

# SECTION V

## D-BURR MACHINES

<b>D-Burr Machines .....</b>	<b>212-235</b>
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**

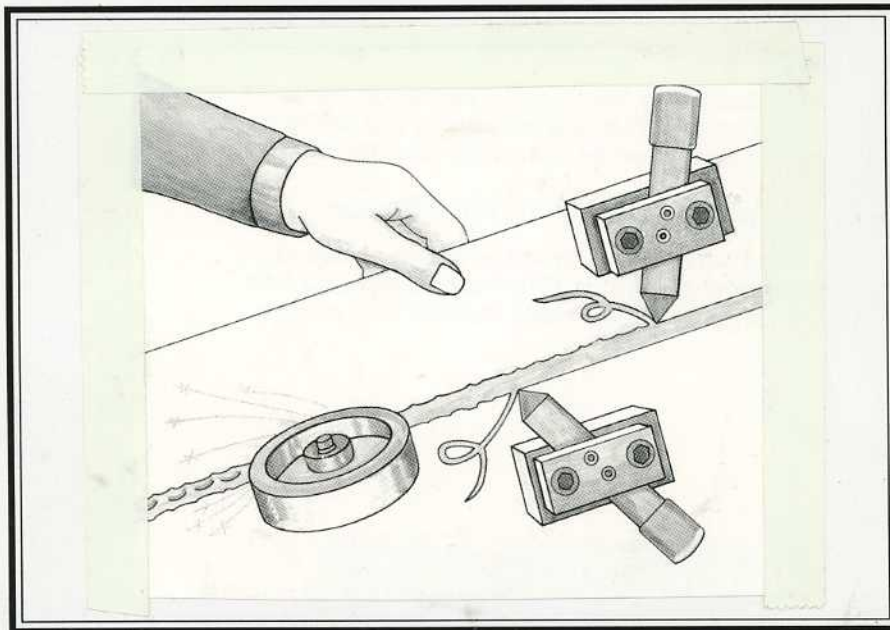
**DEBURRS BOTTOM EDGE IN ONE PASS**

## **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.

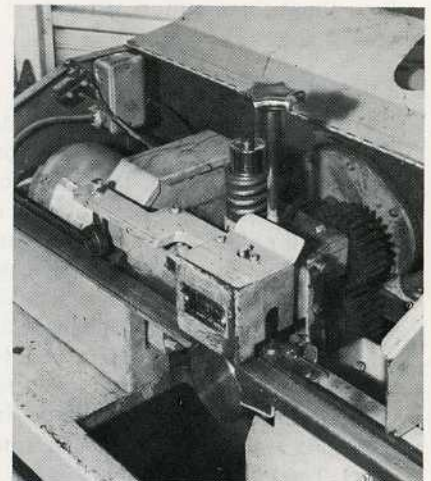
An important aspect of the D-Bur-R design is that its operation is not a grinding or sanding method; the unit generates no dust or pollution. Instead, shavings drop through an opening just below the cutter station into the inside of the machine for future disposal or

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

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%

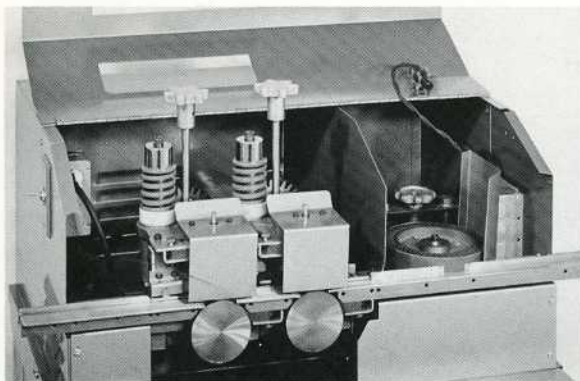
Imagine! Smooth peeled edges at 60 ft./min.! D-BUR-R removes sharp burrs fast. Five models to give you the competitive edge. Four give you perfect edges without grinding or filing. The fifth (Model 131) deburrs top and bottom edges in one pass, as well as eliminates "scallop" marks caused by the punching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

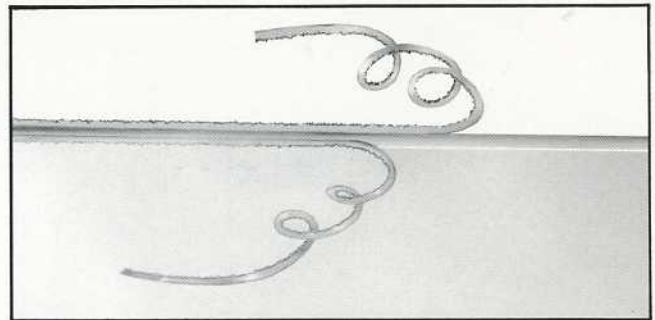
What's more, the triangular cutting tool that is the heart of the D-BUR-R, is presharpener and can be rotated for a projected life span of eight months to a year.

### Large Capacity in Small Space

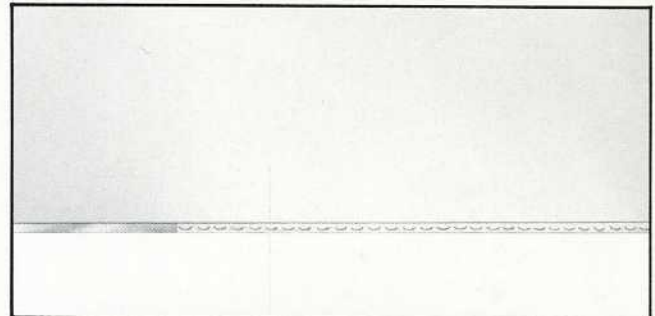
All five D-BUR-R models provide large capacities: Lengths from 4" to 10' or more; thicknesses from 24 gauge to 1/4"; widths from 1/2" to 4' or more.\*



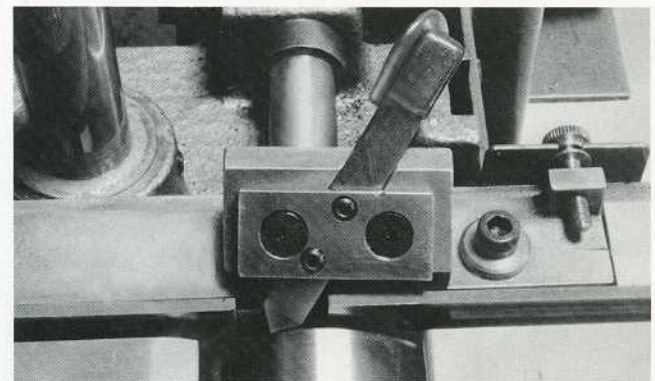
*Easier, safer, faster for operator.*



*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.*



*Triangular cutting tool slashes maintenance costs.*

# 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.

# STRAIGHT EDGE D-BURR MACHINES

## MODEL 121



Deburs the top and bottom edges in one pass.

**LARGER SHEETS  
DO NOT HAVE  
TO BE TURNED  
OVER TO D-BURR**

**HAS GREATER PULL  
WITH SECOND  
ROLLER ASSEMBLY**

## SPECIFICATIONS

<b>DIMENSIONS:</b>	Height 48", Width 48", Depth 27".
<b>ELECTRICS:</b>	Gear Motor 1/4 HP. 115 Volt Single Phase. Brush Motor 1/3 HP. 115 Volt Split Phase.
<b>MATERIAL:</b>	Steel, stainless steel, alu- minum, brass, galvanized, perforated sheet metal.
<b>CAPACITY:</b>	Thickness 24 gauge to 1/4". Width 1/2" to 4' or more. Length 4" to 10' or more.

