

wheel Brush



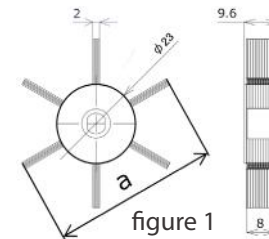
For deburring and polishing side surfaces and inner diameters

For use on machining centers or a combined lathe.



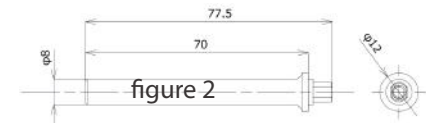
NEW!

The main brush unit and shank are sold separately. Insert a shank into a brush before use. Shanks are reusable. When replacing, order only a brush part.



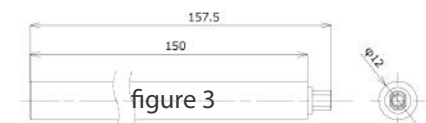
Main Brush Unit

EDP Number	Part Number	Brush Ø (mm)	# of bundles	Bristle (color)	Dimension
60007	W-A11-50	50	6	A11(red)	figure 1
60008	W-A11-75	75	6	A11(red)	figure 1



Shank

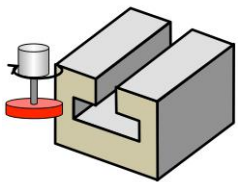
EDP Number	Part Number	Shank Length (mm)	Shank Ø	Set Screw	Dimension
60009	W-SH-M	70	8	M4	figure 2
60010	W-SH-L	150	12	M4	figure 3



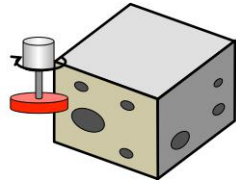
wheel Brush



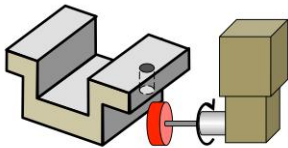
Applicable Work pieces



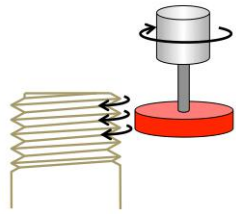
Side surface after end milling



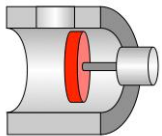
Side surface after drilling



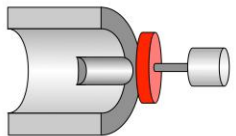
Back burr



Screw thread



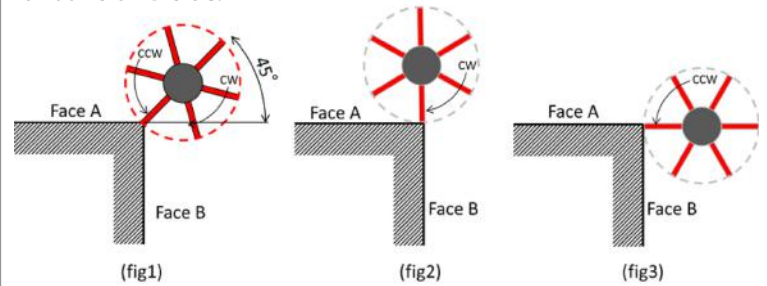
Inner diameter over $\varnothing 50\text{mm}$



Cutout

Processing Conditions

The best approach is to place a center of a brush at the center angle to the edge, figure 1. Burrs on A-side and B-side can both be removed. Edge quality becomes stable if a brush is rotated in both clockwise and counter-clockwise directions. Brush position on figure 2 is effective for burrs on A-side in the same way as figure 3 for burrs on B-side.



W-A11-50	Rotation Speed (min ⁻¹)	Feed Rate (mm/min)	Depth of Cut (mm)
Range of Use Recommended	955 ~ 2230 1590	Max 20070 4770	Max 0.5 0.2
W-A11-75	Rotation Speed (min ⁻¹)	Feed Rate (mm/min)	Depth of Cut (mm)
Range of Use Recommended	640 ~ 1490 1140	Max 14310 3420	Max 0.5 0.2

* As bristles are worn out, bristle length becomes shorter and increase stiffness, causing bristles to be broken. If bristles breakage occurs, please decrease the depth of cut.

- The process conditions may differ depending on burrs. Make adjustments according to the quality of the work piece
- If burrs remain, increase the number of passes
- To extend tool life, increase the feed per bundle

Examples

