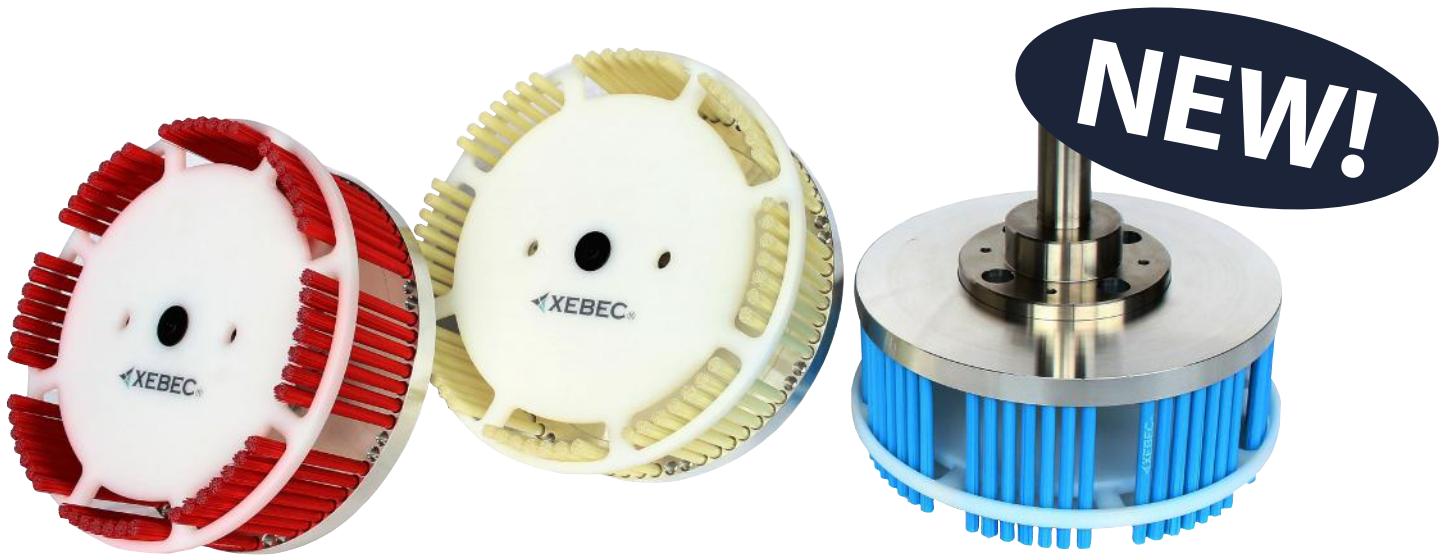


Surface Brush

extra large



For deburring and polishing large workpieces



Reduce number of passes! Process without lap marks!

Suitable for deburring and polishing workpieces
with a **width of 100mm or greater**,
such as cylinder heads, cylinder blocks and machinery beds.

XEBEC Brush™ Surface Extra-Large

Slide ring sold separately

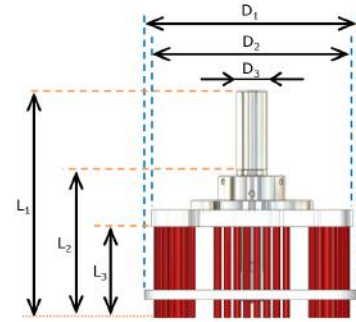
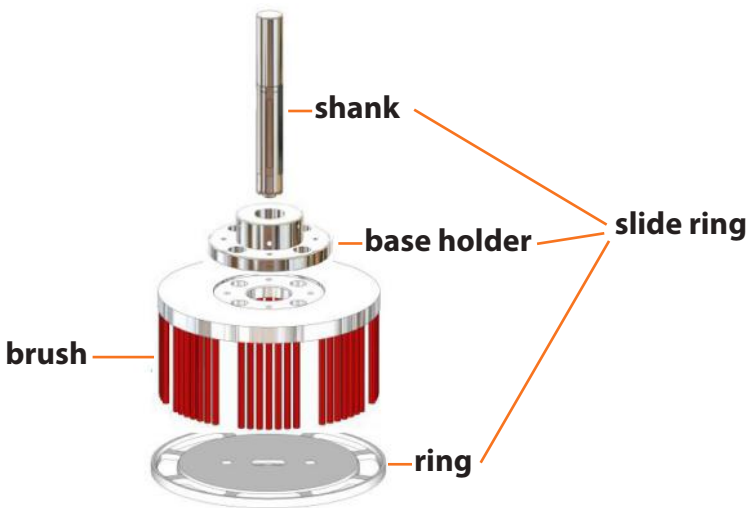
		Ø125mm	Ø165mm	Ø200mm
Brush Color	Red	A11-CB125M EDP 30025	A11-CB165M EDP 30028	A11-CB200M EDP 30031
	White	A21-CB125M EDP 30026	A21-CB165M EDP 30029	A21-CB200M EDP 30032
	Blue	A31-CB125M EDP 30027	A31-CB165M EDP 30030	A31-CB200M EDP30033
Slide Ring		SR125M EDP 40010	SR165M EDP 40011	SR200M EDP 40012

Surface Brush

extra large



Xebec Brush™ Surface Extra-Large Product Structure & Dimensions



Brush Diameter (mm)	L ₁ (mm)	L ₂ (mm)	L ₃ (mm)	D ₁ (mm)	D ₂ (mm)	D ₃ (mm)	Weight (lbs)
125	187	122	75	135	125	25	4.2
165				176	165		5.1
200				211	200		6.0

Xebec Brush™ Surface Extra-Large Parameters

Brush Diameter (mm)	Depth of Cut (mm)					Rotation Speed (mm-1)		Feed Rate (mm/min)			Recommended Brush Projection (mm)
	Vertical Burr	Horizontal Burr	Cutter mark removal	Polishing	Maximum	Recommended	Maximum	Burr Root Thickness (mm)		Cutter mark removal	
125	0.5	1.0	0.5~1.0	0.3~0.5	1.5	800	1000	0.05	0.1	300	15
165	0.5	1.0	0.5~1.0	0.3~0.5	1.5	600	750	0.05	0.1	300	15
200	0.5	1.0	0.5~1.0	0.3~0.5	1.5	480	600	0.05	0.1	300	15

Adjusting Parameters - Deburring

If burrs are not completely removed

- Increase the rotation speed in 25% increments; be aware of the maximum rotation speed
- Decrease the feed rate in 10 - 20 % increments

Edge is too rounded or you want to extend tool life

- Decrease the rotation speed in 25% increments
- Increase the feed rate in 10 - 20% increments

Uneven wear occurs on the brush

- Double the feed rate and process the workpiece using the round pass
- Rotate the brush in a counterclockwise direction for the return pass

Adjusting Parameters - Cutter Marks & Polishing

If cutter marks are not completely removed

- Increase the number of passes
- Increase the rotation speed in 25% increments; be aware of the maximum rotation speed

Cutter marks are removed but edge is too rounded or you want to extend tool life

- Decrease the rotation speed in 25% increments
- Increase the feed rate in 20 - 40% increments

Uneven wear occurs on the brush

- Double the feed rate and process the workpiece using the round pass
- Rotate the brush in a counterclockwise direction for the return pass