**SALES — SERVICE — REPAIRS**

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

**METAL WORKING TOOLS - SHEET / PLATE FABRICATING**

# STRAIGHT EDGE D-BURR MACHINES

## MODEL 131



The most versatile D-BUR-R ever! Falls Products' Model 131 deburrs the top and bottom edges and smooths the sheared sides in one pass! That's right! It eliminates "scallop" marks as it deburrs. And like the others, it does it all in speeds of up to 60 feet per minute!

## SPECIFICATIONS

- DIMENSIONS:** Height 48", Width 48",  
Depth 27".
- ELECTRICS:** Gear Motor 1/4 HP. 115 Volt  
Single Phase. Abrasive  
Motor 1/3 HP. 115 Volt  
Split Phase.
- MATERIAL:** Steel, stainless steel, alum-  
inum, brass, galvanized,  
perforated sheet metal.
- CAPACITY:** Thickness 24 gauge to 1/4".  
Width 1/2" to 4' or more.  
Length 4" to 10' or more.



# **MODEL 111 D-BURR MACHINE**

## **INSTRUCTIONS FOR OPERATING MODEL 111 D-BUR-R**

**The burr must be down when feeding the material into the machine.**

To operate the machine, the operator must hold the work piece against the back guide until the feed rollers automatically draw the material by the cutting tool for removal of the burr.

### **WHEN FIRST FEEDING MATERIAL INTO MACHINE**

1. Raise top roller by turning jackscrew clockwise.
2. Place material between rollers with machine turned on. Lower roller by turning jackscrew counter clockwise until material moves. Then make an extra half turn for firm pressure.

### **ADJUSTING, CUTTING TOOL FOR LIGHT OR HEAVY GAUGES**

1. Loosen securing screw.
2. For heavy gauge move tool toward material by using thumbscrew.
3. For light gauge, move tool away from material by using thumbscrew.
4. Tighten securing screw to prevent tool movement by vibration.

### **ROTATING OR REPLACING TOOLBIT**

1. Remove presser spring.
2. Lift up top assembly.
3. To remove toolbit, loosen two set screws in top plate just enough to slide tool out. Rotate tool until all cutting points are dull. Then remove worn ends with ordinary grinder. Do not burn or discolor while grinding.
4. When returning toolbit to holder, place cutting tool slightly below top of bottom roller, approximately 1/64 and retighten two set screws.
5. Replace top assembly and pressure spring. Apply enough pressure by turning hex driver until pressure gauge fits over pressure spring.

### **INSTRUCTIONS FOR ABRASIVE BRUSH ATTACHMENT**

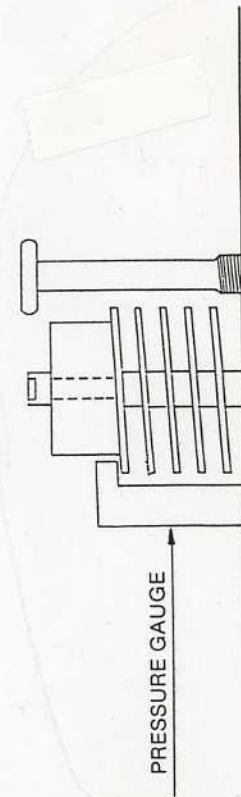
To adjust brush, loosen the two hold-down screws on motor base plate. Hold a piece of stock against back guide. While motor is running, move brush attachment toward edge of stock until brush barely touches. Turn off motor and move brush attachment another 1/16 to 1/8" . Tighten hold down screws.

## Performance Tips

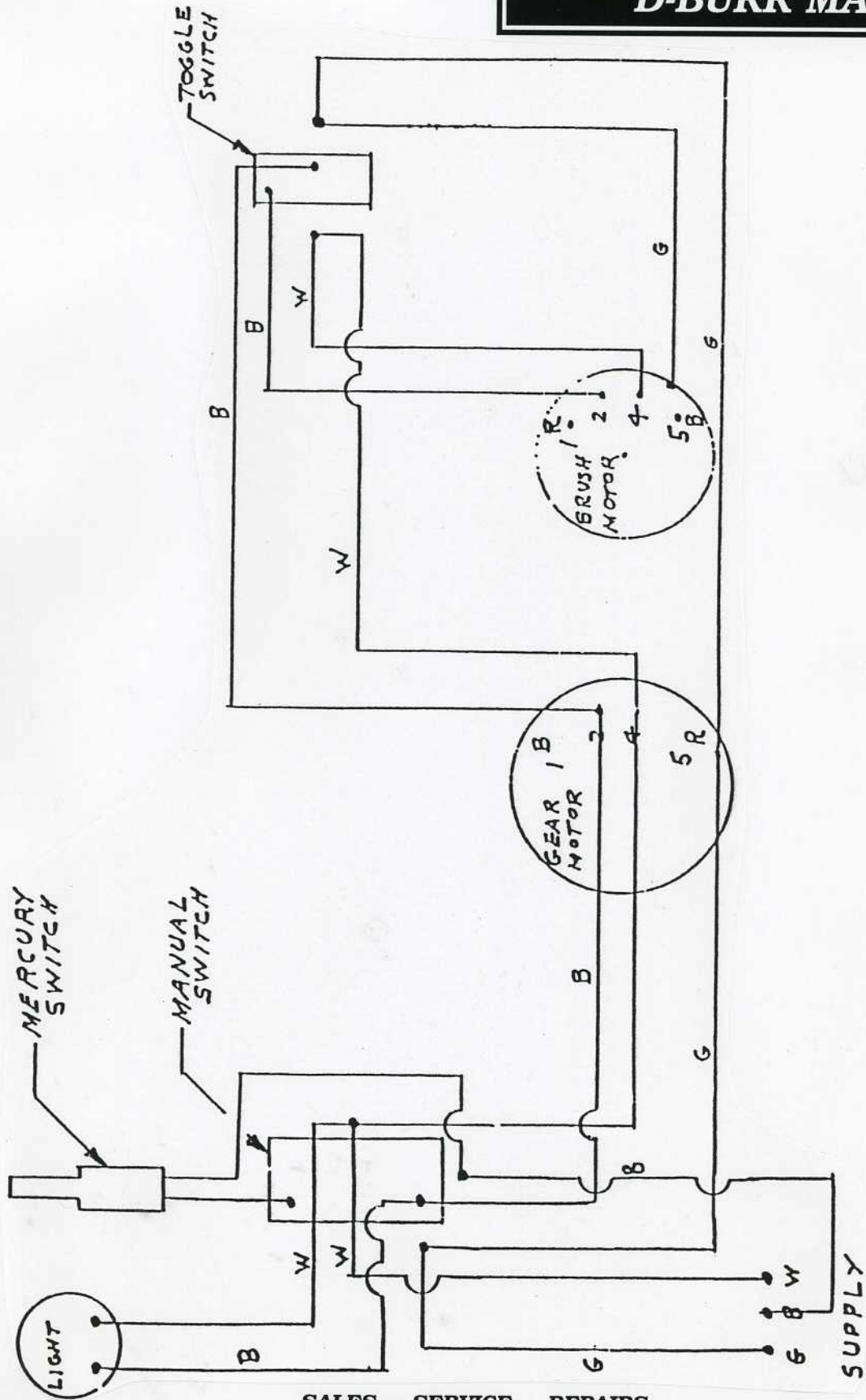
# MODEL 111 D-BURR MACHINE

### THINGS TO WATCH FOR

1. If work jams or stops, it may be that rollers are too close together, or toolbit is taking too much of a bite.
2. When changing from extreme light gauge to extreme heavy gauge, always move toolbit in to reach burr.
3. When changing from extreme heavy gauge to extreme light gauge, always move toolbit out (or away) to keep from jamming.
4. Always use pressure gauge to make sure there is enough pressure on spring.
5. When returning toolbit, always be sure that cutting tip is slightly below top of roller - approximately  $1/64$  "
6. **Never remove burrs by hand. Always use pliers or a hook.**



