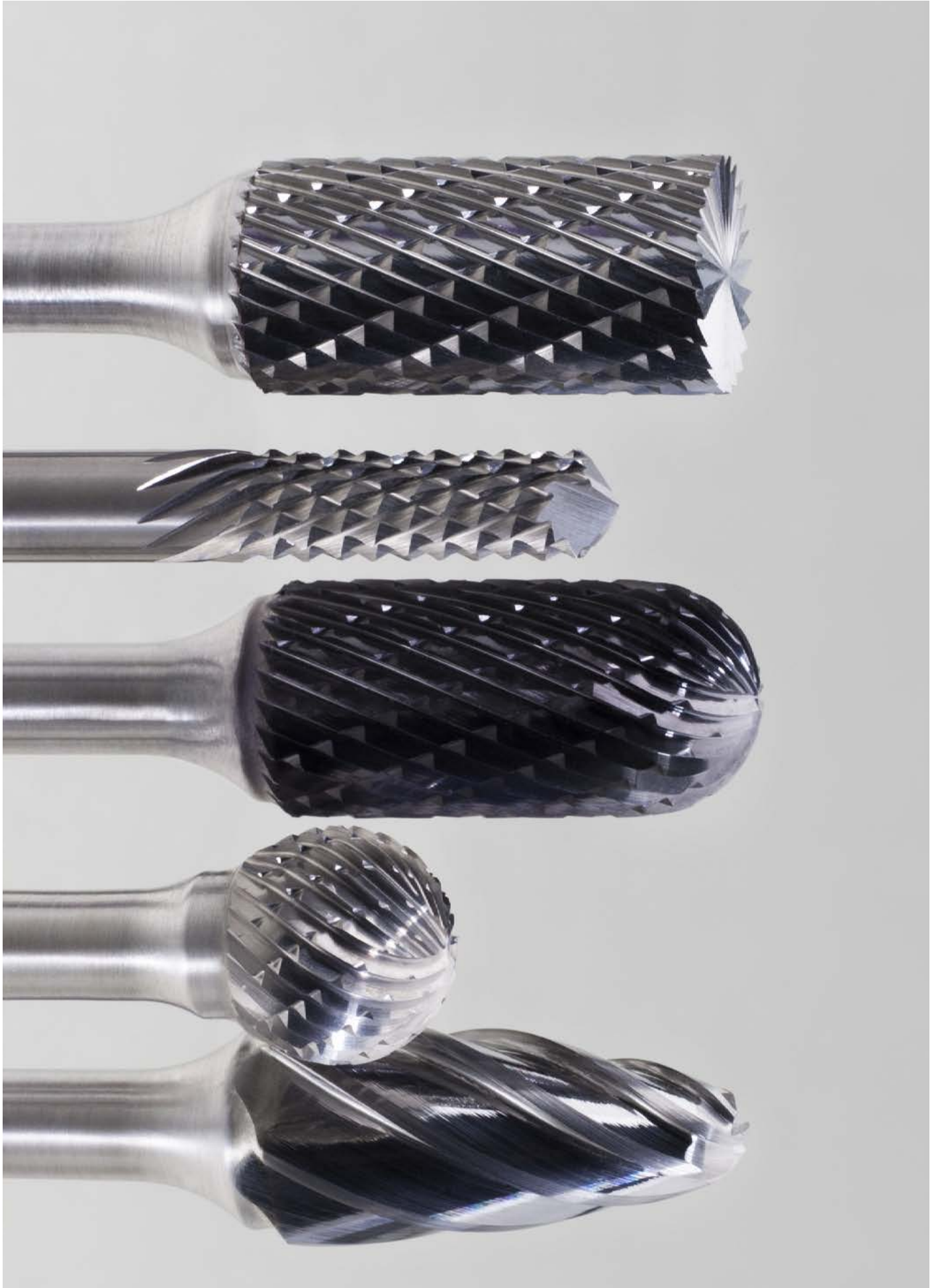


**DORMER**

# Carbide Rotary Burrs

Expanded range 2016





## INTRODUCTION

Dormer's range of carbide burrs is a high quality and comprehensive program. This includes a variety of designs and shapes to offer an ideal option for the majority of applications in all major industry segments.

