ALFRA Edge Deburring Unit KFV

4 applications - 1 device

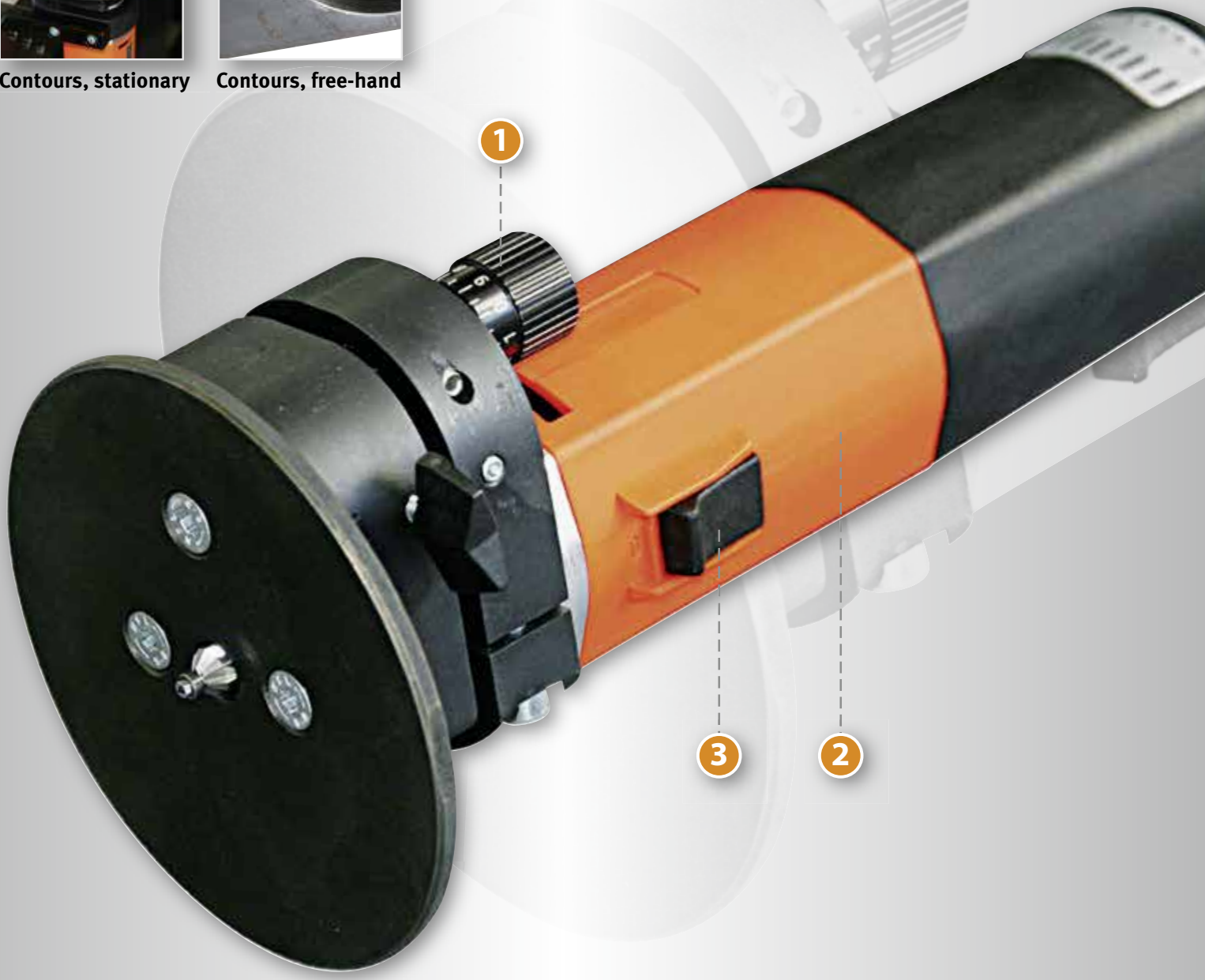
Prisms, free-hand

Prisms, stationary

Contours, stationary

Contours, free-hand

1. Infinitely variable bevel width setting using scale
2. With thermal and overload protection
3. On/Off switch



ALFRA EDGE MILLING UNIT - KFV

Drive motor (with clamping flange Ø 43 mm) 500 watts, speed control 11,000-25,000 rpm, quick-change fitting on the arbor of the attachments.

