

SECTION V

D-BURR MACHINES

D-Burr Machines	212-235
D-Burr General Information	214-217

D-Burr Machines Currently Available

Model 111	218
Model 121	219
Model 131	220

Operating Instructions, Schematics Drawings & Parts

Operating Instructions: Model 111	221
Performance Tips: Model 111	222
Wiring Diagram: Model 111 & 121	223
Part Numbers: Model 111 Main View	224
Schematic Drawing: Model 111 Main View	225
Part Numbers: Model 111 Detail View	226
Schematic Drawing: Model 111 Detail View	227
Operating Instructions: Model 121 & 131	228
Performance Tips: Model 121 & 131	229
Part Numbers: Model 121 & 131 Main View	230
Schematic Drawing: Model 121 & 131 Main View	231
Part Numbers: Model 121 Detail View	232
Schematic Drawing: Model 121 Detail View # 1	233
Schematic Drawing: Model 121 Detail View # 2	234
Schematic Drawing: Model 121 Detail View # 3	235

STRAIGHT EDGE D-BURR MACHINES

**REDUCE STRAIGHT EDGE
D-BURRING TIME
BY AS MUCH AS 90%**

MODEL 111

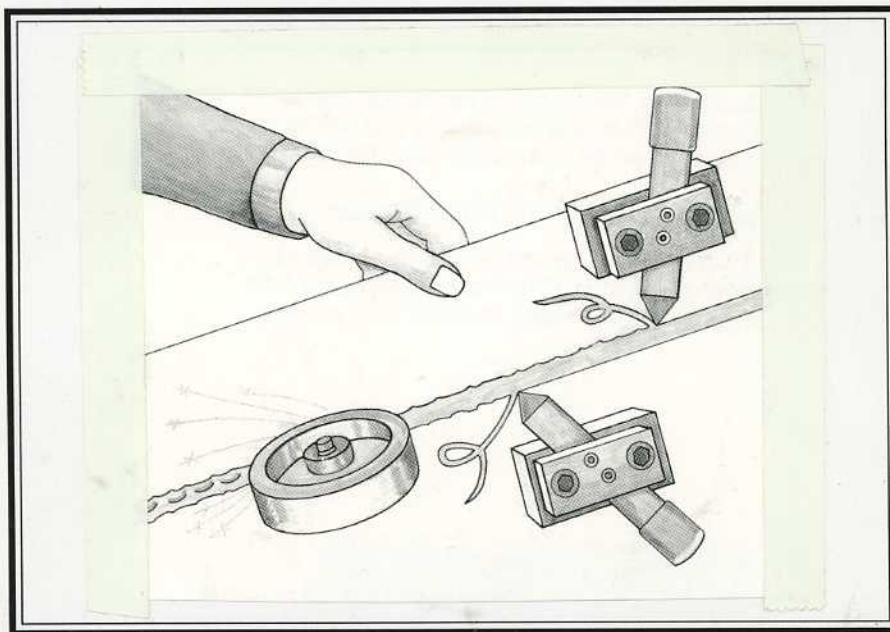
DEBURRS BOTTOM EDGE IN ONE PASS

MODEL 121

DEBURRS THE TOP AND BOTTOM EDGES IN ONE PASS

MODEL 131

**DEBURRS THE TOP AND BOTTOM EDGES AND
SMOOTHS THE SHEARED SIDE IN ONE PASS**



STRAIGHT EDGE D-BURR MACHINES

Machine Eases Deburring of Sheared Sheetmetal Edges

Removing the dangerous burrs left on sheared edges of sheetmetal is an important safety consideration for sheetmetal shops, especially those working with stainless steel. Unless deburred, the sheets can easily expose workers and customers to the risks of lacerated fingers.

Metal workers usually solve the burr problem by hand filing or grinding, but both are labor-intensive and dirty operations. In addition, there is the likelihood that the sheetmetal workpiece might become bent or scarred. Fortunately, there is an alternative.

Oxford Industries, a precision metal fabricator in Largo, Fla., employs a more sophisticated deburring method that utilizes a unique machine called the D-Bur-R. Oxford Industries has used the machine on all commonly worked metals in a great variety of sizes and shapes, but the unit has been particularly useful in deburring stainless-steel sheet.

