060	=	UBS-d120-C12-H80-L125	UB3018	12	4	12	80	125
12.50-13.00	UB1125	UB-d125-C12-H80-L125	+	UB2060	=	UBS-d125-C12-H80-L125	UB3019	12	4	12	80	125
13.00-13.50	UB1130	UB-d130-C12-H80-L125	+	UB2060	=	UBS-d130-C12-H80-L125	UB3020	12	4	12	80	125
13.50-14.00	UB1135	UB-d135-C12-H80-L125	+	UB2060	=	UBS-d135-C12-H80-L125	UB3021	12	4	12	80	125
14.00-14.50	UB1140	UB-d140-C12-H80-L125	+	UB2060	=	UBS-d140-C12-H80-L125	UB3022	12	4	12	80	125
14.50-15.00	UB1145	UB-d145-C12-H80-L125	+	UB2060	=	UBS-d145-C12-H80-L125	UB3023	12	4	12	80	125
15.00-15.50	UB1150	UB-d150-C12-H80-L125	+	UB2060	=	UBS-d150-C12-H80-L125	UB3024	12	4	12	80	125
15.50-16.00	UB1155	UB-d155-C12-H80-L125	+	UB2060	=	UBS-d155-C12-H80-L125	UB3025	12	4	12	80	125
16.00-16.50	UB1160	UB-d160-C16-H80-L125	+	UB2060	=	UBS-d160-C16-H80-L125	UB3026	16	4	12	80	125
16.50-17.00	UB1165	UB-d165-C16-H80-L125	+	UB2060	=	UBS-d165-C16-H80-L125	UB3027	16	4	12	80	125
17.00-17.50	UB1170	UB-d170-C16-H80-L125	+	UB2060	=	UBS-d170-C16-H80-L125	UB3028	16	4	12	80	125
17.50-18.00	UB1175	UB-d175-C16-H80-L125	+	UB2060	=	UBS-d175-C16-H80-L125	UB3029	16	4	12	80	125
18.00-18.50	UB1180	UB-d180-C16-H80-L125	+	UB2060	=	UBS-d180-C16-H80-L125	UB3030	16	4	12	80	125
18.50-19.00	UB1185	UB-d185-C16-H80-L125	+	UB2060	=	UBS-d185-C16-H80-L125	UB3031	16	4	12	80	125
19.00-19.50	UB1190	UB-d190-C16-H80-L125	+	UB2060	=	UBS-d190-C16-H80-L125	UB3032	16	4	12	80	125
19.50-20.00	UB1195	UB-d195-C20-H80-L125	+	UB2060	=	UBS-d195-C20-H80-L125	UB3033	20	4	12	80	125
20.00-20.50	UB1200	UB-d200-C20-H80-L125	+	UB2060	=	UBS-d200-C20-H80-L125	UB3034	20	4	12	80	125
20.50-21.00	UB1205	UB-d205-C20-H80-L125	+	UB2060	=	UBS-d205-C20-H80-L125	UB3035	20	4	12	80	125
21.00-21.50	UB1210	UB-d210-C20-H80-L125	+	UB2060	=	UBS-d210-C20-H80-L125	UB3036	20	4	12	80	125

UBURR



UBURR TOOL-HOLDERS (mm)