## FEATURES AND BENEFITS

- The combination of premium grade materials for both the shank and head, with the precise production process, results in the creation of a consistent and secure program of tools.

**NEW**

- New material specific designs offer improved performance and up to 50% higher metal removal rates over standard carbide burrs.

## SHANK

- Toughened and hardened steel shanks
- Provides rigidity and strength
- Prevents bending and reduces vibrations
- Resulting in improved tool life
- Ground to h6 (carbide) and h7 (steel) for improved holding

## BRAZING

- Special brazing elements provide excellent braze strength
- Excellent impact strength able to withstand high forces
- Able to withstand higher temperature without failing

## CUT STYLES



**NEW**

**ST**

### ST CUT

First choice for high performance machining of **Steels**

- Material specific chip breaker design for higher machining output on steel parts
- Positive geometry, ensures smooth surface finish
- Creates less temperature which helps increase tool life



**NEW**

**VA**

### VA CUT

First choice for high performance machining of **Stainless Steels**

- Sharp cutting geometry, reducing the onset of work-hardening
- Increases metal removal rate



**AL**

### ALUMINIUM CUT

First choice for **non ferrous materials and plastics**

- High helix and large flute volume for rapid metal removal



**BALL NOSE GEOMETRY**

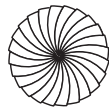
- Skip flute grinding
- Increased strength at the centre
- Reduced chance of swarf congestion
- Improved cutting action closer to the centre

**TiAIN COATING**

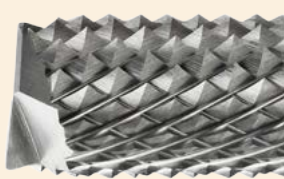
- Increased tool life in difficult conditions
- Reduced friction improves swarf evacuation
- Helps resist “built-up edge” common with cutting tools with small flute volumes



Skip



Normal



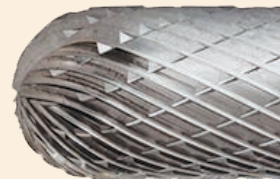
**NEW**

**GRP**

**GRP CUT**

First choice for machining **Fibre Glass and composite materials**

- Available with Drill Point and End Mill styles
- Designed to reduce splintering and improve entry and exit surface quality



**DC**

**DOUBLE CUT**

First choice for **general machining**

- Improves ease of control
- Increases metal removal rate

## Recommended Speed [RPM]

### DC and AL type

AMG		ISO	d <sub>1</sub> Ø [mm]							
			3	6	8	10	12	16	20	
1.1 – 1.5	Steels up to 1200 N/mm <sup>2</sup>	P	64 000	32 000	24 000	20 000	16 000	12 000	10 000	min
			83 000	42 000	32 000	25 000	21 000	16 000	13 000	max
1.6 – 1.8	Steels > 1200 N/mm <sup>2</sup> Hardened Steels < 63HRc	H	51 000	26 000	20 000	16 000	13 000	10 000	8 000	min
			71 000	36 000	27 000	22 000	18 000	14 000	11 000	max
2	Stainless Steel	M	45 000	23 000	17 000	14 000	12 000	9 000	7 000	min
			64 000	32 000	24 000	20 000	16 000	12 000	10 000	max
3	Cast Iron	K	58 000	29 000	22 000	18 000	15 000	11 000	9 000	min
			77 000	39 000	29 000	23 000	20 000	15 000	12 000	max
4	Titanium	S1	45 000	23 000	17 000	14 000	12 000	9 000	7 000	min
			58 000	29 000	22 000	18 000	15 000	11 000	9 000	max
5	Nickel	S1	45 000	23 000	17 000	14 000	12 000	9 000	7 000	min
			58 000	29 000	22 000	18 000	15 000	11 000	9 000	max
6	Copper	N	64 000	32 000	24 000	20 000	16 000	12 000	10 000	min
			71 000	36 000	27 000	22 000	18 000	14 000	11 000	max
7	Aluminium/Magnesium	N	71 000	36 000	27 000	22 000	18 000	14 000	11 000	min
			96 000	48 000	36 000	29 000	24 000	18 000	15 000	max
8	Synthetic materials	O	77 000	39 000	29 000	23 000	20 000	15 000	12 000	min
			96 000	48 000	36 000	29 000	24 000	18 000	15 000	max