According to Al Freeburg of Oxford Industries, "Much of our work is fabricating stainless steel for the food processing and chemical processing industries. There is no other good way to deburr stainless. We like it for our own handling in the shop and our customers like knowing that we deburr all of our sheetmetal products. Whether the work is 10 feet long or just a one-foot square, the machine handles it with no problems."

As an example of the type of stainless-steel construction where deburring is especially valuable, Freeburg cited a current order for several hundred cabinet autoclaves. Each is made in two pieces, a main base and a hinged lid. After the two pieces are sheared from stainless sheet, an operator deburrs all the edges before the blanks are formed and assembled in the shop.

Freeburg points out that operating the deburrer does not require special training. "The machine is easily set up so that anyone can use it—and probably everyone in the shop has. Our particular machine is practically indestructible. About the only things to wear are the cutting tools, and they can be sharpened like any other metal cutters." Freeburg estimates that his shop uses about three cutters per year.

Trims Burrs at 60 fpm

Oxford Industries has an early model of the D-Bur-R that trims burrs from only one edge at a time. There are now models that trim the top and bottom of an edge at once and another that puts clean edges on metal disks. Basic operation of these models is essentially the same. A small wheel advances the workpiece along a stationary bed (of nonscratching brass) so that its burred edge is trimmed by a triangular cutting tool (two tools if it is a two-edge trimmer). The rate at which metal is fed to the cutter ranges to 60 fpm.

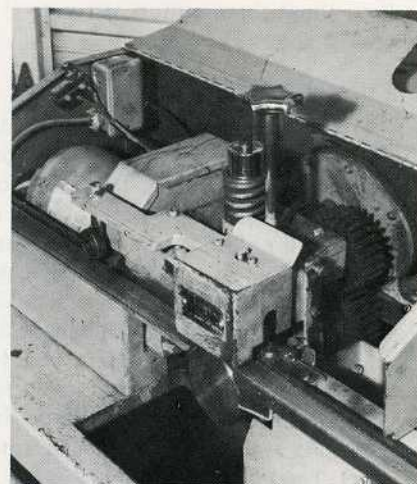
An important aspect of the D-Bur-R design is that its operation is not a grinding or sanding method; the unit generates no dust or pollution. Instead, shavings drop through an opening just below the cutter station into the inside of the machine for future disposal or

recycling. Thus the machine meets all pertinent OSHA and local regulations.

The compact deburring unit can be wheeled to any location in the plant so that large or unwieldy pieces do not have to be brought to the machine. The D-Bur-R, which is manufactured by Falls Metal Products

can handle stock from 24-gage to 1/4 inch thick, lengths from 4 inches up and widths from 1/2 inch up.

According to Freeburg, it is difficult to accurately assess the amount of money saved by the machine. "Labor cost savings alone must run 75 percent or more," he estimates. But there are other important dividends including customer acceptance and reduced worker time lost because of accidents.



Detail view of the D-Bur-R mechanism. The workpiece is drawn along the horizontal track by the drivewheel (lower right). The cutting tool is housed within the metal box over the wheel. Tool position is varied with the vertical control shaft behind the tool.

SALES — SERVICE — REPAIRS

215

1-800-523-5474 / FAX: 1-800-782-6780

METAL WORKING TOOLS - SHEET / PLATE FABRICATING

STRAIGHT EDGE D-BURR MACHINES

Machine Eases Deburring of Sheared Sheetmetal Edges

Trimming machine removes dangerous burrs from sheared sheetmetal edges in a fraction of the time and with none of the mess associated with hand deburring methods.



Oxford Industries' Al Freeburg demonstrates use of Falls D-Bur-R to remove the burr on the edge of stainless-steel sheet.

STRAIGHT EDGE D-BURR MACHINES

SLASH DEBURRING TIME BY AS MUCH AS 90%

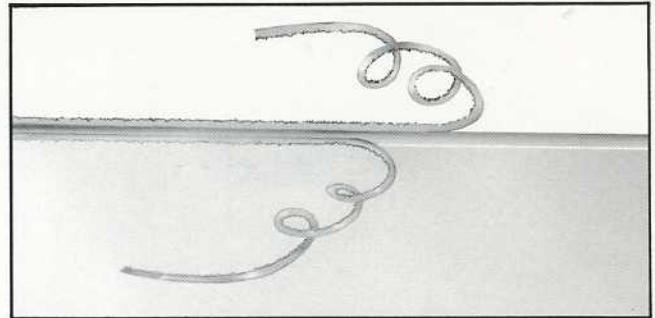
Imagine! Smooth peeled edges at 60 ft./min.! D-BUR-R removes sharp burrs fast. Five models to give you the competitive edge. Four give you perfect edges without grinding or filing. The fifth (Model 131) deburrs top and bottom edges in one pass, as well as eliminates "scallop" marks caused by the punching action.