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	DESCRIPTION TOOL-HOLDER	+	SKU BLADE	=	DESCRIPTION SET	SKU SET	ØDS h6	LTB1 ⁽²⁾	LTB2 ⁽²⁾	H	L
21.50-22.00	UB1215	UB-d215-C20-H80-L125	+	UB2060	=	UBS-d215-C20-H80-L125	UB3037	20	4	12	80	125
22.00-22.50	UB1220	UB-d220-C20-H80-L125	+	UB2060	=	UBS-d220-C20-H80-L125	UB3038	20	4	12	80	125
22.50-23.00	UB1225	UB-d225-C20-H80-L125	+	UB2060	=	UBS-d225-C20-H80-L125	UB3039	20	4	12	80	125
23.00-23.50	UB1230	UB-d230-C20-H80-L125	+	UB2060	=	UBS-d230-C20-H80-L125	UB3040	20	4	12	80	125
23.50-24.00	UB1235	UB-d235-C20-H80-L125	+	UB2060	=	UBS-d235-C20-H80-L125	UB3041	20	4	12	80	125
24.00-24.50	UB1240	UB-d240-C20-H80-L125	+	UB2060	=	UBS-d240-C20-H80-L125	UB3042	20	4	12	80	125
24.50-25.00	UB1245	UB-d245-C20-H80-L125	+	UB2060	=	UBS-d245-C20-H80-L125	UB3043	20	4	12	80	125
25.00-25.50	UB1250	UB-d250-C20-H80-L125	+	UB2060	=	UBS-d250-C20-H80-L125	UB3044	20	4	12	80	125

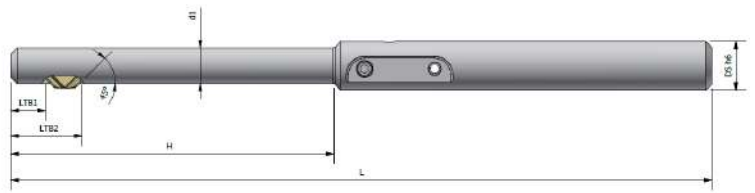
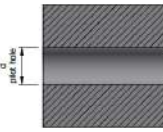
(1) The **UB2020** blade is designed only for back deburring.

(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

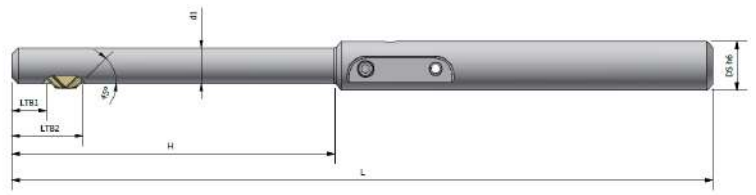
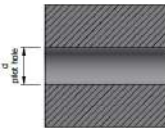
UBURR



UBURR TOOL-HOLDERS (Inch)

