



# Mate **ULTRAFORM**<sup>®</sup>, **Ultraform XT**<sup>™</sup>, & **Ultraform FX**<sup>™</sup> **Rollerball Deburr**<sup>™</sup> Tool Instructions

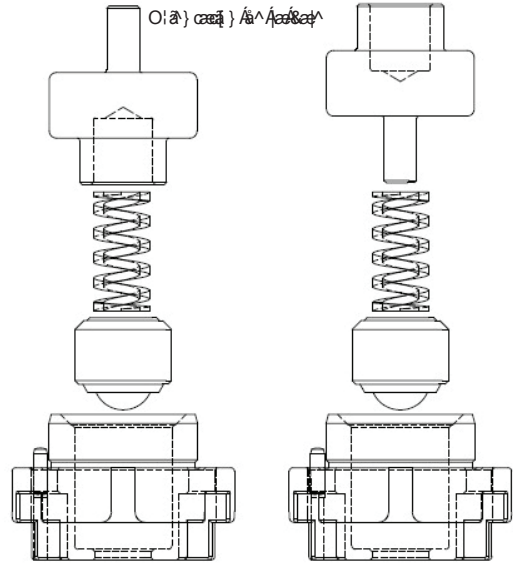
SY YWjcb`Xi`fYggcfhUXYeI UhYb`Z:bwjcb  
 XYg`a Uhj,,fYg`fUj Uj`fYg:

Configuration	Configuration	Configuration
B	B	B
A	A	A
B	B	B
Configuration	Configuration	Configuration
B	B	B
A	A	A
B	B	B
A	A	A
Configuration	Configuration	Configuration
A	A	A
B	B	B
A	A	A
A	A	A

cfh



8 ci l



Configuration A

Configuration B

## Suggestions Xfi h`j]gUjcb`Xi Mate **Rollerball Deburr**<sup>™</sup> Tool:

- The **Rollerball Deburr** tool should be used with the **Mate Sheetmarker**<sup>™</sup>.
- When setting up the tool in the CAM software, it is easiest to follow the edges of the part(s) on the CAD drawing. Depending on your CAM software, you might be able to run it as a nibble offset. You would be able to have the tool follow a path slightly (.02" or 0,5mm) outside of the edge of the part(s). Doing this might further improve edge quality.
- The tool has about .05" (1,25mm) of spring travel. Setting up the tool is very similar to any form tool. Start with the **ULTRAFORM**<sup>®</sup> holder turned as short as it will go and adjust the machine tool depth control and /or the **ULTRAFORM** tool so that the tool just starts to pinch the sheet. Then adjust either the **ULTRAFORM** holder or the machine settings to lower the tool about .02" (0,5mm). Hover height could be set like a punching tool.
- X and Y axis speed should be limited to 400 inches per minute or 10 meters per minute.
- The rollerballs in the **Rollerball Deburr** tool should be lightly oiled with ISO grade 68 or an automotive grade SAE 20 to 30 weight oil.
- Only clean sheets should be used with the **Rollerball Deburr** tool. Contaminants can get into the rollerballs and reduce the life of the product.
- The **Mate Rollerball Deburr** tool can be run over "snap apart tabs". However, the tabs will be weakened somewhat by this. It would be best to increase the width of the tabs by 10-20%.