sPINner Magnetic Deburring
Deburring | Polishing | Finishing

Superior deburring solution for the highest quality precision parts.

sPINner advantages:

- Batch deburr all your small, precision parts at once.
- Magnetized pin media provides unmatched finish quality.
- Deburr where hand deburring cannot.
- Great for irregular parts, internal holes, blind angles, cavities, etc.

Send us your parts for free testing. See the sPINner work for you!
Our deburring specialist will provide a complete report; including media used, deburring time.

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sPINner Machine Setup and Operation

How the sPINner Works

- A powerful magnet located inside the sPINner body activates a rotating magnetic field from under the sPINner well, stirring the contents within your sPINner tub.
- The tumbling action of the magnetized stainless steel pin media effectively deburrs, smooths rough edges, and polishes your parts for the highest quality finish possible.

Operation Procedure

- Choose the container based on the amount and size of your parts.
- Place a single layer of your parts on the bottom of the container, make sure your parts are not overlapping.
- Mix water & deburring solution for a 50:1 water to solution ratio. (Add more solution for brighter, shiny parts.)
- Secure lid to container.
- Enter cycle time, adjust speed / intensity, and press START. (Note: cycle time, media size, and parts quantity will depend on your specific application.)

Parts & Media Separation Procedure

- Slowly drain water/solution leaving parts and media.
- Place media and parts into the separation container.
- Turn the spin frequency to about 1/2 power. Turn on the machine for about 10 seconds.
- Stop the machine. Your parts should be trapped in the top of the separation container. The pins will be pulled through the separation container to the bottom. (Repeat until media and parts are fully separated.)
Applications Overview & Case-study Examples

sPINner Key Points:
- Deburring is fast and media will not harm part or affect tolerances.
- sPINner media lasts 3-5 years and is safe to handle during operation.
- Filtration system and parts separator available for high volume needs.
- Does not transfer material, will not introduce new particles to your parts.

Applications Include:
- Surface polishing
- Pre-electroplating processing
- Removing heat treat scaling
- Oxidized grease/film cleaning
- Removing rust/cleaning threads

Case-study Examples

<table>
<thead>
<tr>
<th>Case 1: Aluminum Gears</th>
<th>Before</th>
<th>After</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>1 9/16&quot; diameter x 5/16&quot; high</td>
<td></td>
</tr>
<tr>
<td>Problem</td>
<td>Soft material, irregular shape with burrs left in multiple gear gaps and rough edges.</td>
<td></td>
</tr>
<tr>
<td>Deburring Time</td>
<td>10 minutes.</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Case 2: Aluminum Cooling Fins</th>
<th>Before</th>
<th>After</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>4.75&quot; x 2.125&quot; x 2.75&quot;</td>
<td></td>
</tr>
<tr>
<td>Problem</td>
<td>Soft material with long burrs left in multiple thin slits and rough edges.</td>
<td></td>
</tr>
<tr>
<td>Deburring Time</td>
<td>15 minutes.</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Case 3: Stainless Steel Turned &amp; Machined Part</th>
<th>Before</th>
<th>After</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dimensions</td>
<td>3/4&quot; diameter x 1 7/16&quot; long</td>
<td></td>
</tr>
<tr>
<td>Problem</td>
<td>Rusty compact cylinder with burrs left in multiple cross-drilled holes.</td>
<td></td>
</tr>
<tr>
<td>Deburring Time</td>
<td>20 minutes.</td>
<td></td>
</tr>
</tbody>
</table>
**sPINner Machines and Media**

**Machines Include:**
- Deburring container
- PFS-747 deburring solution
- Media separator sieve

Choose media specific to your parts (see below).

### Machines Included

<table>
<thead>
<tr>
<th>Machine No.</th>
<th>L x W x H</th>
<th>Tank Size L x W</th>
<th>Container W x H</th>
<th>Power Supply</th>
<th>Amps</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>EHD-728</td>
<td>19&quot; x 19&quot; x 37&quot;</td>
<td>11&quot; x 11&quot;</td>
<td>9&quot; x 8&quot;</td>
<td>220V single phase</td>
<td>5</td>
<td>160 lbs.</td>
</tr>
<tr>
<td>EHD-735</td>
<td>23&quot; x 26&quot; x 34&quot;</td>
<td>15&quot; x 16&quot;</td>
<td>13&quot; x 9&quot;</td>
<td>220V single phase</td>
<td>10</td>
<td>220 lbs.</td>
</tr>
<tr>
<td>EHD-750</td>
<td>29&quot; x 30&quot; x 36&quot;</td>
<td>21&quot; x 23&quot;</td>
<td>19&quot; x 10&quot;</td>
<td>220V single phase</td>
<td>15</td>
<td>385 lbs.</td>
</tr>
<tr>
<td>EHD-765</td>
<td>37&quot; x 39&quot; x 43&quot;</td>
<td>29&quot; x 26.75&quot;</td>
<td>25&quot; x 10&quot;</td>
<td>220V single phase</td>
<td>10</td>
<td>516 lbs.</td>
</tr>
<tr>
<td>EHD-7200</td>
<td>58&quot; x 26.5&quot; x 43&quot;</td>
<td>50&quot; x 14&quot;</td>
<td>32&quot; x 12&quot;</td>
<td>220V three phase</td>
<td>15</td>
<td>1,100 lbs.</td>
</tr>
<tr>
<td>EDH-SFS200</td>
<td>12&quot; x 12&quot; 40&quot;</td>
<td>N/A</td>
<td>N/A</td>
<td>110V single phase</td>
<td>5</td>
<td>75 lbs.</td>
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<tr>
<td>ESS-660</td>
<td>18&quot; x 18&quot; x 26&quot;</td>
<td>18&quot; x 18&quot;</td>
<td>N/A</td>
<td>110V/220V</td>
<td>15</td>
<td>97 lbs.</td>
</tr>
</tbody>
</table>

### sPINner Media:

- SUS 304 stainless steel pins
- Hardened to HRC 30
- Magnetically treated for enhanced effectiveness

### Usage Tips:

- Use 0.5mm diameter media or larger for hard materials or to increase deburring power.
- Use 0.5mm diameter media or smaller for softer materials.
- Use 3mm length media for parts with small holes and crevices.
- Always use media with diameters smaller than the holes of your parts.
- For high-volume deburring needs order the EDH-SFS200 filtration system and 660 parts and media separator with your machine.

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