**MODELS 111 & 121  
D-BURR MACHINE**



**Wiring Diagram 111 & 121**

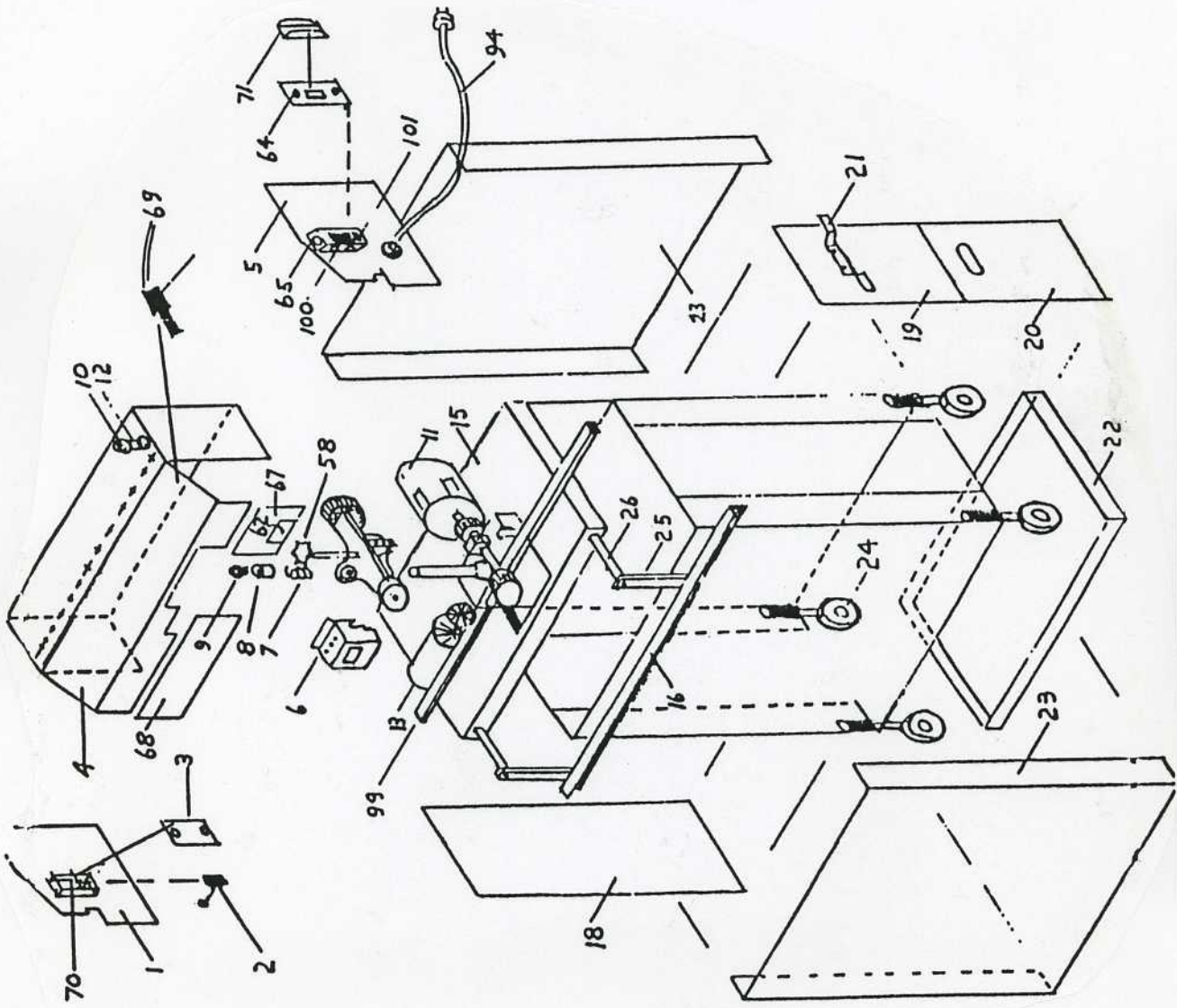
SALES — SERVICE — REPAIRS

# Parts - Model 111 Main View

## MODEL 111 D-BURR MACHINE

Key#	Part #	Part Description	REPLACEMENT PARTS
1	4080	Front Panel Left	1006 OILITE BUSHING
2	8244	Toggle Switch ( Eagle 447 )	2015A TOP ROLLER ASSY ( 111 )
3	8233	Switch Guard Plate	2015B BOTTOM ROLLER ASSY ( 111 )
4	4079	Top Guard Assy (Hinged)	2023 26 TOOTH STEEL GEAR
5	4081	Front Panel Right	2024 26 TOOTH PHENOLIC GEAR
6	2052	Top Roller Guard	2025 15 TOOTH DRIVE GEAR
7	1230	Tension Spring	2027A INTERMEDIATE GEAR ( PHENOLIC )
8	1099	Tension Spring Cap	2027B INTERMEDIATE GEAR (STEEL)
9	1441	Tension Spring Shrew	3034 FELT PADS
10	8242	Light Lens	3037 BRASS BED LEFT ( 111 )
11	2027	Gear Reducer Motor	3038 BRASS BED RIGHT ( 111 )
12	8241	Light Base	6074 ABRASIVE BRUSH
13	7073	Brush Motor	7102 TOOL BIT HSS
15	4061	Top of Base	7104 FIRST STAGE COBALT TOOL BIT ( 121 )
16	4054	Outrigger Sheet Support	7104A SECOND STAGE COBALT TOOL BIT ( 121 )
18	5095	Base Panel Left	3122 BRASS WEAR BED LEFT ( 121 )
19	5093	Base-Top Panel Right	3123 BRASS WEAR BED RIGHT ( 121 )
20	5094	Base Bottom Panel Right	3124 BRASS WEAR BED CENTER
21	5098	Power Cord Bracket	2130 BOTTOM ROLLER ASSY ( 121 )
22	5097	Base Pan	2131 TOP ROLLER ASSY ( 121 )
23	5091	Front and/or Rear Base Panel	6253 STEEL GEAR YB 20
24	7108	Swivel Casters	6254 PHENOLIC GEAR YBP 20
25	4058	Support Bar	REDBELT 80 GRIT STL / SS PKG / 10 ( 131 )
26	4059	Support Rod	BLACKBELT 80 GRIT ALUM / SOFT MATL PKG / 10 ( 131 )
58	1029	Jack Screw Knob	
62	4089	Tool Drawer	
64	8234	Utility Box Cover	
65	8231	Utility Box	
67	4082	Front Guard Left	
68	4083	Front Guard Right	
69	8239	Mercury Switch	
70	8232	Utility Box	
71	8442	Manual Starter Switch Guard	
94	8238	Power Cord Set	
99	3035	Main Gate	
100	8235	Manual Starter Switch	
101	8236	Heater Coil H 14.4B	