- **Contour milling fitting with support table, 72 x 64 mm**
- **Table milling fitting with support plate, Ø 120 mm**
- **Tool-less bevel height setting.**
- **Handy and powerful.**
- **For structural steel, stainless steel, aluminium and other materials.**
- **Also for radii**

Initial drill holes from:
Ø 3.0 mm for pin cutters
Ø 5.0 mm in spherical cutters

Technical specifications:

Bevel angle:	**45°**
Bevel width 45°:	**1-3 mm infinitely adjustable**
Radius:	**R = 1.0 - 1.5 - 2.0**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Rating:	**500 W**
Rotational speed:	**11,000 - 25,000 min^{-1} with Smooth start with thermal and overload protection**
Feed:	**manual**
Weight:	**1.8 kg**

Scope of delivery:

- **KFV deburring and bevelling device, drive motor with clamping flange Ø 43 mm**
- **Quick-change fitting for use with attachments**
- **Contour milling fitting with support table, 72 x 64 mm**
- **Table milling fitting with support plate, Ø 120 mm**
- **Prism milling fitting with guide rails 150 mm length**
- **Clamping shank for vice**
- **Collet 6 mm (mounted), collet 8 mm (included)**
- **1 set of operating tools**
- **Carrying case**
- **Guide stop for outer edges**

		Prod.-No.
Edge deburring unit, KFV complete	230V 50-60 Hz	25260
Edge deburring unit, KFV complete	110V 50-60 Hz	25260.110

ALFRA Edge Deburring Unit

KFH 150

1. High-performance motor with double-bearing-mounted milling spindle
2. Full-wave control electronics
3. Fine adjustment to milling depth/bevel width
4. Guidance handle
5. Clamping handle for quick adjustment
6. Guide rails made of high-strength special steel

ALFRA Edge Deburring Unit - KFH 150

The unit enables work pieces to be worked wherever machined edge milling is too expensive.

Hand-operated model for 45° deburring of larger work pieces, profiles, supports, sheet metal panels, with 90° mounting.

- **Hand-operated, for 45° bevels.**
- **Optimal guidance and safe handling.**
- **Commercially available solid carbide cutter Ø 8 mm.**

Technical specifications:

Prism mounting 45°:	**L = 150 mm**
	W = 20/40 mm
End mill:	**Solid carbide as per DIN, 8 mm Ø**
Max. bevel width:	**1 - 5 mm, depending on material, with fine adjustment**
High-performance motor	**with full-wave control electronics**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Motor performance:	**1,050 W**
Electronics:	**8,000 – 25,000 min^{-1}**
Clamping neck Ø:	**43 mm**
Weight:	**3.5 kg**

Scope of delivery:

- **Edge deburring unit KFH 150**
- **1 set of guide rails**
- **1 collet 8 mm Ø and clamping nut**
- **1 Operating instructions**

		Prod.-No.
Edge deburring unit, KFH 150	230V 50-60 Hz	25100
Edge deburring unit, KFH 150	110V 50-60 Hz	25100.110
Adapter head for edge deburring unit KFH 150		25109

Cost reduction:
Most of the cutting area can be accessed by moving the milling cutter in the collet.

ALFRA EDGE DEBURRING UNIT

KFT 250

1. High-performance motor with double-bearing-mounted milling spindle
2. Full-wave control electronics
3. Fine adjustment to milling depth/bevel width
4. Clamping handle for quick adjustment
5. Guide rails made of high-strength special steel
6. Chip collection container
7. Rubber feet for smooth operation and excellent stability

ALFRA Edge Deburring Unit - KFT 250

Simple, cost-effective deburring unit for light to medium use.

