

XEBEC BRUSH™ Floating Holder

EDP Shown: 50002

(EDPs 50006, 50005 use a single spring without bushings)

Floating Holder

Screw

Spring

(Standard)
Pre-Assembled

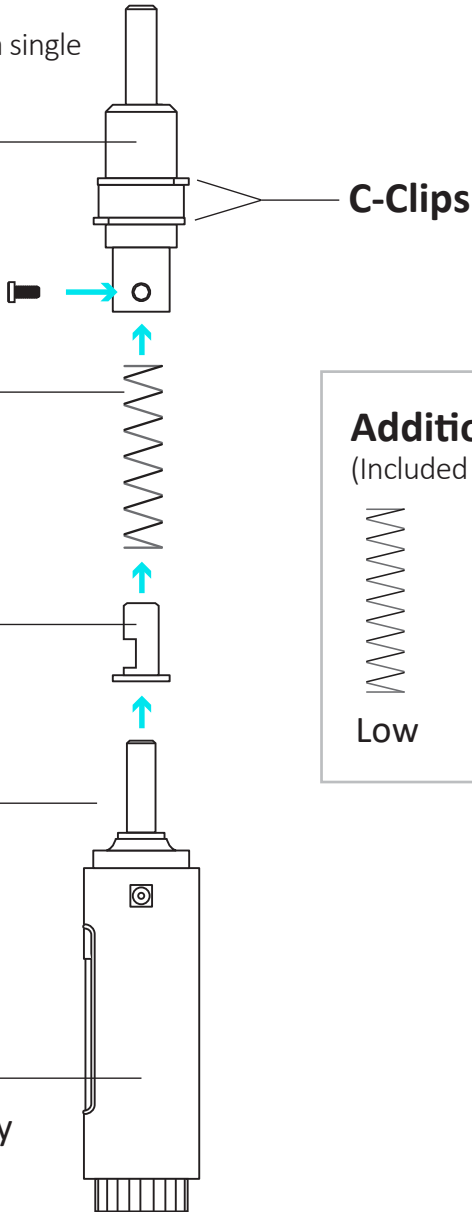
Bushing

Insert

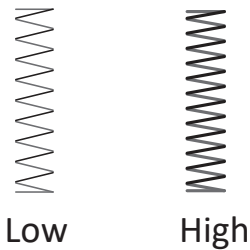
Tool Shank

Surface Brush and Sleeve

Purchased Separately



Additional Springs
(Included with EDP-50002)

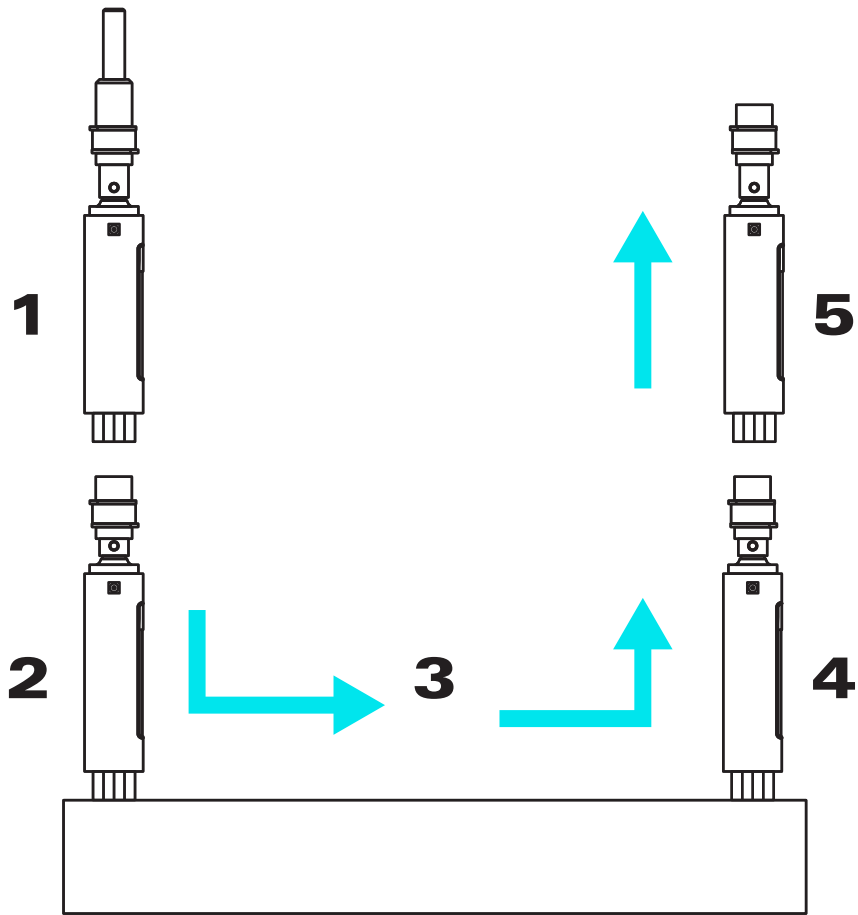


Best Applications

- Improve tool life and surface quality in deburring and surface finishing.
- Great for large parts or long runs.
- Requires less tool offsets due to preload, saving machine time.
- Consistent pressure maximizes results.

Tech Tips

- Must preload on part to be used effectively.
- After setting preload the tool must maintain contact with the same plane, without protrusions or openings in the workpiece that would interrupt the set tension.
- 6mm maximum stroke (preload)
- Spring tension is affected by tool weight. For EDP-50002 the high tension spring may be needed for heavier 25 and 40mm Brushes or when spindle is horizontal.
- Use EDP-50002 6, 15, 25, 40mm Brushes
- Use EDP-50006 for 60mm Brush
- Use EDP-50005 for 100mm Brush



Standard Operation

For Floating Holder to operate effectively, it is necessary to preload the spring by adding tension at the contact point before initiating feed.

1. While Brush is not in motion, lower it vertically until contacting the workpiece. *Do not contact side of Brush with workpiece as it will damage the bristles.*
2. Set the depth of cut and contract the spring (Preload).
3. Begin rotation and start feeding.
4. When complete, stop rotation and feed.
5. Remove the tool vertically.


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Use Ramping to Blur or Eliminate Tool Marks

Blending can be achieved by approaching on a downward arc with the brush rotating. Begin feed at the point where the depth of cut and preload of spring tension is set.


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