# MODEL 111 D-BURR MACHINE



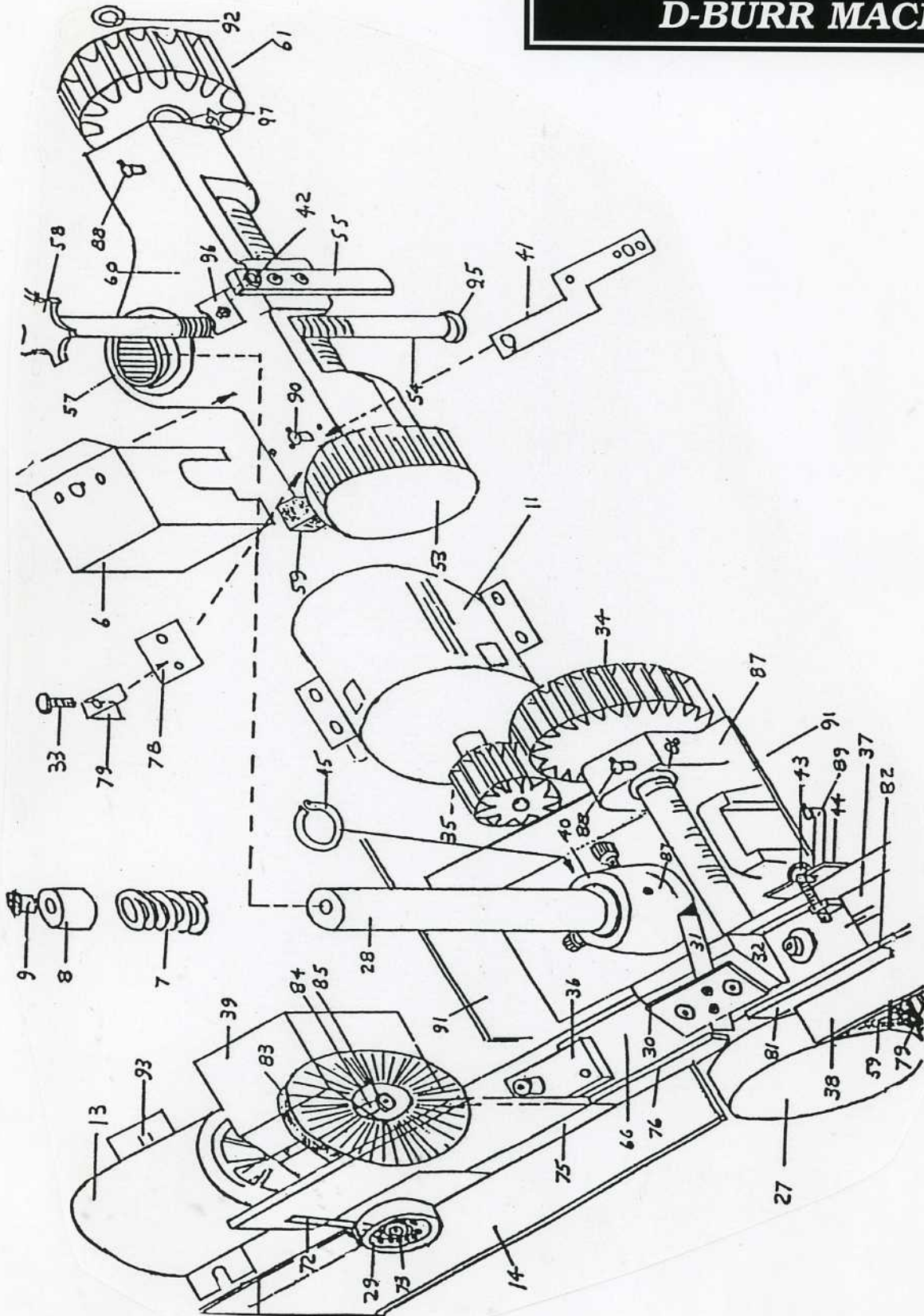
Main View Model 111

## Parts - Model 111 Detail View

# MODEL 111 D-BURR MACHINE

KEY#	PART#	PARTS DESCRIPTION	KEY#	PART#	PARTS DESCRIPTION
6	2052	Top Roller Guard	55	2052	Casting Guide
7	1230	Tension Spring	57	1012	Bronze Bushing
8	1099	Tension Spring Cap	58	1029	Jackscrew Knob
9	1443	Tension Spring Screw	59	3034	Felt Pads
11	2027	Gear Reducer Motor	60	1010	Top Casting
13	7073	Brush Motor	61	2024B	Phenolic Gear 26 Tooth
14	3037	Brass Wear Bed Left	66	3047	Toolholder Base Plate
27	2015B	Bottom Roller Assy	72	6068	Ballbearing Holder
28	1003	Center Post	73	6070	Ballbearing Bushing
29	6069	Roller Bearing	74	3042	Back Guide Left
30	3132	Top Plate Toolholder	75	6075	Brush Guard Asey (Part of Back Guide)
31	7102	HSS Tribit ( Toolbit)	76	3040	Carbide Insert Left
32	3135	"V" Block (Toolholder)	78	3032	Wiper Holder Bracket
33	3444	Brass Screw (Felt Wiper Clamp)	79	3033	Wiper Holder Clamp
34	2023A	Steel Gear 26 Tooth	81	3039	Carbide Insert Right
35	2025	Steel Drive Gear 15 Tooth	82	3041	Back Guide Right
36	3051	Toolholder Holddown Block	83	6074	Abrasive Filament Brush
37	3044	Marker Plate	84	6077	Brush Arbor
38	3038	Brass Wear Bed Right	85	6078	Brush Arbor Cap
39	6071	Brush Guard	86	1006	Oilite Bushing
40	1004	Plastic Collar (Center Post)	87	1002	Bottom Casting
41	6067	Ball Bearing Holddown Arm	88	1007	1/4 Oil Cup (Short Shoulder)
42	3445	Brass Screw for Jackscrew Lock	89	1008	1/4 90 Deg Oil Cup
43	3446	Brass Adjustment Screw	90	1011	1/4 Oil Cup (Long)
44	3050	Adjustment Yoke	91	2026	Motor Mount Base
45	1005	Retaining Ring	92	2019	Gear Cap Washer (Roller Shaft)
53	2015A	Top Roller Assy	93	6072	Brush Motor Mount
54	1028	Jackscrew	95	1030	Thrust Bearing
			96	1031	Jackscrew Lock
			97	2022	Thrust Bushing

# MODEL 111 D-BURR MACHINE



Detail View Model 111

SALES — SERVICE — REPAIRS

227

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

METAL WORKING TOOLS - SHEET / PLATE FABRICATING

## MODEL 121 & 131 D-BURR MACHINE

### INSTRUCTIONS FOR OPERATING MODELS 121 & 131 D-BUR-R

#### MODEL 121 D-BUR-R

The Model 121 D-Bur-R will deburr a sheared edge whether the burr is up or down. The abrasive brushes are used to dress up the edge a little more and should be used when deburring galvanized or perforated materials.

