BRM

BRUSH RESEARCH
MANUFACTURING

NAMPOWER™
RESOURCE GUIDE

Information on Tool Selection,
Grit Selection, Suggested RPM's and More

BRUSHRESEARCH.COM

GENERAL APPLICATION AND SELECTION OF

NAMPOWER™

COMBINATION SILICON CARBIDE AND CERAMIC DISC BRUSHES

Brush Research Manufacturing is proud to offer the highest quality professional grade tools for deburring, edge radiusing and surface finishing applications on the market today: Nampower™ Disc Brushes. Composed of flexible abrasive nylon filaments bonded to a fiber reinforced thermoplastic base, these abrasive disc brushes contain a unique combination of both ceramic and silicon carbide abrasive that produce maximum burr removal rates and provides an optimum surface finish at the same time. The brushes are available in 2 different styles: Dot Style for general purpose deburring and surface finish applications and the Turbine Style brush for medium and heavy deburring applications.

These high-performance tools create reliable, consistent and cost effective results. Nampower™ Disc Brushes are easily integrated into today's automated machinery, CNC machining centers, transfer lines and robotic cells.

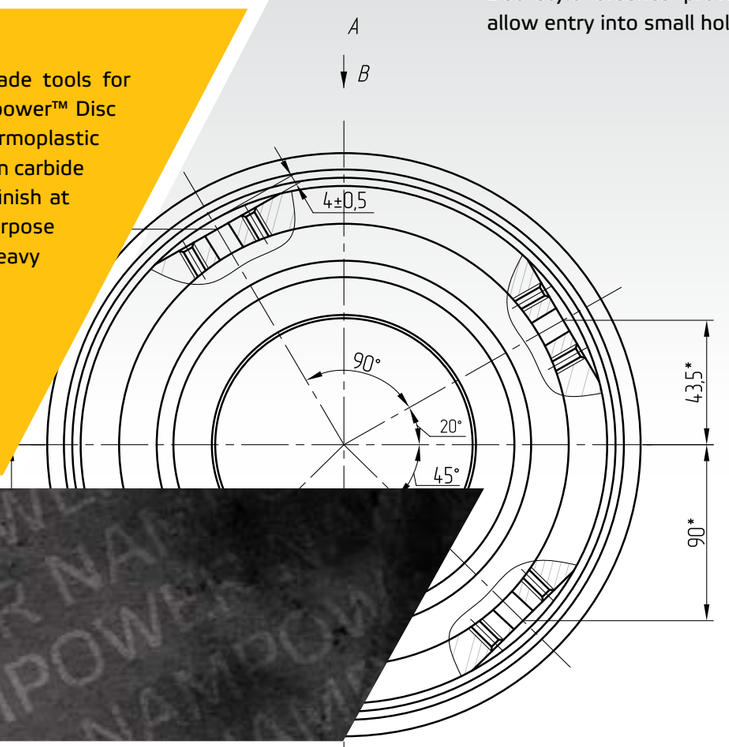
BRUSH SELECTION

DOT STYLE

Used for general purpose edge deburring and surface finishing applications. The Dot style is an economical choice for light deburring applications. Dot style brushes provide greater flexibility and allow entry into small holes and spaces with ease.

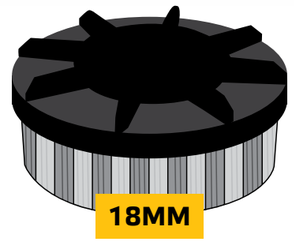
TURBINE STYLE

Ideal for medium and heavy deburring applications. The Turbine style brush has a high density fill that is ideal for short cycle times and long tool life.