Falls Products' D-BUR-R gives you big savings, too. Both in labor and in maintenance. By cutting deburring time by as much as 90% over conventional methods. Safer for your operators and for your sheet metal, too. D-BUR-R won't distort sheets or mar surfaces.

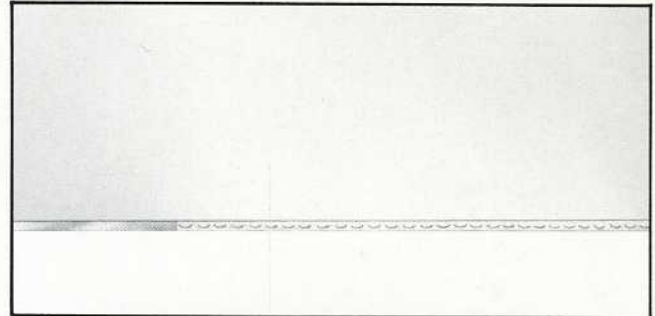
What's more, the triangular cutting tool that is the heart of the D-BUR-R, is presharpener and can be rotated for a projected life span of eight months to a year.

Large Capacity in Small Space

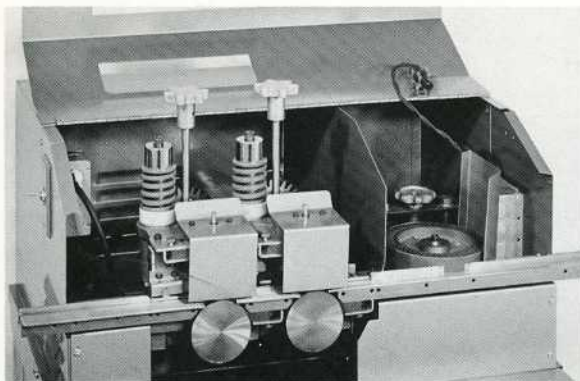
All five D-BUR-R models provide large capacities: Lengths from 4" to 10' or more; thicknesses from 24 gauge to 1/4"; widths from 1/2" to 4' or more.*



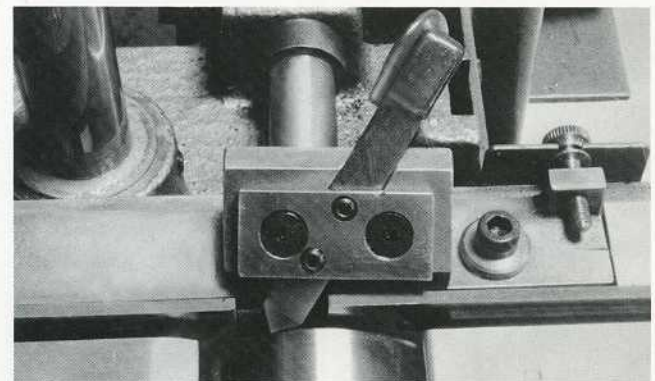
Peels bottom or top and bottom edges without distortion.



Model 131 also smooths the vertical edges of shaker parts, eliminating "scallop" marks in the same operation.



Easier, safer, faster for operator.



Triangular cutting tool slashes maintenance costs.

SALES — SERVICE — REPAIRS

217

1-800-523-5474 / FAX: 1-800-782-6780

METAL WORKING TOOLS - SHEET / PLATE FABRICATING

STRAIGHT EDGE D-BURR MACHINES

MODEL 111



Deburs the bottom edge in one pass.

SPECIFICATIONS

- DIMENSIONS:** Height 50", Width 36",
Depth 26".
- ELECTRICS:** Gear Motor 1/4 HP. 115 Volt
Single Phase. Brush Motor
1/4 HP. 115 Volt Split Phase.
- MATERIAL:** Steel, stainless steel, alum-
inum, brass, galvanized,
perforated, expanded sheet
metal.
- CAPACITY:** Thickness 24 gauge to 1/4".
Width 1/2" to 4' or more.
Length 4" to 10' or more.

