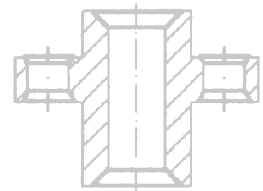
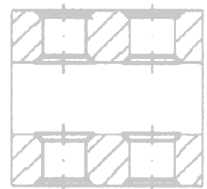


SNAP



CARBIDE Deburring & Chamfering Tools

*For All Purpose
Deburring and
Chamfering of
Through Holes,
Front and Back
in a Single Pass.*



HEULE

TOOL CORPORATION



SNAP

CARBIDE Deburring Tool



The SNAP Tool removes burrs and chamfers the front and back of through holes without stopping or reversing the spindle. SNAP is fast and accurate and does not damage the hole.

High Quality Consistent Chamfers

The SNAP blades are ground with a patented geometry developed by Heule to produce quality chamfers and eliminate secondary burrs. Different chamfer sizes can be achieved by selecting a different blade. There is no need for adjustments or operator intervention. In hard materials above Rc=28, request the SNAP-DF geometry.



Long Tool Life

The solid body design of the SNAP tool provides the highest durability of any deburring tool. Additionally, the coated carbide blades give longer tool life and faster operating speeds. This durability and blade life make SNAP the ideal choice for high volume manufacturers.



Wide Range of Standard Tools

SNAP tools are available from stock from 5mm to 25mm (0.197" to 0.984"). The SNAP Cassette makes it possible to deburr even larger holes quickly and efficiently and is also available from stock.

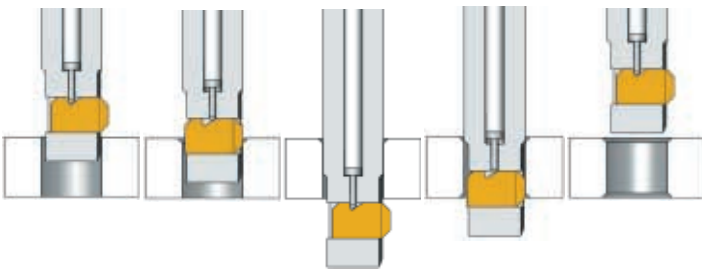


How Does The SNAP Tool Work?

As the rotating tool is fed into the hole, the front cutting edge deburrs the top of the hole by cutting a 45° chamfer. As the tool feeds into the part the blade is forced into the body and slides in the blade window.

When the blade is in the hole, only the ground gliding surface touches the hole protecting it from damage while the tool is fed through, the part. There is no need to stop or reverse the spindle.

When the blade reaches the back of the part the coiled spring acts with the control bolt to push it back out into cutting position. The back edge is deburred and chamfered as the tool is withdrawn. When the blade is again in the hole, the tool can be rapid fed out and on to the next hole.

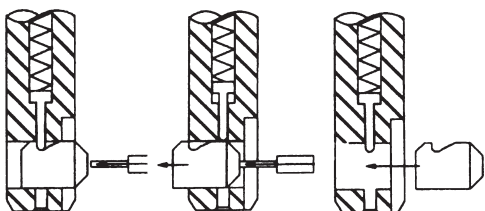


The fastest and most accurate choice for deburring through holes.

Quick Change Cutting Blades

The blade change is quick and easy. There are no tools required and it can be done with the tool in the spindle.

- Remove the blade by simply pushing it past center and out the back of the tool.
- Install the new blade by pushing it into the window until it 'snaps.'
- The tool is ready to run.



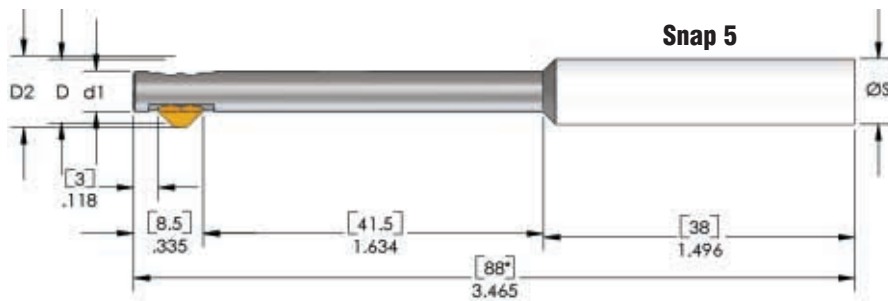
Automotive
Oil & Gas
Heavy Equipment
Aerospace
Medical
Power Generation
General Machining



Before & After

This low carbon steel automotive transmission component was drilled and reamed leaving a heavy burr causing problems with assembly and eventually transmission quality. The heavy burr was removed using a SNAP12-512 tool and a front and back cutting blade. With a clean and chamfered edge the part is now ready for assembly.