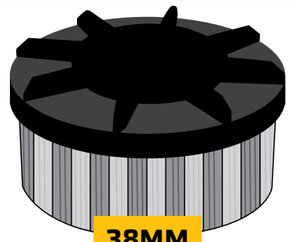


TRIM LENGTH SELECTION

The larger diameter Nampower disc brushes (100mm, 125mm, and 150mm) are available in 18mm and 38mm trim lengths. Smaller diameter disc brushes (50mm, 60mm and 80mm) have an 18mm trim length. Trim length selection is about flexibility versus aggressiveness. Longer trim lengths are less aggressive and more flexible while shorter trim lengths are less flexible and more aggressive. Burr size, part shape and conformity, radius requirements and final finish requirements are all factors affecting trim length selection.



18MM



38MM

DIAMETER	TRIM	GRIT	MSFS	PART # DOT	PART # TURBINE
50mm	18mm	80	6,500	ADD501880	ADT501880
50mm	18mm	120	6,500	ADD5018120	ADT5018120
50mm	18mm	180	6,500	ADD5018180	ADT5018180
50mm	18mm	320	6,500	ADD5018320	ADT5018320
60mm	18mm	80	5,500	ADD601880	ADT601880
60mm	18mm	120	5,500	ADD6018120	ADT6018120
60mm	18mm	180	5,500	ADD6018180	ADT6018180
60mm	18mm	320	5,500	ADD6018320	ADT6018320
80mm	18mm	80	4,000	ADD801880	ADT801880
80mm	18mm	120	4,000	ADD8018120	ADT8018120
80mm	18mm	180	4,000	ADD8018180	ADT8018180
80mm	18mm	320	4,000	ADD8018320	ADT8018320

HOLDER FOR SMALL DISC BRUSHES

PART #	SHANK DIAMETER	HOLDER TYPE
ADH16P	16mm	Standard Collet Flow Through

50mm, 60mm and 80mm brushes are designed to work with our small flow through coolant holder. The 16mm precision ground shank allows coolant to flow from the brush center. This results in better lubricant dispersion which permits the brush to run at greater cut depths and drastically reduces heat generation. These holders are made using a one-piece construction that results in greatly improved balance. All tool holders are heat treated and have a PVD coating for improved corrosion resistance and long life.

DIAMETER	TRIM	GRIT	MSFS	PART # DOT	PART # TURBINE
100mm	18mm	80	2,200	ADD1001880	ADT1001880
100mm	18mm	120	2,200	ADD10018120	ADT10018120
100mm	18mm	180	2,200	ADD10018180	ADT10018180
100mm	18mm	320	2,200	ADD10018320	ADT10018320
100mm	38mm	80	2,200	ADD1003880	ADT1003880
100mm	38mm	120	2,200	ADD10038120	ADT10038120
100mm	38mm	180	2,200	ADD10038180	ADT10038180
100mm	38mm	320	2,200	ADD10038320	ADT10038320
125mm	18mm	80	2,000	ADD1251880	ADT1251880
125mm	18mm	120	2,000	ADD12518120	ADT12518120
125mm	18mm	180	2,000	ADD12518180	ADT12518180
125mm	18mm	320	2,000	ADD12518320	ADT12518320
125mm	38mm	80	2,000	ADD1253880	ADT1253880
125mm	38mm	120	2,000	ADD12538120	ADT12538120
125mm	38mm	180	2,000	ADD12538180	ADT12538180
125mm	38mm	320	2,000	ADD12538320	ADT12538320
150mm	18mm	80	1,800	ADD1501880	ADT1501880
150mm	18mm	120	1,800	ADD15018120	ADT15018120
150mm	18mm	180	1,800	ADD15018180	ADT15018180
150mm	18mm	320	1,800	ADD15018320	ADT15018320
150mm	38mm	80	1,800	ADD1503880	ADT1503880
150mm	38mm	120	1,800	ADD15038120	ADT15038120
150mm	38mm	180	1,800	ADD15038180	ADT15038180
150mm	38mm	320	1,800	ADD15038320	ADT15038320

HOLDERS FOR LARGE DISC BRUSHES

PART #	SHANK DIAMETER	HOLDER TYPE
ADHLWMP	25mm	Standard Collet Flow Through
ADHLWMSL	25mm	Standard Sidelock Collet Flow Through

100mm, 125mm and 150mm brushes are designed to work with our large flow though coolant holder. The 25mm shank is available is standard or side-lock configuration and allows coolant to flow from the brush center resulting in better lubricant dispersion which permits the brush to run at greater cut depths and drastically reduces heat generation. The large holder is made using a carbon fiber reinforced thermoplastic material bonded to a hardened and ground steel shank which results in a more rigid, well balanced and lighter weight holder.