To obtain perfectly milled surfaces with DIN 6527 solid carbide end mills in rolling sections with no secondary milling

Position I: Material thickness from 4.5 mm

Position II: Material thickness from 1.0 mm

Cost reduction:
Most of the cutting area can be accessed by moving the milling cutter in the collet.

Technical specifications:

Deburring area:	**Bevel angle 45°**
Prism mounting position I:	**Material thickness from 4.5 mm**
position II:	**Material thickness from 1.0 mm**
Prism mounting:	**L = 250 mm**
Guide rail:	**W = 40 mm**
Max. bevel width:	**5 mm, depending on material. Also for stainless steel when selecting a suitable-milling cutter and RPM control, and cuts (spray edges with cutting oil).**
Weight:	**5.0 kg**
High-performance drive motor:	**1,050 W**
Triple bearing	
Double bearing-mounted milling spindle	
Spindle bearings with high-speed lubrication	
Standard clamping flange Ø:	**43 mm**
Infinitely variable speed control:	**8,000 - 25,000 min^{-1}**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Full-wave control electronics	
When under load, the tachogenerator provides additional power.	

Foot switch (optional)
Prod.-No. 25116

Scope of delivery:

- **Edge deburring unit KFT 250, with fine milling depth adjustment**
- **1 set of guide rails**
- **1 collet 8 mm Ø and clamping nut**
- **1 chip collection container**
- **1 set of operating tools**
- **1 Operating instructions**

		Prod.-No.
Edge deburring unit, KFT 250	230V 50-60 Hz	25110
Edge deburring unit, KFT 250	110V 50-60 Hz	25110.110
Table for edge deburring unit KFT 250		25111
Special accessories:		
ALFRA foot switch with device cable socket	230V	25116
ALFRA foot switch with device cable socket	110V	25116.110

ALFRA Edge Deburring Unit

KFH 250

1. High-performance motor with double-bearing-mounted milling spindle
2. Full-wave control electronics
3. Fine adjustment to milling depth/bevel width
4. 30° - 45° – 30° swivelling
5. Ergonomically shaped guide hand grip
6. Clamping handle for quick adjustment
7. Guide rails made of high-strength special steel
8. Guide rollers facilitate feeding

ALFRA Edge Deburring Unit - KFH 250

Hand-held model specially developed for working on edges (visible edges) and bevelling up to 60° on large rectangular work pieces.

- **A vital accessory for mechanical engineering.**
- **Wide speed range for different materials.**
- **Individually adjustable milling depth.**
- **Easy to handle and guide with two support rollers.**

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Fine adjustment to milling depth/bevel width

Cost reduction:
Most of the cutting area can be accessed by moving the milling cutter in the collet.

Technical specifications:

Prism mounting:	**L = 250 mm** **W = 70 mm**
End mill Ø:	**12 mm DIN 6527**
Max. bevel width:	**14 mm (depending on the material)**
Edge angle:	**infinitely adjustable swivelling right and left. Also for radii r = 3.0, 4.0, 5.0 using radii solid-carbide milling cutter**
Rating:	**1,800 W (high-quality motor for difficult deburring tasks)**
Infinitely variable speed control:	**2,500 – 23,500 min^{-1}**

Full-wave control electronics
When under load, the tachogenerator provides additional power.

Clamping neck Ø:	**63 mm**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Weight:	**12.8 kg**

Scope of delivery:

- **Edge deburring unit KFH 250, with fine milling depth adjustment**
- **1 set of guide rails with two support rollers**
- **1 collet Ø 12 mm and clamping nut**
- **1 set of operating tools**
- **1 Operating instructions**

		Prod.-No.
Edge deburring unit, KFH 250	230V 50-60 Hz	25130
Edge deburring unit, KFH 250	110V 50-60 Hz	25130.110
Adapter head for edge deburring unit KFH 250		25131

Prism mounting and support rollers made of wear-resistant plastic upon request.