### ST type

AMG		ISO	Range	d <sub>1</sub> Ø [mm]			
				3	6	10	12
1	Steels	P	Max	100 000	65 000	55 000	35 000
			Low	60 000	45 000	30 000	20 000
			High	80 000	60 000	40 000	30 000

### VA type

AMG		ISO	Range	d <sub>1</sub> Ø [mm]			
				3	6	10	12
2	Stainless Steel	M	Max	100 000	65 000	55 000	35 000
			Low	60 000	30 000	20 000	15 000
			High	80 000	45 000	30 000	22 000

### GRP type

AMG		ISO	Range	d <sub>1</sub> Ø [mm]					
				2	3	4	6	10	12
8	Synthetic materials	O	Low	40 000	25 000	20 000	20 000	15 000	10 000
			High	45 000	30 000	25 000	25 000	20 000	15 000

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	
	A	A	A	A	A	B	B	B	B	C	C	C	C	C	D	D	
		TiAlN					TiAlN				TiAlN					TiAlN	
	DC	DC	ST	VA	AL	DC	DC	ST	AL	DC	DC	ST	VA	AL	DC	DC	
	P801	P801C	P701	P601	P831	P803	P803C	P703	P833	P805	P805C	P705	P605	P835	P807	P807C	
∅ [mm]	3.00 16.00	3.00 12.70	6.00 12.70	3.00 12.70	6.00 12.70	3.00 16.00	3.00 12.70	6.00 12.70	6.00 12.70	3.00 16.00	3.00 12.70	6.00 12.70	3.00 12.70	6.00 12.70	3.00 16.00	3.00 12.70	
			<b>NEW</b>	<b>NEW</b>				<b>NEW</b>				<b>NEW</b>	<b>NEW</b>				
AMG	8	8	9	9	9	10	10	11	11	12	12	13	13	13	14	14	
1.1	■	■	■			■	■	■		■	■	■			■	■	P1
1.2	■	■	■			■	■	■		■	■	■			■	■	P1
1.3	■	■	■			■	■	■		■	■	■			■	■	P2
1.4	■	■	■			■	■	■		■	■	■			■	■	P3
1.5	■	■	■			■	■	■		■	■	■			■	■	P4
1.6	■	■	■			■	■	■		■	■	■			■	■	H1
1.7	■	■	■			■	■	■		■	■	■			■	■	H3
1.8	■	■	■			■	■	■		■	■	■			■	■	H4
2.1	■	■	■	■	●	■	■	■	●	■	■	■	■	●	■	■	M1
2.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	M3
2.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	M2
2.4	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	S2
3.1	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	K1
3.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	K2
3.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	K3
3.4	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	K4
4.1	■	■	■	■	●	■	■	■	●	■	■	■	■	●	■	■	S1
4.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	S2
4.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	S3
5.1	■	■	■	■	●	■	■	■	●	■	■	■	■	●	■	■	S1
5.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	S2
5.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	S3
6.1	●	●	■	■	■	●	●	■	●	●	●	■	■	●	●	■	N3
6.2	■	■	■	■	●	■	■	■	●	■	■	■	■	●	■	■	N4
6.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N3
6.4	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N4
7.1	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N1
7.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N1
7.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N1
7.4	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	N2
8.1	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	O
8.2	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	O
8.3	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	O
9.1	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	H
10.1	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■	O

