DEBURRING TOOLS
CRAZYMILL BACKCHAMFER

CrazyMill Backchamfer 3 x d / 5 x d

Carbide | 45° | Z 3-6 | eXedur RIP

BACKSIDE DEBURRING WITH EXTERNAL COOLING

The CrazyMill Backchamfer is recommended for backside deburring of edges, holes, and threads. This means the part no longer needs to be re-clamped on the machine, and it ensures greater precision and faster machining cycles. The short version with a usable length of 3 x d gives the tool even greater stability and is especially suitable when it comes to smaller edge lengths or drilling depths. The long version with a usable length of 5 x d is suited for high edges and greater drilling depths.

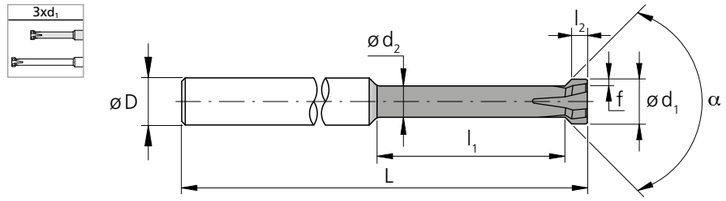
With its diameter range of 0.36 mm - 5.70 mm CrazyMill Backchamfer is suitable for backside deburring of holes with a diameter of 0.4 mm or greater. Its high tooth number (3 - 6 depending on diameter) and special cutting geometry (positively sharply ground) yield excellent surface quality without the formation of a secondary burr.

Coolant type, pressure and filtration

Recommendations for coolant type, pressure and filtration are on page "deburring process".

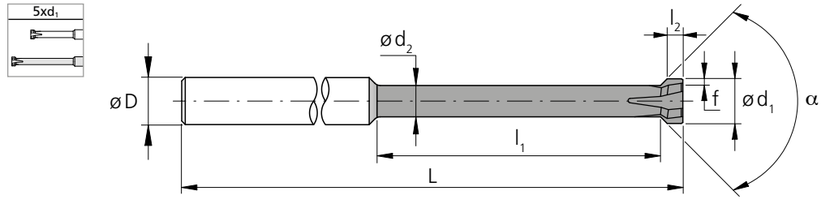
Please note

You couldn't find your suitable version of the CrazyMill Backchamfer (diameter, length, cutting direction…)? Ask us about our customized versions!



d_1 [mm]	l_1 [mm]	d_2 [mm]	l_2 [mm]	D (h6) [mm]	L [mm]	Chamfer α	Z [Teeth]	f [mm]	Item number	Availability
0.36	1.6	0.22	0.20	3	50	90°	3	0.03	2.BC.03036090.1	■
0.46	2.0	0.30	0.25	3	50	90°	3	0.04	2.BC.03046090.1	■
0.65	2.8	0.40	0.35	3	50	90°	3	0.04	2.BC.03065090.1	■
0.90	4.0	0.60	0.50	4	50	90°	4	0.075	2.BC.03090090.1	■
1.40	6.0	0.95	0.90	4	50	90°	4	0.10	2.BC.03140090.1	■
1.90	8.0	1.40	1.00	4	50	90°	5	0.10	2.BC.03190090.1	■
2.90	12.0	2.10	1.50	4	60	90°	5	0.20	2.BC.03290090.1	■
3.70	16.0	2.70	2.00	4	60	90°	5	0.30	2.BC.03370090.1	■
4.70	20.0	3.30	2.00	6	70	90°	6	0.40	2.BC.03470090.1	■
5.70	24.0	4.00	2.00	6	70	90°	6	0.50	2.BC.03570090.1	■