ALFRA Edge Deburring Unit

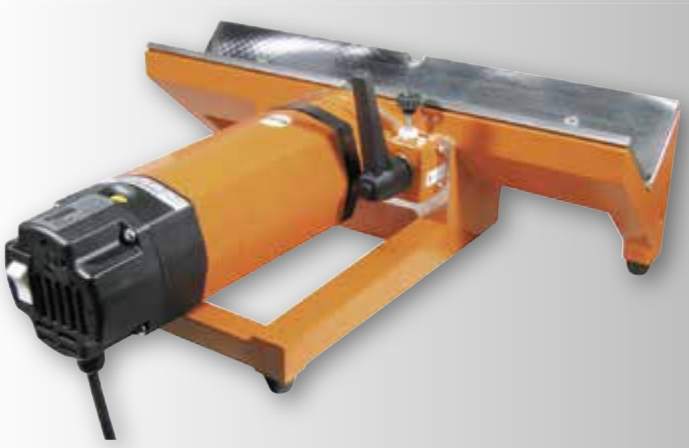
KFT 500

1. High-performance motor with double-bearing-mounted milling spindle
2. Full-wave control electronics
3. Fine adjustment to milling depth/bevel width
4. Clamping handle for quick adjustment
5. Guide rails made of high-strength special steel
6. Chip collection container
7. Rubber feet for smooth operation and excellent stability

ALFRA Edge Deburring Unit - KFT 500

For medium- and large-sized work pieces.
Max. bevel width 14 mm

To obtain perfectly milled surfaces with solid carbide end mills in rolling sections with no secondary milling.



Precise deburring by rolling milling

Foot switch (optional)
Prod.-No. 25116

Fine adjustment to milling depth/bevel width

Position I: Material thickness 6-14 mm

Position II: Material thickness from 1.5 mm

Cost reduction:
Most of the cutting area can be accessed by moving the milling cutter in the collet.

Technical specifications:

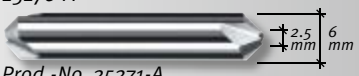
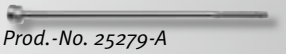
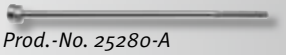
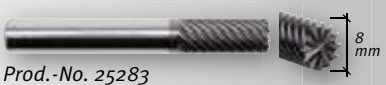
Deburring area:	**Bevel angle 45°**
Prism mounting position I:	**Material thickness 6-14 mm**
position II:	**Material thickness from 1.5 mm**
Prism mounting:	**L = 500 mm**
Guide rail:	**W = 70 mm**
Max. bevel width:	**14 mm, depending on material**
	Also for stainless steel when selecting a suitable-milling cutter and RPM control, and cuts (spray edges with cutting oil).
	Also for radii R 3.0, 4.0, 5.0 using radius solid carbide cutter
High-performance drive motor:	**1,800 W**
Triple bearing, double bearing-mounted milling spindle	
Spindle bearings with high-speed lubrication	
Clamping neck Ø:	**63 mm**
Infinitely variable speed control:	**2,500 – 23,500 min^{-1}**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Full-wave control electronics	
When under load, the tachogenerator provides additional power.	
Weight:	**18 kg**

Scope of delivery:

- **Edge deburring unit KFT 500, with fine milling depth adjustment**
- **1 set of guide rails**
- **1 collet Ø 12 mm and clamping nut DIN 6499**
- **1 chip collection container**
- **1 set of operating tools**
- **1 Operating instructions**

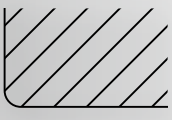
		Prod.-No.
Edge deburring unit, KFT 500	230V 50-60 Hz	25140
Edge deburring unit, KFT 500	110V 50-60 Hz	25140.110
Table for edge deburring unit KFT 500		25141
ALFRA foot switch with device cable socket	230V	25116
ALFRA foot switch with device cable socket	110V	25116.110

Shorter run times and motor-saving work.
Function: Foot switch pressed - socket is live
Foot switch released - power supply interrupted