■ Excellent for application      ● Good for application

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	
	D	D	D	E	E	E	F	F	F	F	F	G	G	G	G	H	
	ST	VA	AL	DC	ST	VA	DC	DC	ST	VA	AL	DC	DC	ST	VA	DC	
	P707	P607	P837	P809	P709	P609	P811	P811C	P711	P611	P841	P813	P813C	P713	P613	P815	
∅ [mm]	6.00 12.70	3.00 12.70	6.00 12.70	3.00 16.00	12.70	8.00 12.70	3.00 16.00	3.00 12.70	6.00 12.70	3.00 12.70	6.00 12.70	3.00 16.00	3.00 12.70	6.00 12.70	6.00 12.70	3.00 16.00	
	<b>NEW</b>	<b>NEW</b>			<b>NEW</b>	<b>NEW</b>			<b>NEW</b>	<b>NEW</b>				<b>NEW</b>	<b>NEW</b>		
AMG	15	15	15	16	17	17	18	18	19	19	19	20	20	21	21	22	ISO
1.1	■			■	■		■	■	■			■	■	■		■	P1
1.2	■			■	■		■	■	■			■	■	■		■	P1
1.3	■			■	■		■	■	■			■	■	■		■	P2
1.4	■			■	■		■	■	■			■	■	■		■	P3
1.5	■			■	■		■	■	■			■	■	■		■	P4
1.6	■			■	■		■	■	■			■	■	■		■	H1
1.7				■	■		■	■	■			■	■	■		■	H3
1.8				■	■		■	■	■			■	■	■		■	H4
2.1		■	●	■		■	■	■		■	●	■	■		■	■	M1
2.2		■		■		■	■	■		■		■	■		■	■	M3
2.3		■		■		■	■	■		■		■	■		■	■	M2
2.4		■		■		■	■	■		■		■	■		■	■	S2
3.1				■			■	■				■	■			■	K1
3.2				■			■	■				■	■			■	K2
3.3				■			■	■				■	■			■	K3
3.4				■			■	■				■	■			■	K4
4.1			●	■			■	■			●	■	■			■	S1
4.2				■			■	■				■	■			■	S2
4.3				■			■	■				■	■			■	S3
5.1			●	■			■	■			●	■	■			■	S1
5.2				■			■	■				■	■			■	S2
5.3				■			■	■				■	■			■	S3
6.1			●	■	●		■	■	●			■	■	●		■	N3
6.2			●	■			■	■		●		■	■			■	N4
6.3				■			■	■				■	■			■	N3
6.4				■			■	■				■	■			■	N4
7.1			■									■					N1
7.2												■					N1
7.3			■									■					N1
7.4			■									■					N2
8.1			■									■					O
8.2			■									■					O
8.3			■									■					O
9.1				■			■	■				■	■			■	H
10.1																	O

■ Excellent for application

● Good for application

	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM		
	H	H	H	J	K	L	L	L	L	L	M	N				
				60°	90°									135°	180°	
	DC	ST	VA	DC	DC	DC	DC	ST	VA	AL	DC	DC	DC	GRP	GRP	
	P815C	P715	P615	P817	P819	P821	P821C	P721	P621	P842	P823	P825	P843	P844	P880	P890
∅ [mm]	8.00 12.70	8.00 12.70	8.00 12.70	3.00 16.00	3.00 16.00	3.00 16.00	3.00 12.70	10.00 12.70	8.00 12.70	6.00 12.70	3.00 16.00	3.00 16.00	3.00 8.00	3.00 8.00	Set	Set
		<b>NEW</b>	<b>NEW</b>					<b>NEW</b>	<b>NEW</b>				<b>NEW</b>	<b>NEW</b>	<b>NEW</b>	
AMG	22	23	23	24	25	26	26	27	27	27	28	29	30	31	32	33
1.1	■	■		■	■	■	■	■			■	■				P1
1.2	■	■		■	■	■	■	■			■	■				P1
1.3	■	■		■	■	■	■	■			■	■				P2
1.4	■	■		■	■	■	■	■			■	■				P3
1.5	■	■		■	■	■	■	■			■	■				P4
1.6	■	■		■	■	■	■	■			■	■				H1
1.7	■	■		■	■	■	■	■			■	■				H3
1.8	■	■		■	■	■	■	■			■	■				H4
2.1	■		■	■	■	■	■	■	■	●	■	■				M1
2.2	■		■	■	■	■	■	■	■	■	■	■				M3
2.3	■		■	■	■	■	■	■	■	■	■	■				M2
2.4	■		■	■	■	■	■	■	■	■	■	■				S2
3.1	■			■	■	■	■	■			■	■				K1
3.2	■			■	■	■	■	■			■	■				K2
3.3	■			■	■	■	■	■			■	■				K3
3.4	■			■	■	■	■	■			■	■				K4
4.1	■			■	■	■	■	■		●	■	■				S1
4.2	■			■	■	■	■	■			■	■				S2
4.3	■			■	■	■	■	■			■	■				S3
5.1	■			■	■	■	■	■		●	■	■				S1
5.2	■			■	■	■	■	■			■	■				S2
5.3	■			■	■	■	■	■			■	■				S3
6.1	●			●	●	●	●	●			●	●				N3
6.2	■			■	■	■	■	■		●	■	■				N4
6.3	■			■	■	■	■	■			■	■				N3
6.4	■			■	■	■	■	■			■	■				N4
7.1										■						N1
7.2										■						N1
7.3										■						N1
7.4										■						N2
8.1										■			■	■		O
8.2										■			■	■		O
8.3										■			■	■		O
9.1	■			■	■	■	■				■	■				H
10.1																O