■ Stock item



d_1 [mm]	l_1 [mm]	d_2 [mm]	l_2 [mm]	D (h6) [mm]	L [mm]	Chamfer α	Z [Teeth]	f [mm]	Item number	Availability
0.36	2.4	0.22	0.20	3	50	90°	3	0.03	2.BC.05036090.1	■
0.46	3.0	0.30	0.25	3	50	90°	3	0.04	2.BC.05046090.1	■
0.65	4.2	0.40	0.35	3	50	90°	3	0.04	2.BC.05065090.1	■
0.90	6.0	0.60	0.50	4	60	90°	4	0.075	2.BC.05090090.1	■
1.40	9.0	0.95	0.90	4	60	90°	4	0.10	2.BC.05140090.1	■
1.90	12.0	1.40	1.00	4	60	90°	5	0.10	2.BC.05190090.1	■
2.90	18.0	2.10	1.50	4	70	90°	5	0.20	2.BC.05290090.1	■
3.70	24.0	2.70	2.00	4	70	90°	5	0.30	2.BC.05370090.1	■
4.70	30.0	3.30	2.00	6	80	90°	6	0.40	2.BC.05470090.1	■
5.70	36.0	4.00	2.00	6	80	90°	6	0.50	2.BC.05570090.1	■

■ Stock item

Regrinding: This product is not suitable for regrinding.

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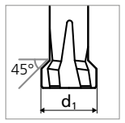
RECOMMENDATION FOR USE
● Excellent | ◐ Good | ○ Acceptable | ⊠ Not recommended

P ● N ● S3 ●
M ● S1 ● H1 ●
K ● S2 ● H2 ⊠

DEBURRING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min]	f_z [mm] Ød1 0.36 - 1.90 mm f_z	f_z [mm] Ød1 2.90 - 5.70 mm f_z
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	120	0.030	0.040
		1.0401	C15	AISI 1015			
		1.1191	C45E/CK45	AISI 1045			
		1.0044	S275JR	AISI 1020			
		1.0715	11SMn30	AISI 1215			
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	100	0.020	0.030
		1.7131	16MnCr5	AISI 5115			
		1.3505	100Cr6	AISI 52100			
		1.7225	42CrMo4	AISI 4140			
		1.2842	90MnCrV8	AISI O2			
	High alloyed tool steel Rm < 1200 N/mm²	1.2379	X153CrMoV12	AISI D2	80	0.015	0.030
		1.2436	X210CrW12	AISI D4/D6			
		1.3343	HS6-5-2C	AISI M2 / UNS T11302			
		1.3355	HS18-0-1	AISI T1 / UNS T12001			
M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	50	0.010	0.030
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	80	0.015	0.030
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH			
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	50	0.015	0.030
		1.4435	X2CrNiMo 18-14-3	AISI 316L			
		1.4441	X2CrNiMo 18-15-3	AISI 316LM			
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L			
K	Cast iron	0.6020	GG20	ASTM 30	60	0.015	0.030
		0.6030	GG30	ASTM 40B			
		0.7040	GGG40	ASTM 60-40-18			
		0.7060	GGG60	ASTM 80-60-03			
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351	200	0.030	0.040
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	200	0.030	0.040
		3.2381	GD-AlSi10Mg	UNS A03590			
	Copper	2.004	Cu-OF / CW008A	UNS C10100	40	0.020	0.030
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	40	0.020	0.030
		2.036	CuZn40 CW509L	UNS C28000			
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	200	0.030	0.040
		2.102	CuSn6	UNS C51900			
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	200	0.030	0.040
		2.096	CuAl9Mn2	UNS C63200			
S_1	Super alloys	2.4856		Inconel 625	40	0.020	0.030
		2.4668		Inconel 718			
		2.4617	NiMo28	Hastelloy B-2			
		2.4665	NiCr22Fe18Mo	Hastelloy X			
S_2	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	40	0.020	0.030
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	40	0.020	0.030
		9.9367	TiAl6Nb7	ASTM F1295			
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	50	0.015	0.030
			CrCoMo28	ASTM F1537			
H_1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.015	0.020
H_2	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			

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