To operate the machine the operator must hold the work piece against the back guide until the feed rollers automatically draw the material by the cutting tools for removal of the top or bottom burr.

#### MODEL 131 D-BUR-R

The Model 131 D-Bur-R has an abrasive belt and two cutting tools to remove the top or bottom burr and the sharp punch marks from material produced on a CNC punch press.

To operate the machine the operator must hold the work piece against the back guide, as he or she is feeding it into the machine, until it passes the abrasive wheel. The feed rollers then automatically draw the material by the cutting tools for removal of the top or bottom burr.

#### WHEN FIRST FEEDING MATERIAL INTO MACHINE

1. Raise top rollers by turning jackscrews clockwise.
2. Place material between rollers with machine on.  
Lower rollers by turning jackscrews counter clockwise doing first stage and then second stage until material moves. Then make an extra half turn for firm pressure.

#### ADJUSTING, CUTTING TOOLS FOR LIGHT OR HEAVY GAUGES

1. Loosen securing screw.
2. For heavy gauge move tool toward material by using thumbscrew.
3. For light gauge, move tool away from material by using thumbscrew.
4. Tighten securing screw to prevent tool movement by vibration.

#### ROTATING OR REPLACING 1ST STAGE TOOLBIT

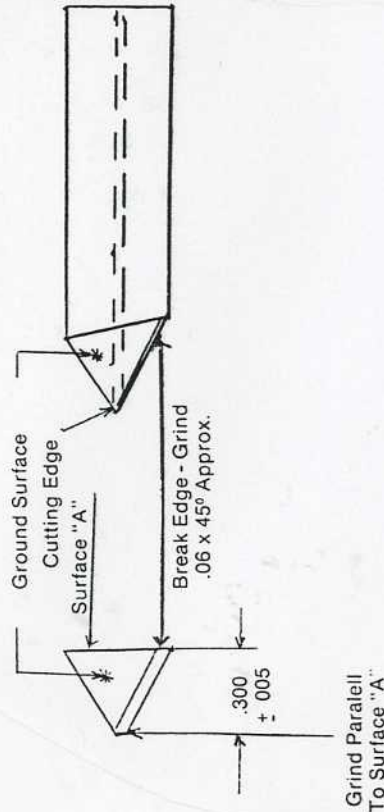
1. Remove pressure spring.
2. Lift up top assembly.
3. To remove toolbit, loosen two set screws. Rotate tool until all six cutting points are dull. Then remove worn ends with ordinary grinder. Do not burn or discolor while grinding.
4. When returning toolbit to holder, place cutting tool slightly below top of bottom roller, approximately 1/64 and retighten two set screws.
5. Replace top assembly and pressure spring. Apply enough pressure by turning hex driver until pressure gauge fits over pressure spring. See diagram page 16.

#### REMOVING TOOLBIT FOR SHARPENING, OR REPLACING ON SECOND STAGE

1. Remove top assembly.
2. Set top assembly in upside down position.
3. Move toolholder as far back (away from roller) as it will go.
4. Loosen both set screws in top plate just enough to slide toolbit out.
5. Place toolbit in grinding fixture with ground surface up so that surface to be ground is horizontal with the surface of surface grinder bed. Grind off worn end. (See page 3 for clearance grinding.)
6. When returning or replacing toolbit, first clean out "V" groove in toolholder of any chips by using air.
7. Ground clearance on toolbit should be placed in the bottom of "V" groove.
8. The top of toolbit must be placed at least 1/64 below the top surface of roller (with assembly still in upside down position.)
9. Tighten top plate firmly.
10. Place assembly and pressure spring back on machine. Apply enough pressure so that pressure gauge fits over spring. See diagram page 16.
11. Move toolholder progressively toward material until it starts to remove burr by using brass adjustment screw.
12. Tighten securing screw so that vibration will not move tool.



GRINDING DIAGRAM  
For Second Stage Toolbit



Place toolbit in grinding fixture with ground surface so that surface to be ground is horizontal with the surface of surface grinder bed. Grind off worn end.  
(If possible, refer to configuration of discarded 2nd stage toolbit)

INSTRUCTIONS FOR ABRASIVE BRUSH ATTACHMENT

MODEL 121 D-BUR-R

To adjust brushes, loosen the four hold-down screws on motor base plate. Hold a piece of stock against back guide. While motor is running, move brush attachment toward edge of stock until brush barely touches. Turn off motor and move brush attachment another 1/16 to 1/8 inch. Tighten hold-down screws.

INSTRUCTIONS FOR ABRASIVE WHEEL ATTACHMENT

MODEL 131 D-BUR-R

The Model 131 D-Bur-R is equipped with a six-inch expander wheel. Two different types of belts are supplied. The orange belt is made up of a special ceramic aluminum oxide and should be used for deburring carbon steel and stainless steel. The black belt is made of a silicon carbide material and should be used for deburring soft metal, such as aluminum, brass and copper. Both belts are made for a faster, more aggressive cutting action and with a special backing for longer-belt life. These belts can be obtained through Falls Products.

To adjust abrasive wheel, loosen the four securing screws on base of motor mount bracket. Move forward or back so that belt is lightly touching material as it is resting against the back guide.

By using the jackscrew, operator can raise or lower abrasive wheel so that the full use of belt is utilized.

THINGS TO WATCH FOR

1. If work jams or stops, it may be that rollers are too close together, or toolbit is taking too much of a bite.
2. When changing from extreme light gauge to extreme heavy gauge, always move toolbit in to reach burr.
3. When changing from extreme heavy gauge to extreme light gauge, always move toolbit out (or away) to keep from jamming.
4. Always use pressure gauge to make sure there is enough pressure on spring.
5. When returning toolbit, always be sure that cutting tip is slightly below top of roller - approximately 1/64.
6. If abrasive wheel is too close to material, gouging may occur.
7. Grinding area should be cleaned periodically on 131.
8. Lubricate back guides periodically on 131 to prevent galling.
9. Never remove burrs by hand. Always use pliers or a hook.