GENERAL APPLICATION AND SELECTION OF

NAMPOWER™

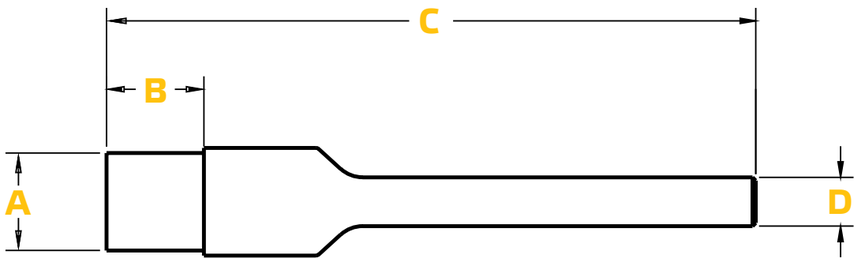
CERAMIC END BRUSHES

Brush Research's Nampower line of brushes have always stood for the best in abrasive finishing and deburring technology providing incredible performance and outstanding value. Now this high volume, production grade line is growing up and getting smaller. These all new brushes are available from 2" down to 1/2" (12.7mm), in a high density, solid end brush configuration that offers more cutting points for increased efficiency and performance. The machined aluminum and hard coat anodized cups hold state of the art ceramic abrasive filaments that have lasted 3-5 times longer than the competition during testing.

The wide range of grits available enable the tools to accomplish even the most challenging of deburring and surface finishing or prep applications. From removing extrusion type burrs, to achieving single digit Ra finishes. The long shank length lets you get down into the work wherever you need it and the tool is designed to be loaded directly into your automated machining center to get to work immediately with no special adaptors needed.

BRUSH DIAMETER

PART #	DIAMETER (A)		TRIM LENGTH (B)		OAL (C)		SHANK DIAMETER (D)		GRIT
	INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS	
AEB125880	1/2"	12.7mm	5/8"	16mm	4.88"	124mm	3/8"	9.5mm	.040/80
AEB1258120	1/2"	12.7mm	5/8"	16mm	4.88"	124mm	3/8"	9.5mm	.040/120
AEB1258180	1/2"	12.7mm	5/8"	16mm	4.88"	124mm	3/8"	9.5mm	.035/180
AEB1258320	1/2"	12.7mm	5/8"	16mm	4.88"	124mm	3/8"	9.5mm	.022/320
AEB343480	3/4"	19mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.040/80
AEB3434120	3/4"	19mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.040/120
AEB3434180	3/4"	19mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.035/180
AEB3434320	3/4"	19mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.022/320
AEB1003480	1"	25.4mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.040/80
AEB10034120	1"	25.4mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.040/120
AEB10034180	1"	25.4mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.035/180
AEB10034320	1"	25.4mm	3/4"	19mm	5"	127mm	3/8"	9.5mm	.022/320
AEB11210080	1-1/2"	38mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.040/80
AEB1121100120	1-1/2"	38mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.040/120
AEB1121100180	1-1/2"	38mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.035/180
AEB1121100320	1-1/2"	38mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.022/320
AEB20010080	2"	51mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.040/80
AEB200100120	2"	51mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.040/120
AEB200100180	2"	51mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.035/180
AEB200100320	2"	51mm	1"	25.4mm	5-1/4"	133.4mm	1/2"	12.7mm	.022/320



DIAMETER (A)

TRIM LENGTH (B)

OAL (C)

SHANK DIAMETER (D)

