

EASY DEBURRING with BARRIQUAN.



COMPLETE
METALWORKING
SOLUTIONS

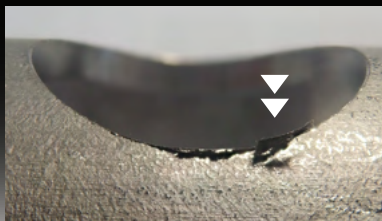
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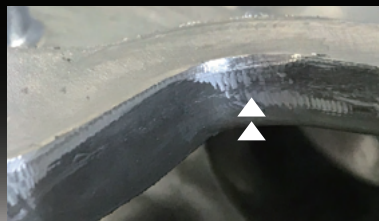


DEBURRING TOOL HOLDER BARRIQUAN BRQ-TX01 FOR MACHINING CENTERS

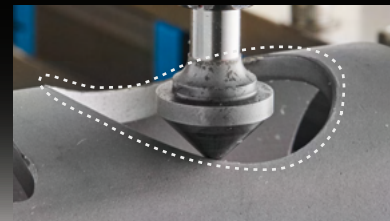
Barriquan's self-compensating tool holders solve many deburring challenges.



Remaining Burr



Cutting Too Deep



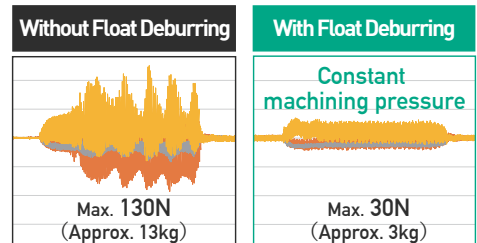
Complicated Workpiece Shape

What is Float Deburring?



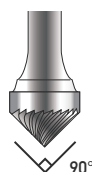
It is a machining method that prevents burrs from being left behind and workpieces from being over-shaved by aligning the tool to the shape of the workpiece at a constant pressure.

Machining Load Comparison



Suitable tools
for
Float Deburring

Cutters



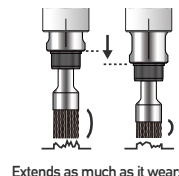
90° tip angle is recommended



More blades are better



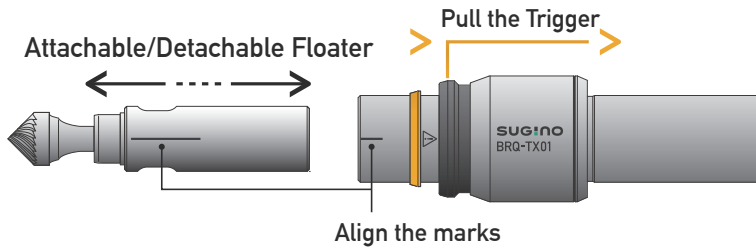
Brushes



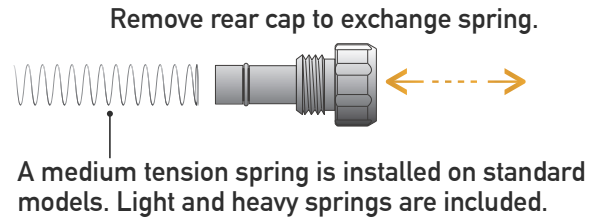
Extends as much as it wears out.

Brush should have cutting power at the tip of the bristles

1 Detachable Floater



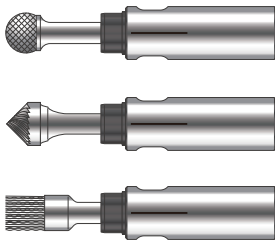
2 Exchangeable Spring



1 Quick Tool Change

The floater is **easily changed in 3 seconds** just by pulling the trigger.

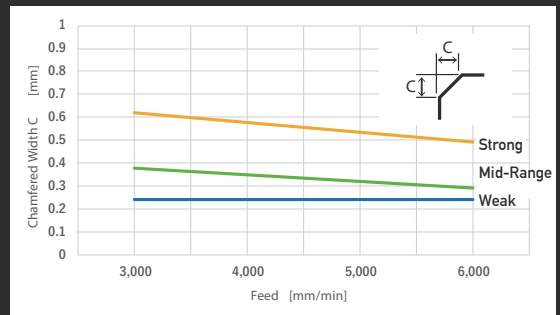
No tools are required for daily maintenance. Daily maintenance will extend the lifetime of Barriquan.



2 Manual Spring Change (No Tools Required)

Springs can be replaced manually, just by detaching the rear cap, no tools are required. You can choose the right spring for your specific needs.

Relationship between Feed Speed and Chamfer width by Spring



Machine = Sugino SC-V30a
Material = Steel
Rotation Speed = 8,000min⁻¹

Specifications

Model	BRQ-TX01
Series	BARRIQUAN
Shank size	φ20 X 40.5L
Length without shank	72mm
Body diameter	φ29
Weight	270g
Allowable rotation speed	12,000min ⁻¹
Collet	φ6 (standard)
	φ3 (option)
	φ6.35 = 1/4 inch (option)
	φ3.175 = 1/8 inch (option)
Spring	Medium (installed inside body when you receive)
	Weak (attached with BRQ-TX01)
	Strong (attached with BRQ-TX01)

Corresponds to allowable rotation speed of 12,000min⁻¹
High feed rate shortens CT and provides stable finishing.

Deburring examples at varied spindle speeds.

<p>Entrance area</p>	<p>Spindle speed 5,000 min⁻¹</p>	<p>Max. Chamfered Width 0.49mm Min. Chamfered Width 0.24mm</p> <p>Deburring width is not stable at entrance area.</p>
	<p>Spindle speed 12,000 min⁻¹</p>	<p>Max. Chamfered Width 0.37mm Min. Chamfered Width 0.37mm</p> <p>Deburring width is stable at higher spindle speeds, even from the start.</p>

Feed = 6,000 mm/min
Material = Steel

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