SNAP Deburring Series 5

For holes 0.197" through 0.315"

$\text{Ø}d1 = \text{Ø}d - 0.1\text{mm}$, $\text{Ø}D2 = \text{Ø}D + 0.6\text{mm}$

Order Number	Minimum Hole Ød Inches	mm	Shank Øs	Blade, Carbide-TiAlN, 90°, front and back Order Number (GH-Q-M-____) and (Chamfer ØD)		
SNAP5-5.0	.197	5.0	8mm	-30205 (6.0)	-30206 (6.5)	-30207 (7.0)
SNAP5-5.5	.217	5.5	8mm	-30206 (6.5)	-30207 (7.0)	-30208 (7.5)
SNAP5-6.0	.236	6.0	8mm	-30207 (7.0)	-30208 (7.5)	-30209 (8.0)
SNAP5-6.5	.256	6.5	8mm	-30208 (7.5)	-30209 (8.0)	-30210 (8.5)
SNAP5-7.0	.276	7.0	8mm	-30209 (8.0)	-30210 (8.5)	-30211 (9.0)
SNAP5-7.5	.296	7.5	8mm	-30210 (8.5)	-30211 (9.0)	-30212 (9.5)
SNAP5-8.0*	.315	8.0	10mm	-30211 (9.0)	-30212 (9.5)	-30213 (10.0)

* the overall length for SNAP5-8.0 is 98mm

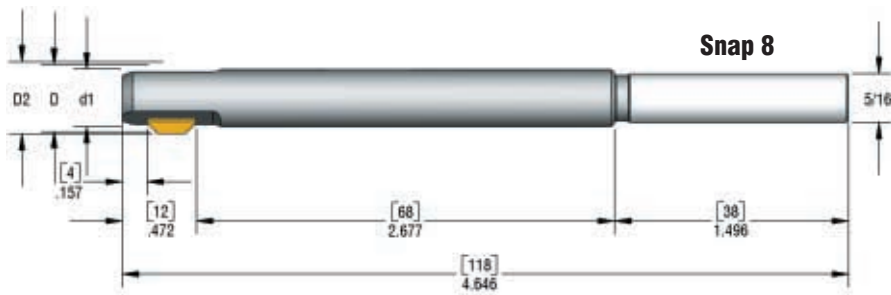
** for better performance in aluminum, use DLC coated blades by using the order number beginning with GH-Q-M-304XX

How to Order

The SNAP tool can accept different blade sizes to achieve different chamfer sizes. Choose the tool that best fits the hole diameter then choose a blade that best fits the chamfer requirements.

SNAP 5-6.0 - tool sized for a $\text{Ø}6\text{mm}$ hole

GH-Q-M-30209 - blade choice for up to a $\text{Ø}8\text{mm}$ chamfer

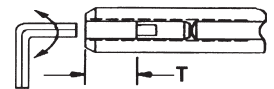


SNAP Deburring Series 8

For holes 0.315" through 0.472"

$\text{Ø}d1 = \text{Ø}d - 0.2\text{mm}$, $\text{Ø}D2 = \text{Ø}D + 0.8\text{mm}$

Order Number	Minimum Hole Ød Inches	mm	Shank Øs	Blade, Carbide-TiN, 90°, front and back Order Number (GH-Q-M-____) and (Chamfer ØD)		
SNAP8-315	.315	8.0	5/16"	-03720 (8.5)	-03721 (9.0)	-03722 (9.5)
SNAP8-335	.335	8.5	5/16"	-03721 (9.0)	-03722 (9.5)	-03723 (10.0)
SNAP8-354	.354	9.0	5/16"	-03722 (9.5)	-03723 (10.0)	-03724 (10.5)
SNAP8-374	.374	9.5	5/16"	-03723 (10.0)	-03724 (10.5)	-03725 (11.0)
SNAP8-394	.394	10.0	5/16"	-03724 (10.5)	-03725 (11.0)	-03726 (11.5)
SNAP8-413	.413	10.5	5/16"	-03725 (11.0)	-03726 (11.5)	-03727 (12.0)
SNAP8-433	.433	11.0	5/16"	-03726 (11.5)	-03727 (12.0)	-03728 (12.5)
SNAP8-453	.453	11.5	5/16"	-03727 (12.0)	-03728 (12.5)	-03729 (13.0)
SNAP8-472	.472	12.0	5/16"	-03728 (12.5)	-03729 (13.0)	-03730 (13.5)