GRIT SELECTION

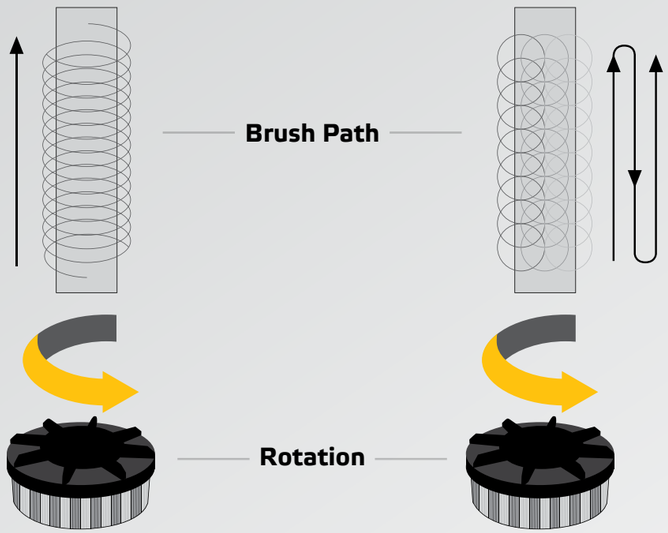
GRIT SELECTION	STARTING RA
80	50-60
120	40-50
180	30-40
320	20-30

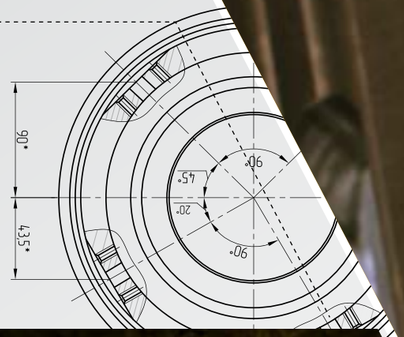
Grit selection is highly dependent on the starting surface finish and the amount of material refinement required. The general rule of thumb is to choose the coarsest grit possible that will still yield the required surface finish. A fine grit tool used on a coarse starting finish will have less effect on the overall finish improvement as a coarse grit tool followed by a finer grit tool. Coarse grits are recommended for use on heavier burrs or where a fine surface finish is not required.