Description	Prod.-No.				
Solid carbide milling cutter 90° Ø 6 mm, tip Ø 2.5 mm, length 31 mm, 3 cuts Suitable for: stainless steel, cast iron	25270-A	■	■		 Prod.-No. 25270-A
Solid carbide milling cutter 90° Ø 6 mm, tip Ø 2.5 mm, length 31 mm, 5 cuts Suitable for: stainless steel, cast iron	25271-A	■	■		 Prod.-No. 25271-A
Solid carbide milling cutter radius R = 0.5 Ø 6 mm, tip Ø 2.9 mm, length 31 mm, 3 cuts Radius R = 0.5 Suitable for: stainless steel, cast iron	25272-A	■	■		 Prod.-No. 25272-A
Solid carbide milling cutter radius R = 1.0 Ø 6 mm, tip Ø 2.9 mm, length 31 mm, 3 cuts Suitable for: stainless steel, cast iron	25273-A	■	■		 Prod.-No. 25273-A
Solid carbide milling cutter radius R = 1.5 Ø 6 mm, tip Ø 2.9 mm, length 31 mm, 3 cuts Suitable for: stainless steel, cast iron	25274-A	■	■		 Prod.-No. 25274-A
Solid carbide milling cutter radius R = 1.0 Ø 10 mm, tip Ø 4.8 mm, length 30 mm, 6 cuts Suitable for: stainless steel, cast iron	25275-A	■	■		 Prod.-No. 25275
Solid carbide milling cutter radius R = 1.5 Ø 10 mm, tip Ø 4.8 mm, length 30 mm, 6 cuts Suitable for: stainless steel, cast iron	25276-A	■	■		 Prod.-No. 25276-A
Solid carbide milling cutter radius R = 2.0 Ø 10 mm, tip Ø 4.8 mm, length 30 mm, 6 cuts Suitable for: stainless steel, cast iron	25277-A	■	■		 Prod.-No. 25277-A
Solid carbide milling cutter 90° Ø 10 mm, tip Ø 4.8 mm, length 30 mm, 6 cuts Suitable for: stainless steel, cast iron	25278-A	■	■		 Prod.-No. 25278-A
Solid carbide milling cutter radius R = 2.0 Ø 10 mm, tip Ø 2.9 mm, length 30 mm, 3 cuts incl. thrust bearing Suitable for: stainless steel, cast iron	25284-A	■	■		 Prod.-No. 25284-A
Solid carbide milling cutter 45° Ø 10 mm, tip Ø 2.9 mm, length 30 mm, 3 cuts incl. thrust bearing Suitable for: stainless steel, cast iron	25285-A	■	■		 Prod.-No. 25285-A
Axes with thrust bearing Axes: Ø 1.5 mm - KL: Ø 3.0 mm) Suitable for deburring end mills with tips - Ø 2.5 - 2.9 mm	25279-A	■	■		 Prod.-No. 25279-A
Axes with thrust bearing Axes: Ø 1.5 mm - KL: Ø 5.0 mm) Suitable for deburring end mills with tips - 4.8 mm	25280-A	■	■		 Prod.-No. 25280-A
Solid carbide milling cutter with serration Ø 8 mm, 4 cuts Suitable for: Steel, stainless steel, cast iron	25281			■	 Prod.-No. 25281
Solid carbide milling cutter with serration Ø 8 mm, 6 cuts Suitable for: Steel, stainless steel, cast iron, brass, bronze	25282			■	 Prod.-No. 25282
Solid carbide milling cutter with serration Ø 8 mm, 12 cuts Suitable for: Steel, stainless steel, cast iron	25283			■	 Prod.-No. 25283

ALFRA - Solid Carbide Milling Cutters (similar to DIN 6527)

- This solid carbide end mill was developed for perfect deburring.
- The chips are removed from the motor spindle into the chip collection container
- or in the chip duct.
- Total length 60 mm or 80 mm.
- **Coated design**