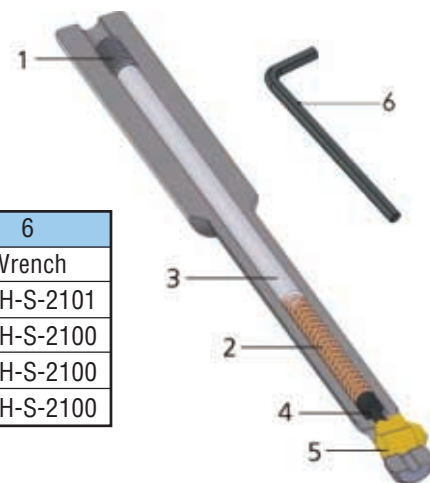
Adjusting the Cutting Force

A hexagonal wrench can be used to adjust the amount of cutting pressure behind the blade. Adjust the set screw (item 1 below) into the body for more cutting force.

Spare Parts

	1	2	3	4	5	6
	Set Screw	Spring	Distance Pin	Control Bolt	Blade	Wrench
SNAP5	GH-H-S-0127	GH-H-F-0019	GH-Q-E-0041*	GH-Q-E-0008	see tables	GH-H-S-2101
SNAP8	GH-H-S-0119	GH-H-F-0007	GH-Q-E-0028	GH-Q-E-0002	see tables	GH-H-S-2100
SNAP12	GH-H-S-0119	GH-H-F-0007	GH-Q-E-0032	GH-Q-E-0002	see tables	GH-H-S-2100
SNAP20	GH-H-S-0119	GH-H-F-0011	GH-Q-E-0031	GH-Q-E-0003	see tables	GH-H-S-2100

*For SNAP 5-8.0 use GH-Q-E-0068



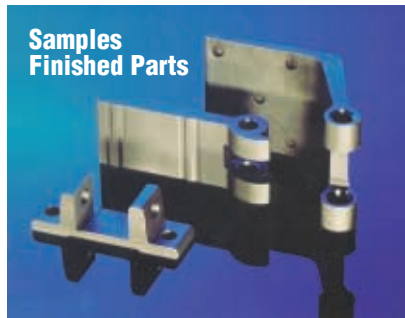
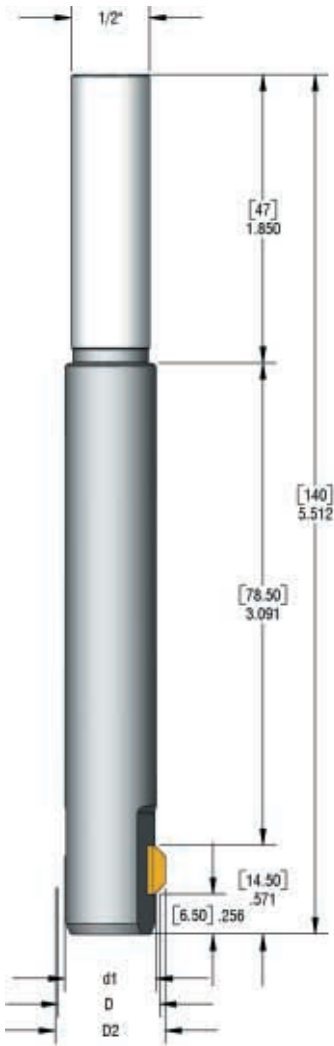
Snap 12

SNAP Deburring Series 12

For holes 0.472" through 0.787"

