

**Question:** What are the key operating parameters for cutting fiber brushes?

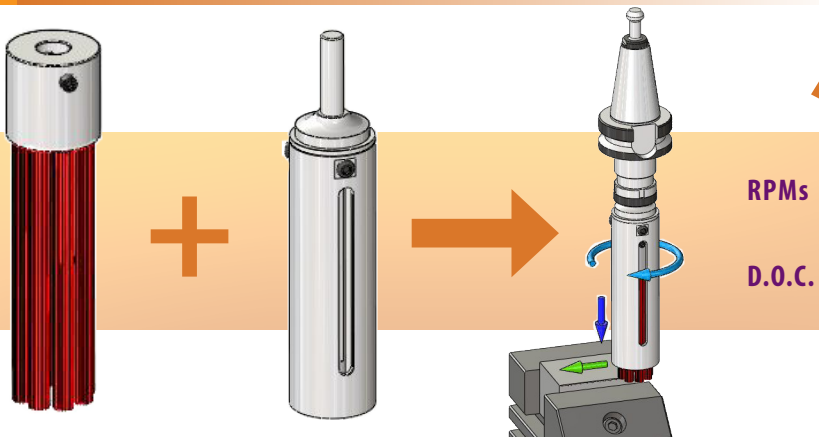
**Answer:**

**RPM:** Performs well between 60 - 80% of maximum RPM.

**Depth of Cut:** Keep 0.020 - 0.060 D.O.C. depending on the burr direction.

**Feed Rate:** Achieves optimal performance between 80 - 200 inches per minute. Higher feed rates are possible depending on the diameter of the brush and the material.

## HOW TO ATTACH ON CNC



- The use of coolant or oil prolongs tool life & improves surface finish.
- When brush projection is shorter than 0.200 inches, the fibers are more rigid & increases grinding power.
- When projection of the brush is greater than 0.200 inches, surface finish improves which increases part contouring.