■ Excellent for application

● Good for application





# P803 P803C

• Rotary Burr – Cylinder with endcut

Brazed above 6.00 mm

P803, P803C	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	
		5.1	5.2	5.3	6.2	6.3	6.4	9.1												
	•	6.1																		



$d_1$ Ø mm	$d_2$ Ø <sub>h7</sub> mm	$l_2$ mm	$l_1$ mm	P803	P803C
3.00	3	14	38	P8033.0X3.0 <sup>1)</sup>	P803C3.0X3.0 <sup>1)</sup>
6.30	3	12.7	45	P8036.3X3.0	
6.00	6	18	50	P8036.0X6.0 <sup>1)</sup>	P803C6.0X6.0 <sup>1)</sup>
8.00	6	19	64	P8038.0X6.0	P803C8.0X6.0
9.60	6	19	64	P8039.6X6.0	P803C9.6X6.0
12.70	6	25	70	P80312.7X6.0	P803C12.7X6.0
16.00	6	25	70	P80316.0X6.0	

<sup>1)</sup>  $d_2$  tolerance h6

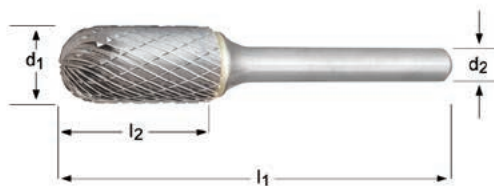
P805	HM	C					DC	
P805C	HM	C			TiAlN		DC	

# P805 P805C

• Rotary Burr – Ball Nosed Cylinder

Brazed above 6.00 mm

P805, P805C	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2
		5.1	5.2	5.3	6.2	6.3	6.4	9.1											
	•	6.1																	



$d_1$ $\varnothing$ mm	$d_2$ $\varnothing_{h_7}$ mm	$l_2$ mm	$l_1$ mm	P805	P805C
3.00	3	14	38	P8053.0X3.0	P805C3.0X3.0 <sup>1)</sup>
6.30	3	12.7	45	P8056.3X3.0	
6.00	6	18	50	P8056.0X6.0	P805C6.0X6.0 <sup>1)</sup>
8.00	6	19	64	P8058.0X6.0	P805C8.0X6.0
9.60	6	19	64	P8059.6X6.0	P805C9.6X6.0
12.70	6	25	70	P80512.7X6.0	P805C12.7X6.0
16.00	6	25	70	P80516.0X6.0	

<sup>1)</sup>  $d_2$  tolerance h6



# P811 P811C

• Rotary Burr – Ball Nosed Tree

Brazed above 6.00 mm

P811, P811C	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2
		5.1	5.2	5.3	6.2	6.3	6.4	9.1											
	●	6.1																	