$\text{Ø}d1 = \text{Ø}d - 0.2\text{mm}$, $\text{Ø}D2 = \text{Ø}D + 0.8\text{mm}$

Order Number	Minimum Hole Inches	Ød mm	Shank Øs	Blade, Carbide-TiN, 90°, front and back Order Number (GH-Q-M-____) and (Chamfer ØD)		
SNAP12-473	.473	12.0	1/2"	-03741 (13.0)	-03742 (13.5)	-03743 (14.0)
SNAP12-492	.492	12.5	1/2"	-03742 (13.5)	-03743 (14.0)	-03744 (14.5)
SNAP12-512	.512	13.0	1/2"	-03743 (14.0)	-03744 (14.5)	-03745 (15.0)
SNAP12-531	.531	13.5	1/2"	-03744 (14.5)	-03745 (15.0)	-03746 (15.5)
SNAP12-551	.551	14.0	1/2"	-03745 (15.0)	-03746 (15.5)	-03747 (16.0)
SNAP12-571	.571	14.5	1/2"	-03746 (15.5)	-03747 (16.0)	-03748 (16.5)
SNAP12-591	.591	15.0	1/2"	-03747 (16.0)	-03748 (16.5)	-03749 (17.0)
SNAP12-610	.610	15.5	1/2"	-03748 (16.5)	-03749 (17.0)	-03750 (17.5)
SNAP12-630	.630	16.0	1/2"	-03749 (17.0)	-03750 (17.5)	-03751 (18.0)
SNAP12-650	.650	16.5	1/2"	-03750 (17.5)	-03751 (18.0)	-03752 (18.5)
SNAP12-669	.669	17.0	1/2"	-03751 (18.0)	-03752 (18.5)	-03753 (19.0)
SNAP12-689	.689	17.5	1/2"	-03752 (18.5)	-03753 (19.0)	-03754 (19.5)
SNAP12-709	.709	18.0	1/2"	-03753 (19.0)	-03754 (19.5)	-03755 (20.0)
SNAP12-729	.729	18.5	1/2"	-03754 (19.5)	-03755 (20.0)	-03756 (20.5)
SNAP12-748	.748	19.0	1/2"	-03755 (20.0)	-03756 (20.5)	-03757 (21.0)
SNAP12-768	.768	19.5	1/2"	-03756 (20.5)	-03757 (21.0)	-03758 (21.5)
SNAP12-787	.787	20.0	1/2"	-03757 (21.0)	-03758 (21.5)	-03759 (22.0)



SNAP Deburring Series 20

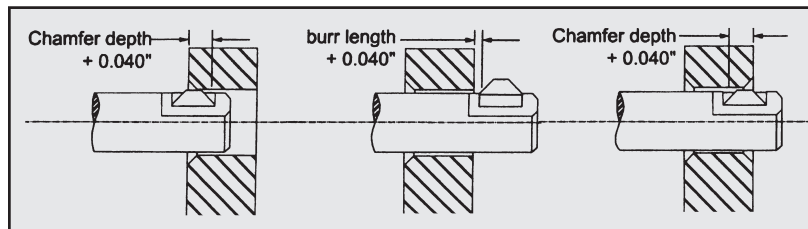
For holes 0.787" through 1.378"

Tools for hole diameters from 0.787" to 0.984" (21mm to 25mm) are available from stock. More details on these tools up to Ø35mm are available at www.heuletool.com.

SNAP Deburring Series Cassette

For holes from 1.378"

The SNAP cassette is used with custom holders for chamfering and deburring holes that are larger than Ø1.376" (35mm). More information about the SNAP Cassette and guidelines for the custom holders are available at www.heuletool.com.



Programming Information

	Typical Material	IPR	SFM
	aluminum	0.008-0.016	400-600
	iron	0.008-0.016	220-330
	low carbon steel	0.008-0.012	200-280
	med carbon steel	0.006-0.012	175-225
	stainless steel	0.005-0.010	150-225
	cast steel	0.006-0.012	180-250
	titanium	0.002-0.005	40-80
	free machining alloys	0.008-0.014	200-280

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Heule Tooling Systems

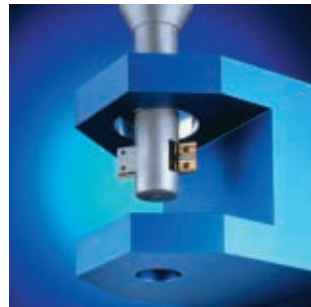
HEULE manufactures cutting tools of the highest quality and precision consistent with Swiss craftsmanship for use in the machine tools of some of the world's largest manufactures; and the smallest machine shops.



COFA

Universal deburring tool for even deburring on uneven surface

Product Line



GH-Z/E

Automatic front and back spotfacing systems



SNAP

Simple and economical front and back deburring tool



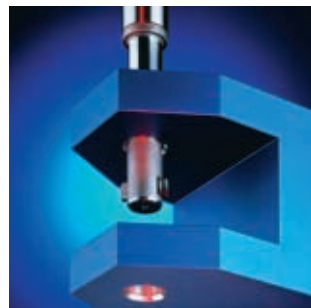
GH-K

Precision, chatter-free countersinks



SOLO

Reliable automatic front and back counterboring and spotface tool



DEFA

Adjustable front and back chamfering tool



Combi

Combine the latest technology for producing holes with our deburring and chamfering system

Let Heule technology solve your finishing problems - call today.

Heule Tool Corporation
4722 A Interstate Drive
Cincinnati, Ohio 45246

Tel: (513) 860-9900
Fax: (513) 860-9992
Email: info@heuletool.com
www.heuletool.com