

**Recommended Starting Speeds and Feeds
For Michigan Deburring Tools**

All measurements are in inches

Material	SFM	Feed (IPR)
Free Machining	75-125	.004 - .010
Aluminum	90-150	.004 - .010
Cast Iron	70-110	.004 - .010
Low Carbon	60-100	.004 - .010
Med Carbon	45-80	.004 - .010
Stainless	20-40	.004 - .010
High Alloy Steel	25-50	.004 - .010

Material, speed (RPM), and feed rate are some of the variables which can affect the performance of our tools. Other variables include burr condition, tool holding, type of coolant used, proper coolant penetration, proper workholding/ stability of the part being deburred and blade settings. A general rule is to set the RPM of our tools at the same speed you would set a high speed steel drill of the same diameter. Then, alter the feed rate and blade elevation to achieve the desired results. Chamfers can range between a minimal edge break, to a large chamfer for tapping purposes. Raising the blade elevation may allow for a higher feed rate, and can also be used to compensate for blade dulling.