# MODEL 121 & 131 D-BURR MACHINE

## Instructions Models 121 & 131

# Parts - Model 121 Main View

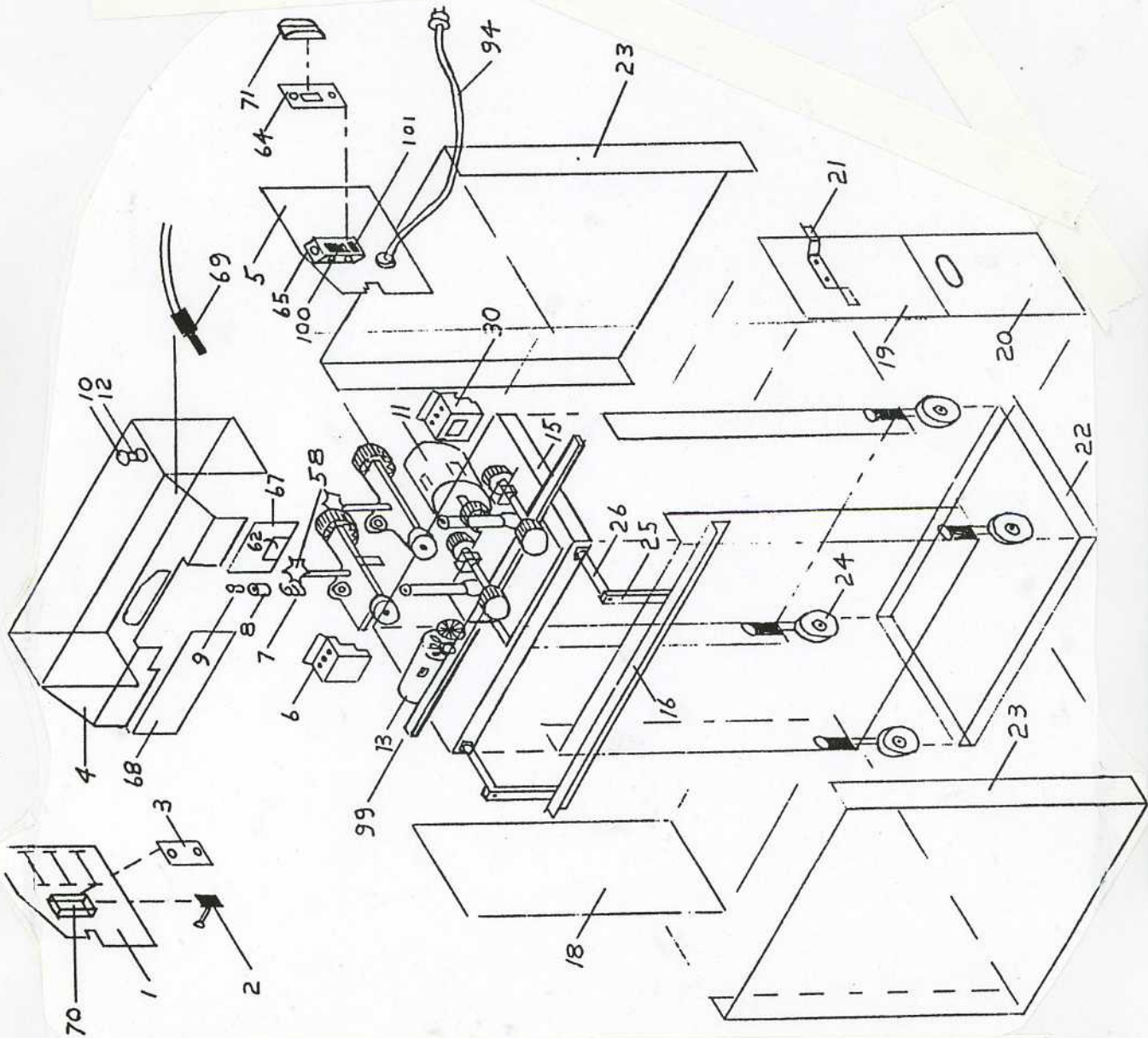
## MODEL 121 & 131 D-BURR MACHINE

KEY #	PART #	PART DESCRIPTION	KEY #	PART #	PART DESCRIPTION
1	5177	Front Panel Left	64	8234	Utility Box Cover
2	8244	Toggle Switch (Eagle #447)	65	8231	Utility Box
3	8233	Switch Guard Plate	67	5180	Front Guard Right
4	5179	Top Guard Assembly	68	5181	Front Guard Left
5	5176	Front Panel Right	69	8239	Mercury Switch
6	2143	Roller Guard Left	70	8232	Utility Box
7	1230	Tension Spring	71	8442	Manual Starter Switch Guard
8	1099	Tension Spring Cap	94	8238	Power Cord Set
9	1441	Tension Spring Screw	99	3121	Main Gate
10	8242	Light Lens (Red)	100	8235	Manual Starter Switch
11	2027	Gear Reducer Motor	101	8236	Heater Coil H 14.4 B
12	8241	Light Base			
13	7073	Brush Motor			
15	4170	Ten Gage Top			
16	4145	Outrigger Sheet Support			
18	5095	Base Panel Left			
19	5093	Base Top Panel Right			
20	5094	Base Bottom Panel Right			
21	5098	Power Cord Bracket			
22	5172	Base Bottom Pan			
23	5173	Front & Rear Base Panel			
24	7108	Swivel Casters			
25	4058	Support Bar			
26	4059	Support Rod			
27	2143	Roller Guard Right			
58	1029	Jackscrew Knob			
62	4089	Tool Drawer			

REPLACEMENT PARTS	
1006	OILITE BUSHING
2015A	TOP ROLLER ASSY ( 111 )
2015B	BOTTOM ROLLER ASSY ( 111 )
2023	26 TOOTH STEEL GEAR
2024	26 TOOTH PHENOLIC GEAR
2025	15 TOOTH DRIVE GEAR
2027A	INTERMEDIATE GEAR ( PHENOLIC )
2027B	INTERMEDIATE GEAR ( STEEL )
3034	FELT PADS
3037	BRASS BED LEFT ( 111 )
3038	BRASS BED RIGHT ( 111 )
6074	ABRASIVE BRUSH
7102	TOOL BIT HSS
7104	FIRST STAGE COBALT TOOL BIT ( 121 )
7104A	SECOND STAGE COBALT TOOL BIT ( 121 )
3122	BRASS WEAR BED LEFT ( 121 )
3123	BRASS WEAR BED RIGHT ( 121 )
3124	BRASS WEAR BED CENTER
2130	BOTTOM ROLLER ASSY ( 121 )
2131	TOP ROLLER ASSY ( 121 )
6253	STEEL GEAR YB 20
6254	PHENOLIC GEAR YBP 20
REDBELT	80 GRIT STL / SS PKG / 10 ( 131 )
BLACKBELT	80 GRIT ALUM / SOFT MATL PKG / 10 ( 131 )