$d_1$ Ø mm	$d_2$ Ø <sub>h7</sub> mm	$l_2$ mm	$l_1$ mm	P811	P811C
3.00	3	14	38	P8113.0X3.0 <sup>1)</sup>	P811C3.0X3.0 <sup>1)</sup>
6.30	3	12.7	45	P8116.3X3.0	
6.00	6	18	50	P8116.0X6.0 <sup>1)</sup>	P811C6.0X6.0 <sup>1)</sup>
8.00	6	20	65	P8118.0X6.0	
9.60	6	19	64	P8119.6X6.0	P811C9.6X6.0
12.70	6	25	70	P81112.7X6.0	P811C12.7X6.0
16.00	6	25	70	P81116.0X6.0	

<sup>1)</sup>  $d_2$  tolerance h6



# P813 P813C

• Rotary Burr – Pointed Tree

Brazed above 6.00 mm

P813, P813C	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2
		5.1	5.2	5.3	6.2	6.3	6.4	9.1											
	•	6.1																	



$d_1$ Ø mm	$d_2$ Ø <sub>h7</sub> mm	$l_2$ mm	$l_1$ mm	P813	P813C
3.00	3	14	38	P8133.0X3.0 <sup>1)</sup>	P813C3.0X3.0 <sup>1)</sup>
6.30	3	12.7	45	P8136.3X3.0	
6.00	6	18	50	P8136.0X6.0 <sup>1)</sup>	P813C6.0X6.0 <sup>1)</sup>
8.00	6	19	64	P8138.0X6.0	
9.60	6	19	64	P8139.6X6.0	P813C9.6X6.0
12.70	6	25	70	P81312.7X6.0	P813C12.7X6.0
16.00	6	25	70	P81316.0X6.0	

<sup>1)</sup>  $d_2$  tolerance h6



# P821 P821C

• Rotary Burr – Ball Nosed Cone

Brazed above 6.00 mm








P821, P821C	■	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	2.1	2.2	2.3	2.4	3.1	3.2	3.3	3.4	4.1	4.2	
		5.1	5.2	5.3	6.2	6.3	6.4	9.1												
	•	6.1																		



$d_1$ Ø mm	$d_2$ Ø <sub>h7</sub> mm	$l_2$ mm	$l_1$ mm		P821	P821C
3.00	3	14	38	8°	P8213.0X3.0 <sup>1)</sup>	P821C3.0X3.0 <sup>1)</sup>
6.00	6	18	50	14°	P8216.0X6.0 <sup>1)</sup>	
8.00	6	25.4	70	14°	P8218.0X6.0	
9.60	6	30	76	14°	P8219.6X6.0	
12.70	6	32	77	14°	P82112.7X6.0	P821C12.7X6.0
16.00	6	33	78	14°	P82116.0X6.0	

<sup>1)</sup>  $d_2$  tolerance h6

### Icon descriptions

<b>Material</b>	 Carbide				
<b>Coating</b>	 Bright	 Titanium Aluminium Nitride			
<b>Countersink</b>	 60°	 90°	 135°	 180°	
<b>Application</b>	 <b>A</b> Cylinder without endcut	 <b>B</b> Cylinder with endcut	 <b>C</b> Ball Nosed Cylinder	 <b>D</b> Ball	 <b>E</b> Oval
	 <b>F</b> Ball nosed tree	 <b>G</b> Pointed Tree	 <b>H</b> Flame	 <b>J</b> 60° Countersink	 <b>K</b> 90° Countersink
	 <b>L</b> Ball nosed cone	 <b>M</b> Cone	 <b>N</b> Inverted cone	 Fibreglass routing	
<b>Type</b>	 High Metal Removal Rate in Steels	 High Metal Removal Rate in Stainless Steels	 Aluminium Cut for non-ferrous materials including plastics	 Fibreglass and Composites	 Double Cut for General purpose use
<b>End Cut</b>	 Standard	 Drill Point	 End Mill		

## WARNING

These recommendations are for standard length Burrs with 13 mm maximum overhang, when exceeding the maximum overhang of 13 mm it is generally recommended to use much lower safety speeds. Don't run the burr above the maximum speed, this can cause premature wear. Don't run the burr too slowly, this can cause chipping.

Don't apply more cutting depth than 1/3 of the diameter, don't encapsulate. For brazed rotary burrs: don't allow the burr to become too hot, this may cause the braze to soften and cause the head to become detached from the shank.



**Personal protective equipment must be worn at all times!**





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