

Surface Brushes & accessories



XE BEC Brush™ Surface

Brush Dimensions				Aggressiveness				Required sleeve to hold brush (see below)	Max RPM
Diameter		Length		Less <<<<<<<<<>>>>>>> More					
mm	in	mm	in	Pink	Red	White	Blue		
6	0.236	30	1.181	A13-CB06M EDP 30015	A11-CB06M EDP 30006	A21-CB06M EDP 30012	A31-CB06M EDP 30021	S06M	10,000
15	0.591	50	1.969	A13-CB15M EDP 30013	A11-CB15M EDP 30005	A21-CB15M EDP 30011	A31-CB15M EDP 30020	S15M-P	6,000
25	0.984	75	2.953		A11-CB25M EDP 30004	A21-CB25M EDP 30010	A31-CB25M EDP 30019	S25M	5,000
40	1.575	75	2.953		A11-CB40M EDP 30003	A21-CB40M EDP 30009	A31-CB40M EDP 30018	S40M	3,000
60	2.363	75	2.953		A11-CB60M EDP 30002	A21-CB60M EDP 30008	A31-CB60M EDP 30017	S60M	2,000
100	3.937	75	2.953		A11-CB100M EDP 30001	A21-CB100M EDP 30007	A31-CB100M EDP 30016	S100M	1,000

XE BEC Brush™ Sleeve

Sleeve Description	EDP#	Dimensions							
		Shank				Sleeve external diameter		Overall Length	
		Diameter mm	Diameter in	Length mm	Length in	mm	in	mm	in
S06M	40006	6	0.236	29	1.142	10	0.394	70	2.756
S15M-P	40007	6	0.236	29	1.142	18	0.709	90	3.543
S25M	40004	8	0.315	30	1.181	30	1.181	140	5.511
S40M	40003	8	0.315	30	1.181	45	1.771	140	5.511
S60M	40002	12	0.472	40	1.575	65	2.559	150	5.906
S100M	40001	16	0.630	35	1.378	110	4.330	162	6.378



- Save time & money! Automate the deburring process
- Superior grinding force
- Consistent cutting edges
- Amazing polishing ability

Also available:



XE BEC Floating Holder™
Part number: FH-ST12
EDP: 50002

XE BEC Brush Length Adjustment Tool™
Part number: XP-EZ-001
EDP: 50004



Surface Brushes

operating parameters



Xebec Brush™ Surface Starting Operating Parameters for Automated Machining

	SFPM	Brush Diameter (mm)		6	15	25	40	60	100	FEED RATE	
		1st	2nd	RPM	RPM	RPM	RPM	RPM	RPM	finishing	deburring
Low Carbon Steel	600	WHITE	BLUE	9707	3883	2330	1456	971	582	47	94
Medium Carbon Steel	550	WHITE	BLUE	8898	3559	2136	1335	890	534	40	80
High Carbon Steel	500	WHITE	BLUE	8089	3236	1941	1213	809	485	34	67
Cast Steel	450	BLUE	WHITE	7280	2912	1747	1092	728	437	27	54
300 Series Stainless	525	WHITE	RED	8494	3397	2038	1274	849	510	47	94
400 Series Stainless	575	WHITE	RED	9303	3721	2233	1395	930	558	47	94
Grey Cast Iron	400	BLUE	WHITE	6471	2589	1553	971	647	388	54	107
Ductile Cast Iron	350	BLUE	WHITE	5662	2265	1359	849	566	340	47	94
Alloy Cast Iron	300	BLUE	WHITE	4854	1941	1165	728	485	291	40	80
Aluminum Cast Alloys	700	RED	WHITE	10000	4530	2718	1699	1132	679	80	161
Aluminum Diecast Alloys	800	RED	WHITE	10000	5177	3106	1941	1294	777	74	147
Aluminum Wrought Alloys	900	RED	WHITE	10000	5824	3495	2184	1456	874	67	134
Zinc Diecastings	800	RED	WHITE	10000	5177	3106	1941	1294	777	67	134
Copper	600	RED	WHITE	9707	3883	2330	1456	971	582	60	121
Brass, Free Machining	600	RED	WHITE	9707	3883	2330	1456	971	582	74	148
Cast Bronze	500	RED	WHITE	8089	3236	1941	1213	809	485	47	94
Nickel Alloys	200	BLUE	WHITE	3236	1294	777	485	324	194	40	80
Titanium Alloys	200	BLUE	WHITE	3236	1294	777	485	324	194	40	80
Plastic, Thermosetting	500	PINK	RED	8089	3236	1941	1213	809	485	80	161
Plastic, Thermoplastic	800	PINK	RED	10000	5177	3106	1941	1294	777	80	161

Starting parameters for deburring and polishing

Deburring Parameters

RPM: 80% of the maximum speed

D.O.C : 0.020" for vertical burr, 0.040" horizontal burr

Feed Rate: 160 inches/min when burr thickness is less than 0.004"^{*1} 100 inches/min more than 0.004"^{**2}

Polishing Parameters

RPM: 80% of the maximum speed

D.O.C: .0.012"

Feed Rate: 20 inches/min

*1 Burr can be bent by fingernail *2 Burr CANNOT be bent by fingernail

Material/Brush Choice

MATERIAL	1st Brush Choice	2nd Brush Choice
Aluminum	●	○
Steel	○	●
Hard to cut	●	○