

## FCAL1 Process Sheet

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**Process Spec:** 1.3.3.1.1.2-2 – Tube De-Burring

**Components:** Copper Tube [4.2.7.1.2.1]

**Material:** Nitril Gloves  
Compressed Air/Nitrogen

**Tooling:** Drill Press  
Grinder  
60° Angle De-burring Tool  
Compressed Air/Nitrogen Gun

**Location:** UofA PAS 346 – Laboratory

**QC Form:** FCal1-QC-1.3.3.1.2-3 – De-Burring Inspection

### Process:

1. Gloves should be worn whenever tubes are handled.
2. Place de-burring cutter into drill press.
3. Set drill press to lowest speed.
4. De-burr both ends of selected tubes. De-burring diameter should be less than half of the tube's wall thickness.
5. Wire-brush each de-burred end with .10 wire wheel in grinder.
6. Remove de-burring debris with a blast of compressed air.
7. Place de-burred tubes in plastic bin for inspection (see process sheet [1.3.3.1.1.2-3](#)).
8. Note date and name of person completing de-burring on tube traveler form assigned to each batch.

### Remarks:

**Global Process:** [1.3.3.1.1.2](#) – Tube Processing

**Previous:** [1.3.3.1.1.2-1](#) – Visual Tube Inspection

**Follow-Up:** [1.3.3.1.1.2-3](#) – Tube De-Burring Inspection