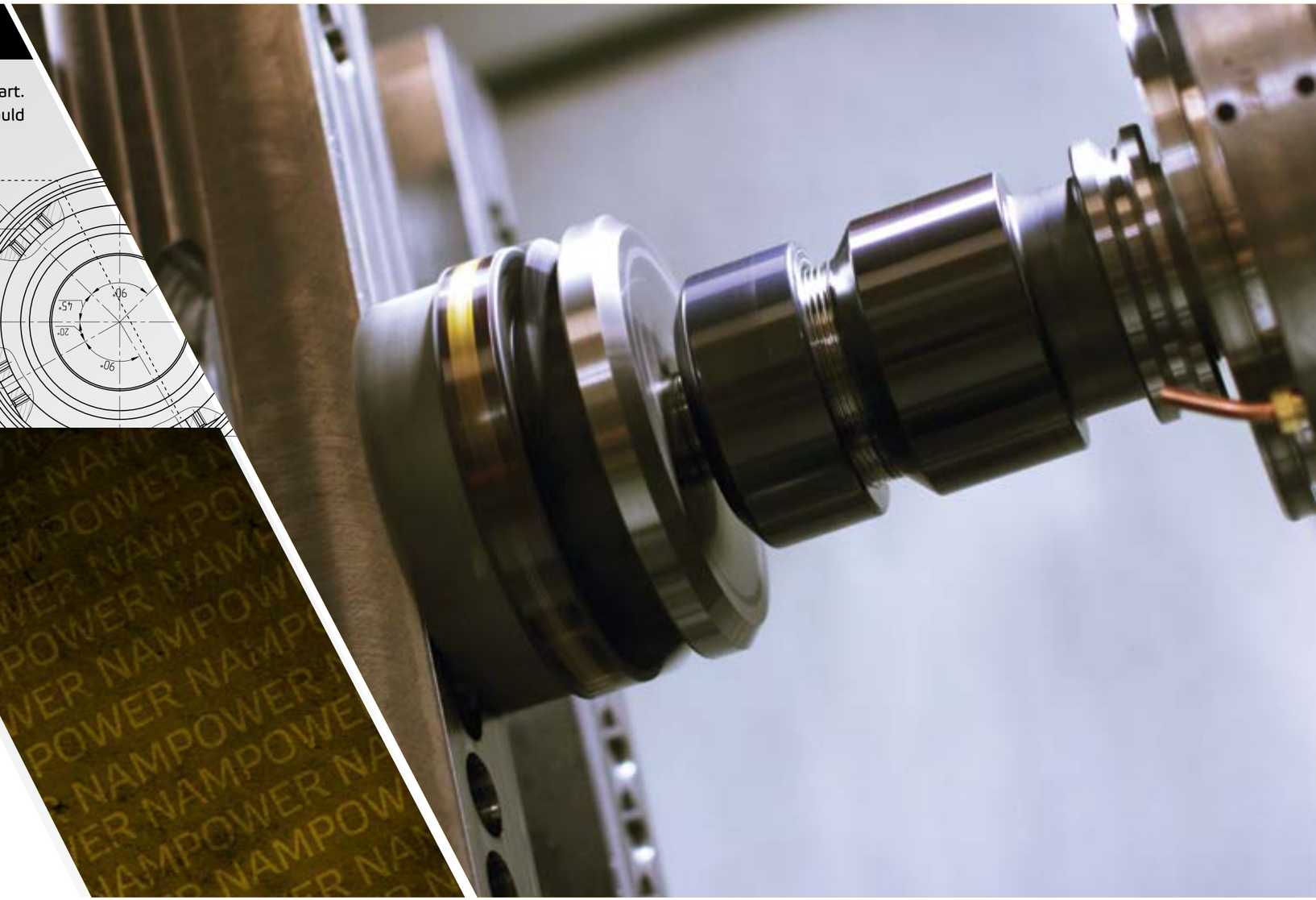
EASILY INTEGRATED
INTO TODAY'S AUTOMATED MACHINERY, CNC MACHINING CENTERS, TRANSFER LINES AND ROBOTIC CELLS

SELECTING BRUSH DIAMETER, PART COVERAGE

The brush diameter should ideally be larger than the cutting tool used to machine the part. If a smaller brush is required due to fixture restrictions, the centerline of the brush tool should be aligned with the targeted edge with a minimum of 1" of overlap.







TOOL PATH ROTATIONAL DIRECTION

Tool Path: The brush should be rotating at full speed and start and finish its path completely off the part.

Rotational Direction: The brush should be rotated in the direction opposite of the cutting tool that created the burr on its initial pass.

SUGGESTED OPERATING PARAMETERS

BRUSH SPEEDS (RPM)

END BRUSHES

Dia. (mm)	Dia. (in)	Trim (in)	80 Grit	120 Grit	180 Grit	320 Grit	Max RPM
12.7	1/2	0.625	6000	5500	5000	4000	10000
19.1	3/4	0.75	5000	4500	4000	3500	10000
25.4	1	0.75	4500	4000	3500	2500	10000
38.1	1-1/2	1.00	3000	2750	2500	2000	7000
50.8	2	1.00	2750	2500	2250	1750	7000