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	DESCRIPTION TOOL-HOLDER	+	SKU BLADE	=	DESCRIPTION SET	SKU SET	ØDS h6	LTB1 ⁽²⁾	LTB2 ⁽²⁾	H	L
0.098-0.118	UB1025	UB-d025-C08-H29-L69	+	UB2020 ⁽¹⁾	=	UBS-d025-C08-H29-L69	UB2500	0.315	N/A	0.276	1.142	2.717
0.118-0.138	UB1030	UB-d030-C08-H29-L85	+	UB2030	=	UBS-d030-C08-H29-L85	UB3000	0.315	0.157	0.394	1.142	3.35
0.138-0.157	UB1035	UB-d035-C08-H29-L85	+	UB2030	=	UBS-d035-C08-H29-L85	UB3001	0.315	0.157	0.394	1.142	3.35
0.157-0.177	UB1040	UB-d040-C08-H29-L85	+	UB2030	=	UBS-d040-C08-H29-L85	UB3002	0.315	0.157	0.394	1.142	3.35
0.177-0.197	UB1045	UB-d045-C08-H29-L85	+	UB2030	=	UBS-d045-C08-H29-L85	UB3003	0.315	0.157	0.394	1.142	3.35
0.197-0.217	UB1050	UB-d050-C08-H53-L85	+	UB2060	=	UBS-d050-C08-H29-L85	UB3004	0.315	0.157	0.472	2.087	4.53
0.217-0.236	UB1055	UB-d055-C08-H53-L115	+	UB2060	=	UBS-d055-C08-H53-L115	UB3005	0.315	0.157	0.472	2.087	4.53
0.236-0.256	UB1060	UB-d060-C08-H53-L115	+	UB2060	=	UBS-d060-C08-H53-L115	UB3006	0.315	0.157	0.472	2.087	4.53
0.256-0.276	UB1065	UB-d065-C08-H53-L115	+	UB2060	=	UBS-d065-C08-H53-L115	UB3007	0.315	0.157	0.472	2.087	4.53
0.276-0.295	UB1070	UB-d070-C08-H53-L115	+	UB2060	=	UBS-d070-C08-H53-L115	UB3008	0.315	0.157	0.472	2.087	4.53
0.295-0.315	UB1075	UB-d075-C08-H53-L115	+	UB2060	=	UBS-d075-C08-H53-L115	UB3009	0.315	0.157	0.472	2.087	4.53
0.315-0.335	UB1080	UB-d080-C08-H53-L115	+	UB2060	=	UBS-d080-C08-H53-L115	UB3010	0.394	0.157	0.472	2.087	4.53
0.335-0.354	UB1085	UB-d085-C08-H53-L115	+	UB2060	=	UBS-d085-C08-H53-L115	UB3011	0.394	0.157	0.472	2.087	4.53
0.354-0.374	UB1090	UB-d090-C08-H53-L115	+	UB2060	=	UBS-d090-C08-H53-L115	UB3012	0.394	0.157	0.472	2.087	4.53
0.374-0.394	UB1095	UB-d095-C08-H53-L115	+	UB2060	=	UBS-d095-C08-H53-L115	UB3013	0.394	0.157	0.472	2.087	4.53
0.394-0.413	UB1100	UB-d100-C10-H80-L125	+	UB2060	=	UBS-d100-C10-H80-L125	UB3014	0.394	0.157	0.472	3.15	4.92
0.413-0.433	UB1105	UB-d105-C10-H80-L125	+	UB2060	=	UBS-d105-C10-H80-L125	UB3015	0.394	0.157	0.472	3.15	4.92
0.433-0.453	UB1110	UB-d110-C10-H80-L125	+	UB2060	=	UBS-d110-C10-H80-L125	UB3016	0.394	0.157	0.472	3.15	4.92
0.453-0.472	UB1115	UB-d115-C12-H80-L125	+	UB2060	=	UBS-d115-C12-H80-L125	UB3017	0.472	0.157	0.472	3.15	4.92
0.472-0.492	UB1120	UB-d120-C12-H80-L125	+	UB2060	=	UBS-d120-C12-H80-L125	UB3018	0.472	0.157	0.472	3.15	4.92
0.492-0.512	UB1125	UB-d125-C12-H80-L125	+	UB2060	=	UBS-d125-C12-H80-L125	UB3019	0.472	0.157	0.472	3.15	4.92
0.512-0.531	UB1130	UB-d130-C12-H80-L125	+	UB2060	=	UBS-d130-C12-H80-L125	UB3020	0.472	0.157	0.472	3.15	4.92
0.531-0.551	UB1135	UB-d135-C12-H80-L125	+	UB2060	=	UBS-d135-C12-H80-L125	UB3021	0.472	0.157	0.472	3.15	4.92
0.551-0.571	UB1140	UB-d140-C12-H80-L125	+	UB2060	=	UBS-d140-C12-H80-L125	UB3022	0.472	0.157	0.472	3.15	4.92
0.571-0.591	UB1145	UB-d145-C12-H80-L125	+	UB2060	=	UBS-d145-C12-H80-L125	UB3023	0.472	0.157	0.472	3.15	4.92
0.591-0.610	UB1150	UB-d150-C12-H80-L125	+	UB2060	=	UBS-d150-C12-H80-L125	UB3024	0.472	0.157	0.472	3.15	4.92
0.610-0.630	UB1155	UB-d155-C12-H80-L125	+	UB2060	=	UBS-d155-C12-H80-L125	UB3025	0.472	0.157	0.472	3.15	4.92
0.630-0.650	UB1160	UB-d160-C16-H80-L125	+	UB2060	=	UBS-d160-C16-H80-L125	UB3026	0.630	0.157	0.472	3.15	4.92
0.650-0.669	UB1165	UB-d165-C16-H80-L125	+	UB2060	=	UBS-d165-C16-H80-L125	UB3027	0.630	0.157	0.472	3.15	4.92
0.669-0.689	UB1170	UB-d170-C16-H80-L125	+	UB2060	=	UBS-d170-C16-H80-L125	UB3028	0.630	0.157	0.472	3.15	4.92
0.689-0.709	UB1175	UB-d175-C16-H80-L125	+	UB2060	=	UBS-d175-C16-H80-L125	UB3029	0.630	0.157	0.472	3.15	4.92
0.709-0.728	UB1180	UB-d180-C16-H80-L125	+	UB2060	=	UBS-d180-C16-H80-L125	UB3030	0.630	0.157	0.472	3.15	4.92
0.728-0.748	UB1185	UB-d185-C16-H80-L125	+	UB2060	=	UBS-d185-C16-H80-L125	UB3031	0.630	0.157	0.472	3.15	4.92
0.748-0.768	UB1190	UB-d190-C16-H80-L125	+	UB2060	=	UBS-d190-C16-H80-L125	UB3032	0.630	0.157	0.472	3.15	4.92
0.768-0.787	UB1195	UB-d195-C20-H80-L125	+	UB2060	=	UBS-d195-C20-H80-L125	UB3033	0.787	0.157	0.472	3.15	4.92
0.787-0.807	UB1200	UB-d200-C20-H80-L125	+	UB2060	=	UBS-d200-C20-H80-L125	UB3034	0.787	0.157	0.472	3.15	4.92
0.807-0.827	UB1205	UB-d205-C20-H80-L125	+	UB2060	=	UBS-d205-C20-H80-L125	UB3035	0.787	0.157	0.472	3.15	4.92
0.827-0.846	UB1210	UB-d210-C20-H80-L125	+	UB2060	=	UBS-d210-C20-H80-L125	UB3036	0.787	0.157	0.472	3.15	4.92