# MODEL 121 & 131 D-BURR MACHINE



Main View Model 121

SALES — SERVICE — REPAIRS

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

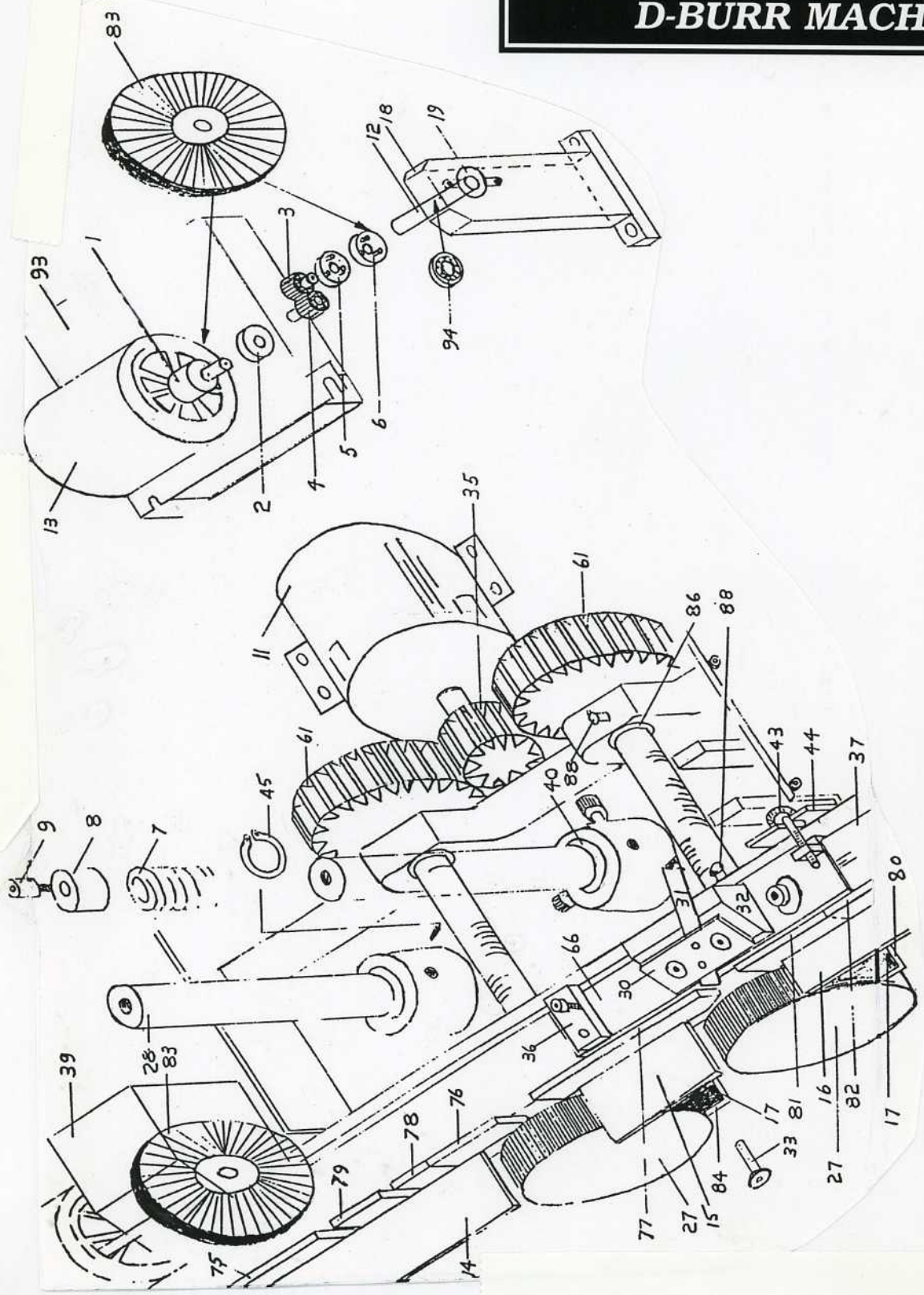
METAL WORKING TOOLS - SHEET / PLATE FABRICATING

# MODEL 121 D-BURR MACHINE

## Parts - Model 121 Detail View

KEY #	PART #	PART DESCRIPTION	KEY #	PART #	PART DESCRIPTION	KEY #	PART #	PART DESCRIPTION
1	6168	Brush Arbor	29	6069	Ball Bearing	57	3118	Wiper Bracket Right
2	6166-2	Brush Spacer Cap	30	3132	Top Plate Toolholder	58	3117	Wiper Holder (Clamp)
3	6253	Steel Gear YB-20	31	7104	Cobalt Tribit (1st Stage)	59	3119	Wiper Bracket Left
4	6254	Phenolic Gear YBP-20	32	3135	"V" Block Toolholder	60	1183	Top Casting Right (First Stage)
5	6166-1	Spacer Left	33	3444	Brass Screw (Felt Wiper Clamp)	61	2024-B	Phenolic Gear (26 Tooth)
6	6165	Spacer Right (Threaded)	34	2023-A	Steel Gear (26 Tooth)	62	1184	Top Casting Left (Second Stage)
7	1230	Tension Spring	35	2025	Spigel Drive Gear (15 Tooth)	63	2140	Roller Guard Spacer Right
8	1099	Tension Spring Cap	36	3131	Toolholder Holddown Block	64	2139	Roller Guard Spacer Left
9	1443	Tension Spring Screw	37	3044	Marker Plate	66	3133	Base Plate (Toolholder)
10	1028	Jackscrew	38	1030	Thrust Bearing	67	1012	Bronze Bushing
11	2027	Gear Reducer Motor	39	6163	Brush Guard Assembly	72	6068	Ballbearing Holder
12	6167	Driven Shaft	40	1004	Plastic Collar (Center Post Clearance)	73	6070	Ballbearing Bushing
13	7073	Brush Motor	41	3268	Second Stage Adjustment Yoke	75	3126	Back Guide Left
14	3122	Brass Wear Bed Left	42	2019	Washer Cap (Roller Shaft)	76	3040	Carbide Insert Left
15	3124	Brass Wear Bed Center	43	3446	Brass Adjustment Screw	77	3185	Carbide Insert Center
16	3123	Brass Wear Bed Right	44	3050	First Stage Adjustment Yoke	78	3127	Back Guide Center (Right)
17	3034	Felt Pad	45	1005	Retaining Ring	79	3128	Back Guide Center (Left)
18	6169	Brush Bearing Holder (Boss)	46	3134	Baseplate Second Stage Toolholder	80	3033-B	Felt Wiper Clamp (Right)
19	6251	Flange Bearing	47	3136	"V" Block Second Stage Toolholder	81	3039	Carbide Insert Right
20	2141	Gear Guard Right	48	3137	Top Plate Clamp Second Stage Toolholder	82	3125	Back Guide (Right)
21	1013	Plastic Collar	49	7104-A	Second Stage Cobalt Tribit	83	6074	Abrasive Filament Brush
22	2142	Gear Guard Left	50	6057	Name Plate	84	3033-A	Felt Wiper Clamp (Left)
23	2144	Roller Guard Right	51	2143	Roller Guard Right	86	1006	Oilite Flange Bushing
24	6158	Brush Guard (on Holddown Arm)	53	2131	Top Roller Assembly	88	1007	1/4 Oil Cup (Short Shoulders)
25	6147	Holddown Arm (Roller Bearing)	54	1029	Jackscrew Knob	93	6164	Motor Mount (Brush Motor Assembly)
27	2130	Bottom Roller Assembly	55	1114	Casting Guide	94	6252	New Departure Bearing
28	1003	Center Post	56	1011	1/4 Oil Cup (Long)	97	2022	Thrust Bushing