DISC BRUSHES

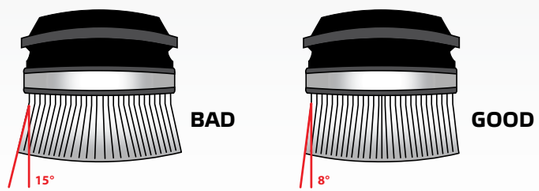
Dia. (mm)	Dia. (in)	Trim (mm)	80 Grit	120 Grit	180 Grit	320 Grit	Max RPM
50	1.97	18	3250	3000	2750	2125	6500
60	2.36	18	3000	2750	2500	1875	5500
80	3.15	18	*2375	2375	2125	1625	4000
100	3.94	18	*1875	*1875	1875	1500	2200
	3.94	38	1625	1500	1250	1000	2200
125	4.92	18	*1500	*1500	*1500	1375	2000
	4.92	38	1375	1250	1125	875	2000
150	5.91	18	*1250	*1250	*1250	1250	1800
	5.91	38	1250	1250	1125	875	1800

*** Speeds capped due to SFM**

The speeds listed in the table above are a guide to start setting up your application without coolant and minimal part engagement. Many factors affect optimum RPM including the brush diameter, trim length, filament diameter, fill pattern, cut depth, tool path, part engagement and if the brush is being run dry or with through spindle coolant. The maximum RPM marked on the brush may not be the optimum working speed. Excessive speed, especially with longer trim length, causes the filament to flair and bounces off the work piece. Filaments used with coolant can spin faster than dry applications without overheating and smearing. You should never exceed the max RPM.

BRUSH FLARE

Brush flare should always be kept to less than 10 degrees to ensure filaments properly wipe across the surface of the part for effective surface finishing and deburring action. Coarse grit filaments, shorter trim lengths, and higher density brushes can spin faster than fine grit filaments, longer trim lengths, and less dense brushes, without flaring.



WEAR COMPENSATION

It is possible to automate wear compensation on dedicated equipment, by using electronic controls to monitor the load on drive motors to adjust the position of the brushing tool to maintain a relatively consistent amount of pressure. Standard CNC machines which do not have the possibility of automated load adjustments need to try other methods like automatic indexing, probe control or manual setting.

BRUSH DEPTH

BRUSH STYLE	DEPTH OF INTERFERENCE
Dot Style Disc Brushes	.015 – .150
Turbine Style Disc Brushes	.004 – .093
AEB End Brushes	.004 – .093

Depth of interference (DOI) should be set up to 10% penetration of the available trim length on the finer filament grits (180, 320) and up to 5% penetration on coarser grit filaments (80, 120). Dot Style brushes can be set for a deeper penetration than Turbine Style and End brushes. Spindle speed is usually decreased with increased depth of interference so the filaments can conform smoothly to part contours.

FEED RATE

MATERIAL	FEED RATE
Non-Ferrous	80 in./min.
Cast Iron	60 in./min.
Mild Steel and Ductile Iron	50 in./min.
Stainless and Alloy Steels	30 in./min.
Titanium and High Nickel Alloys	30 in./min.

Feed rate is affected by many factors including burr size, work piece material, surface contours and finish requirements. Contoured surfaces are processed at slower speeds and greater depth of interference than flat surfaces. Starting feed rates between 30ipm and 80ipm are recommended but the final feed rate is application specific and must be developed through deburring trial.

APPLICATION OPTIMIZATION

For More Aggression
+ Use coarser grit size
+ Use ADT (Turbine Style) or AEB (End Style) Nampower Brush
+ Decrease trim length
+ Increase brush diameter
+ Increase depth of interference
+ Decrease feed rate

For Less Aggression
+ Use finer grit brush
+ Use ADD (Dot Style) Nampower Brush
+ Increase trim length
+ Decrease brush diameter
+ Decrease depth of interference
+ Increase feed rate

For Contouring
+ Use finer grit size
+ Use ADD (Dot Style) Nampower Brush
+ Increase trim length
+ Increase depth of interference
+ Decrease spindle speed (RPM)

For Finer Finishing
+ Use finer grit size
+ Increase trim length
+ Increase brush diameter
+ Decrease depth of interference
+ Increase feed rate

For Coarser Finishing
+ Use coarser grit size
+ Decrease trim length
+ Decrease brush diameter
+ Increase depth of interference
+ Decrease feed rate