UBURR



UBURR TOOL-HOLDERS (Inch) cont'd.

Ød min. PILOT HOLE RANGE	SKU TOOL- HOLDER	DESCRIPTION TOOL-HOLDER	+	SKU BLADE	=	DESCRIPTION SET	SKU SET	ØDS h6	LTB1 ⁽²⁾	LTB2 ⁽²⁾	H	L
0.846-0.866	UB1215	UB-d215-C20-H80-L125	+	UB2060	=	UBS-d215-C20-H80-L125	UB3037	0.787	0.157	0.472	3.15	4.92
0.866-0.886	UB1220	UB-d220-C20-H80-L125	+	UB2060	=	UBS-d220-C20-H80-L125	UB3038	0.787	0.157	0.472	3.15	4.92
0.886-0.906	UB1225	UB-d225-C20-H80-L125	+	UB2060	=	UBS-d225-C20-H80-L125	UB3039	0.787	0.157	0.472	3.15	4.92
0.906-0.925	UB1230	UB-d230-C20-H80-L125	+	UB2060	=	UBS-d230-C20-H80-L125	UB3040	0.787	0.157	0.472	3.15	4.92
0.925-0.945	UB1235	UB-d235-C20-H80-L125	+	UB2060	=	UBS-d235-C20-H80-L125	UB3041	0.787	0.157	0.472	3.15	4.92
0.945-0.965	UB1240	UB-d240-C20-H80-L125	+	UB2060	=	UBS-d240-C20-H80-L125	UB3042	0.787	0.157	0.472	3.15	4.92
0.965-0.984	UB1245	UB-d245-C20-H80-L125	+	UB2060	=	UBS-d245-C20-H80-L125	UB3043	0.787	0.157	0.472	3.15	4.92
0.984-1.004	UB1250	UB-d250-C20-H80-L125	+	UB2060	=	UBS-d250-C20-H80-L125	UB3044	0.787	0.157	0.472	3.15	4.92

(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



For additional details about our UBURR line, including the complete product range and technical guidelines, please visit our website at: <https://nogamt.com/products/uburr-2/>

CUTTING RECOMMENDATIONS

The table shown on page 54-55 presents cutting recommendations, outlining initial feed rates and cutting speed for materials group based on ISO 513 and VDI 3323 standards.