	Ø	Cutting	Prod.-No.	Prod.-No.	Prod.-No.	Prod.-No.
Solid Carbide Milling Cutter End mill with larger chip spaces, suitable for large bevels on soft materials such as **aluminium** as well as brass, copper, and plastics. Universal application for steel and stainless steel.						
	8 mm	3	25150P	25150P		
	12 mm	3			25160P	25160P
Solid Carbide Milling Cutter End mill with larger chip spaces, suitable for larger bevels Universal application such as for **stainless steel**, as well as steel, cast iron, non-ferrous metals, plastics						
	8 mm	4	25151P	25151P		
	12 mm	4			25161P	25161P
Solid Carbide Milling Cutter Roughing, fine cord. For attaching welding bevels. For **steel**, as well as cast iron, stainless steel (universal milling cutter)						
	8 mm	4	25154P	25154P		
	12 mm	4			25163P	25163P
Solid carbide radius milling cutter* - Solid carbide radius end mill with 2 radius grooves for dual use - For rounding off work piece edges - Universally applicable. For hard materials, the radii should be created in successive steps with increasing milling depths. - The fine adjustment of the contour of the radii to the edge of the work piece is achieved using the axial displacement of the motor in the clamping holes.						
 	R 3.0	12 mm	5			25165	25165
	R 4.0	12 mm	5			25166	25166
	R 5.0	12 mm	5			25167	25167

*Delivery time upon request.

ALFRA Edge Deburring Unit

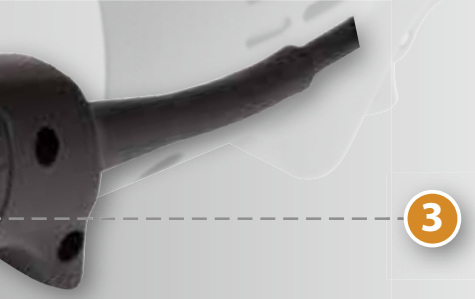
KFK 5

1. High-performance motor with Smooth start
2. Infinitely variable bevel width setting using scale
3. Ergonomically shaped hand grip with on/off switch
4. With thermal and overload protection

ALFRA Edge Deburring Unit - KFK 5

For deburring inner and outer edges, bevelling metal parts, milling radii and holes from Ø 20 mm.
Specially developed to produce clean visible edges and weld preparation.

- **Tool-less bevel height setting.**
- **Handy and powerful.**
- **For structural steel, stainless steel, aluminium and other materials.**
- **Multiple insert holders 45° (optional 30°).**
- **Also for radii R = 2.5**



Start holes from Ø 20 mm.

Technical specifications:

Bevel angle:	**45° (optional 30°, 60°)**
Bevel width 45°:	**Steel 0 - 5 mm 400 N/mm² steel infinitely variable**
	Steel 0 - 8 mm 250 N/mm² steel infinitely variable
Bevel width 30°:	**Steel 0 - 4 mm 400 N/mm² steel infinitely variable**
	Steel 0 - 6 mm 250 N/mm² steel infinitely variable
Radius:	**R = 2.5**
Motor voltage:	**230 V 50-60Hz; 110V 50-60Hz**
Rating:	**1,530 W**
Rotational speed:	**4,200 - 11,000 min^{-1} with Smooth start with thermal and overload protection**
Feed:	**manual**
Weight:	**4 kg**

Scope of delivery:

- **KFK 5 - Deburring and bevelling unit**
- **1 pc. 45° milling tool with inserts**
- **1 tool set**
- **Carrying case**
- **1 Operating instructions**

Prod.-No. 25207

	Prod.-No.
Edge deburring unit KFK 5 - with 45° milling head 230V 50-60 Hz	25200
Edge deburring unit KFK 5 - with 45° milling head 110V 50-60 Hz	25200.110
Edge deburring unit KFK 5 - with 30° milling head 230V 50-60 Hz	25201
Edge deburring unit KFK 5 - with 30° milling head 110V 50-60 Hz	25201.110
Additional Accessories:	
45° replacement milling head/radius R=2.5 (no inserts)	25202
30° replacement milling head (no inserts)	25203
60° replacement milling head (no inserts) upon request	25213
Adjustable guide stop for outer edges	25207
Tools:	
Insert PM25M for steel 13.47 x 3 coated	25206
Radius insert 2.5 mm	25205
Insert K10 for aluminium/cast iron	25208
Insert BK84 for steel/stainless steel	25209
Torx screws, individual, for replacement inserts	25210