For Smear Reduction
+ Decrease brush diameter
+ Decrease depth of interference
+ Decrease spindle speed (RPM)
+ Increase coolant

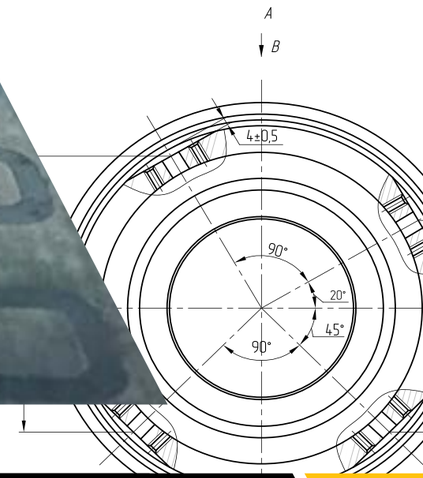
NAMPOWER APPLICATIONS

COMMON MATERIALS	TYPICAL APPLICATIONS
ALUMINUM	FINISHING
CARBON STEEL	DEBURRING
STAINLESS STEEL	SURFACE PREP
BRASS AND BRONZE	BLEND OUT MACHINING MARKS
HIGH NICKEL ALLOYS	HOMOGENIZE PART SURFACE
TITANIUM	RADIUSING
CAST IRON	EDGE BREAKING

FINISHING KNIFE BLADES AND HANDLES

A California knife maker uses Nampower brushes on many components to deburr, clean and polish. To learn more, read the article here: **http://info.brushresearch.com/nampower-zodiac-article**

"I CAN DEBURR AND SURFACE FINISH THE POCKETS IN A KNIFE FRAME WITH A NAMPOWER BRUSH IN 8 TO 12 SECONDS."



SANDING FIBERGLASS

Sea Ray, a prestigious boat manufacturer, uses Nampower tubine style disc brushes in their robotic sanding cell to minimize manual function and increase efficiencies. To read the article, go to: **http://info.brushresearch.com/nampower-disc-brushes-sea-ray**

"OVERALL IT WILL BE MORE EFFICIENT, FASTER, AND WILL RESULT IN SIGNIFICANT REDUCTION IN THE LABOR INVOLVED."

DEBURRING AND FINISHING VISES

A vise manufacturer produces vises in a variety of different sizes with different heat treatments. The hardened surfaces, measuring as high as 50 to 60 HRc, required grinding because milling cutters would wear out too quickly. Learn how Nampower brushes improved the process. To read the article, go to: **http://info.brushresearch.com/orange-vise-nampower-brushes**

GRINDING WOULD BE SO MUCH MORE WORK. WITH THE BRUSHES IT REALLY DOESN'T TAKE ANY EXTRA EFFORT AT ALL. IT ADDS MAYBE 30 SECONDS TO THE PROCESS."

DEBURRING COMPLEX PARTS

A machine shop in Houston, Texas, had issues removing large burrs from machined holes in an extremely hard 4140 steel alloy part used as a muzzle brake for firearms. Nampower Composite Wheels provided the ideal solution. Read the article at: **http://info.brushresearch.com/nampower-wheel-brushes-article**