# MODEL 121 D-BURR MACHINE



Detail View # 1 Model 121

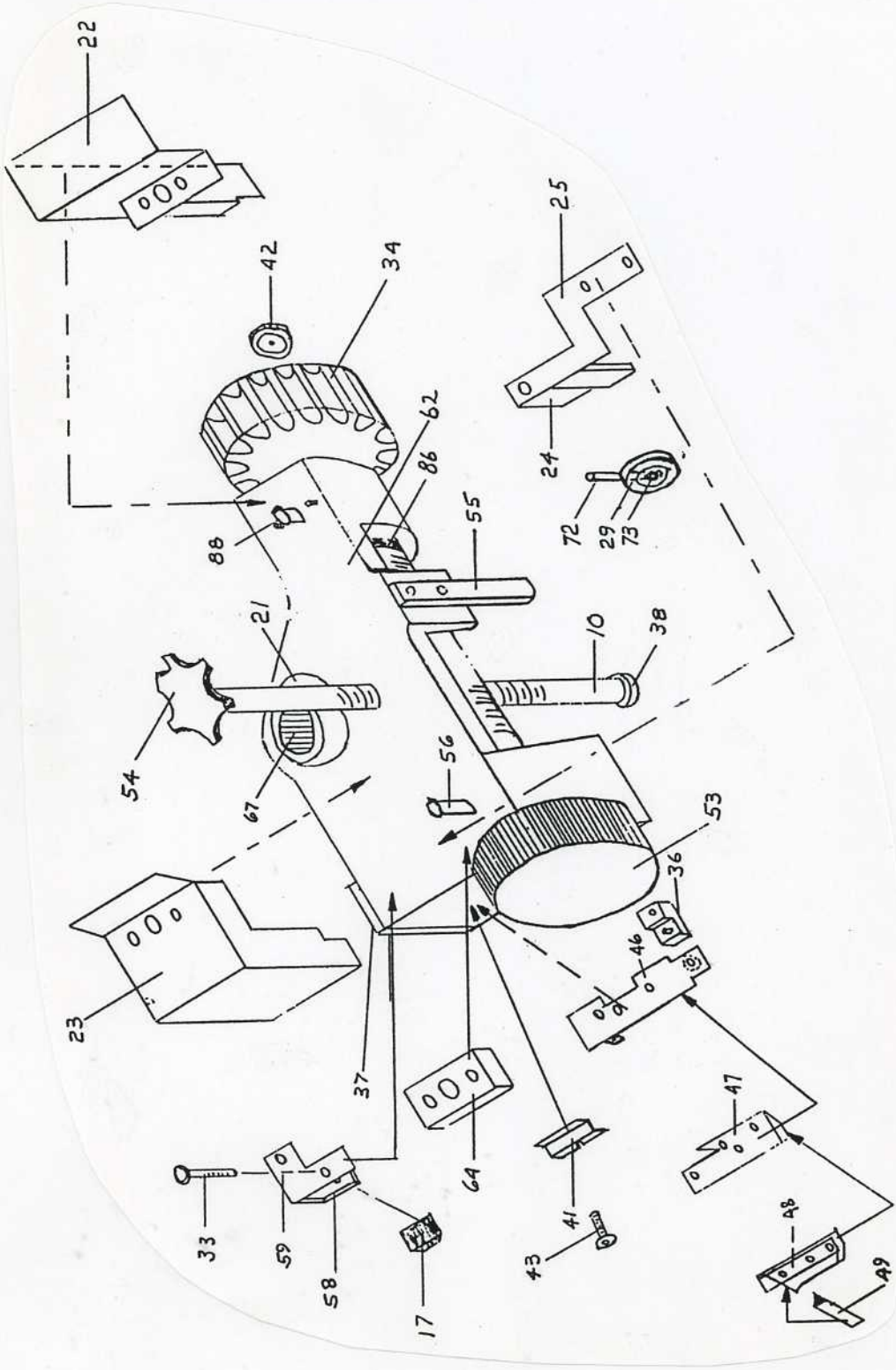
SALES — SERVICE — REPAIRS

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

METAL WORKING TOOLS - SHEET / PLATE FABRICATING

# MODEL 121 D-BURR MACHINE

## Detail View # 2 Model 121

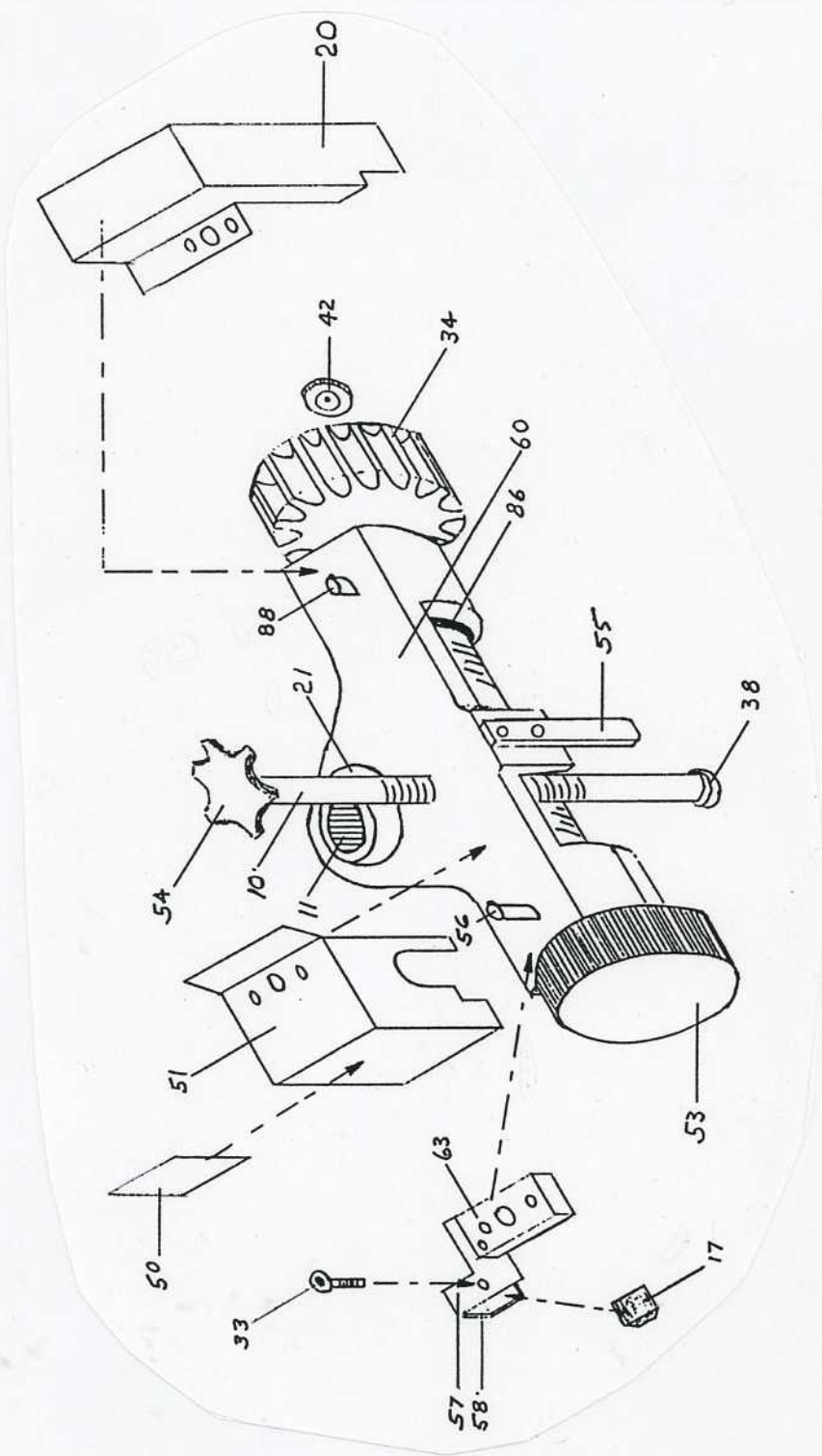


Second Stage

**MODEL 121  
D-BURR MACHINE**

**Detail View # 3 Model 121**

**First Stage**



**SALES — SERVICE — REPAIRS**

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

**METAL WORKING TOOLS - SHEET / PLATE FABRICATING**