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How to Deburr Holes and Edges

Drilling and cutting always leave burrs.

Which tool

Tool	Use	Source
Burring tool	Removes a burr from an edge of a sheet or from a hole	H-31 p. 4-14
Bearing scraper	Removes the burr round a drilled hole	p. 4-14
Metal countersink	Removes burrs round a hole; rotate by hand	pp. 4-14, 4-40
Drill bit larger than the hole	Same job; rotate by hand	pp. 4-14, 4-40
Deburring tool or oversize drill	AC 43.13-1B wants rivet holes deburred this way	AC par. 4-58
File	Removes rough edges and slivers from a finished part	p. 4-13
Step drill	Can deburr holes left by other bits	p. 4-17

Typical mistakes

Mistake	What happens	Fix
Leaving the burr	Rivets do not seat; scratched rivet and sheet	Remove burrs before riveting
Deburring with a power drill	Enlarged or damaged hole	Turn the bit or countersink by hand
Over-deburring	Takes the hole out of round, or a knife edge	Light touch; just break the burr
Chips left between sheets	Parts do not seat	Separate, clean, reassemble

Key points

- **Not approved data.** A deburring tool that takes away material from a countersink or hole may exceed the SRM's limits; check.
- **No depth figure.** The sources do not limit how much to remove; the aim is only to break the burr.

SOURCES · FAA-H-8083-31B, AMT Handbook: Airframe, Chapter 4 · FAA AC 43.13-1B CHG 1, Acceptable Methods, Techniques and Practices

SCAN · OPEN THIS GUIDE
theaviationpoint.com/standard-practices/tools/deburring-tool/

Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.