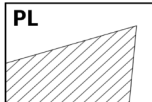
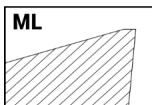
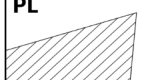
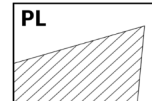
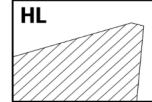
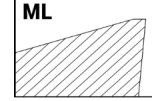
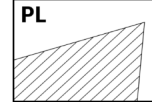
(1) To ensure optimal performance and tool-life under varying conditions:

- For moderate tool-holder or workpiece stability, consider reducing feed rates by up to 10%.
- For poor tool-holder or workpiece stability, it's advisable to decrease feed rates by up to 30%.

Additionally, the operator must ensure the utilization of appropriate coolant media directed to the cutting tip of the blade and right-hand machining (clockwise).

CUTTING RECOMMENDATIONS

ISO	MATERIAL		CONDITION	As is AISI/SAE/ASTM	DIN W.-Nr.	
P	Non-Alloy Steel and Cast Steel Free Cutting Steel	<0.25%C	Annealed	1020	1.0044	
		≥0.25%C	Annealed	1035	1.0501	
		<0.55%C	Quenched and tempered	1045	1.1201	
		≥0.55%C	Annealed	1055	1.0535	
			Quenched and tempered	1060	1.1221	
	Low Alloy and Cast Steel (less than 5% of Alloying Elements)		Annealed	G92600	1.5028	
			Quenched and Tempered	4130	1.7218	
				4142	1.2332	
				5045	1.7006	
	High-Alloy Steel, Cast Steel and Tool Steel		Annealed	H13	1.2344	
Quenched and Tempered			M33	1.3249		
Stainless Steel, Cast Steel		Ferritic / Martensitic	420	1.4021		
		Martensitic				
M	Stainless Steel, Cast Steel		Austenitic, Duplex	304L	1.4306	
K	Grey Cast Iron (GG)		Ferritic / Pearlitic	Class 25	0.6015	
			Pearlitic / Martensitic	Grade H20	0.36037	
	Nodular Cast Iron (GGG)		Ferritic	60-40-18	0.7043	
			Pearlitic	F33500	0.7050	
	Malleable Cast Iron		Ferritic	A47	0.8135	
Pearlitic			A220 Class	0.8155		
N	Aluminum - Wrought Alloys		Not Hardenable	5005	3.3315	
			Hardenable	7075	3.4365	
	Aluminum - Cast Alloys		<12%Si	Not Hardenable	518	3.3292
			>12%Si	Hardenable	515	3.3241
	Copper Alloys		≥ 1% Pb	High Temperature	390	
				Free Cutting	C36000	2.0375
				Brass	C22000	2.0230
				Electrolytic Copper	C63000	2.0966
	Non Metallic		Duroplastics, Fiber Plastics	Bakelite		
			Hard Rubber	Ebonite		
S	High Temperature Alloys	Fe based	Annealed	330	1.4864	
			Hardened	S590	1.4977	
		Ni or Co based	Annealed	Inconel 825	2.4858	
			Hardened	Inconel 718	2.4668	
			Cast	Nimocast K24	2.4674	
	Titanium Alloys		Pure	Titanium G.1	3.7024	
			Alpha+Beta Alloys, Hardened	Titanium G.5	3.7165	
H	Hardened steel		Hardened	HARDOX 500		
			Hardened	HARDOX EXTREME		
	Chilled Cast Iron		Cast	A532 IIIA 25% Cr	0.9650	
	Cast Iron		Hardened	A532 IIID 20% CrMo	0.9645	
C	Carbon Fiber Re-inforced Plastics (CFRP)		Cured	—		
	Glass Fiber Re-inforced Plastics (GFRP)					

	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			