BEFORE

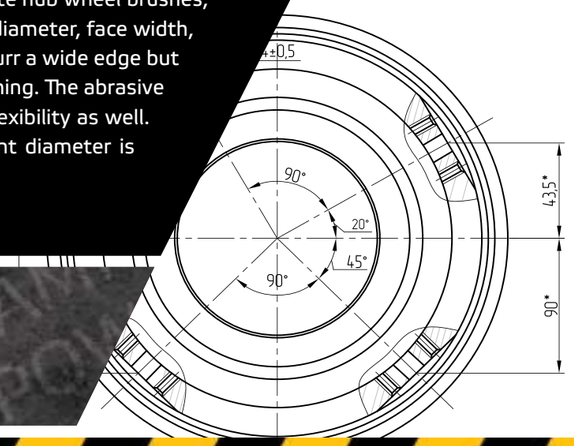
AFTER

GENERAL APPLICATION AND SELECTION OF

NAMPOWER™

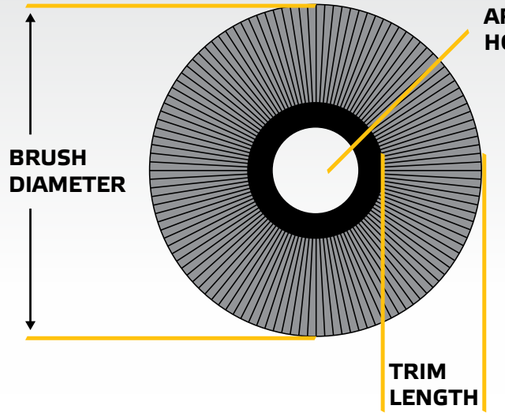
COMPOSITE HUB WHEEL BRUSHES

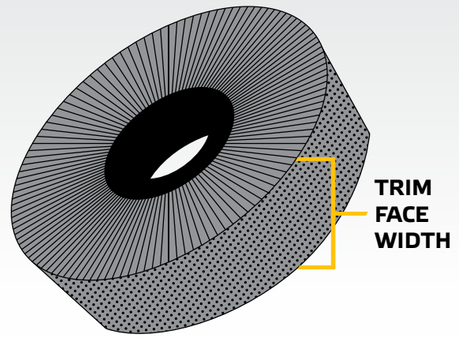
Brush Research's NamPower™ composite hub wheel brushes are abrasive nylon brushing tools for machine-based and offhand deburring, surface finishing, and edge radiusing. These safe, dependable radial wheel brushes feature molded cores that allows higher filament density which results in better brush performance. Their unique, balanced construction puts more cutting tips at the point of attack. As a safer alternative to wire wheels and with a performance advantage over non-woven abrasive brushes, NamPower composite hub wheel brushes are used in the production of turbine blades, steel gears, machine parts, extrusion cut-offs and shaft finishing. Diamond filament wheel brushes are used to produce an edge radius on cutting tool inserts and to polish the flute relief on drills and end mills. When selecting composite hub wheel brushes, as with all industrial brushes, it is important to consider the proper diameter, face width, and trim length. The brush's face width must be wide enough to deburr a wide edge but also narrow enough to access part recesses that may also need finishing. The abrasive grit selected will affect cutting and finish. Grit selection influences flexibility as well. The coarser the abrasive grit (lower number), the larger the filament diameter is which results in a less flexible, more aggressive brush.

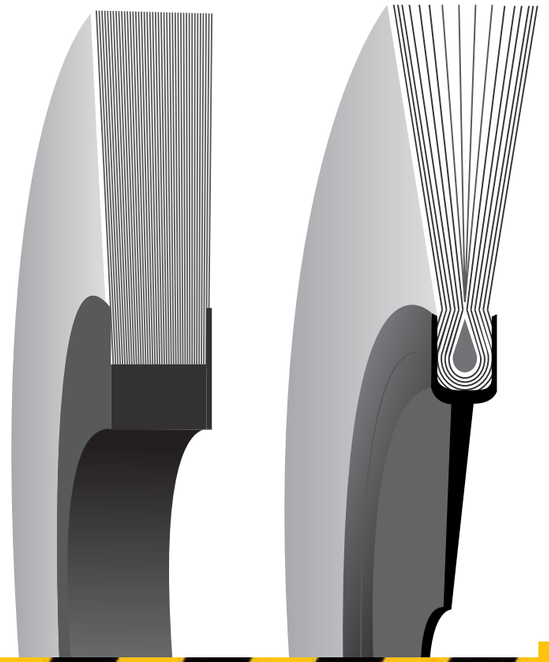


BRUSH DIAMETER SELECTION

Standard Nampower Composite Hub Wheels come in 6 inch and 8 inch diameters. Diamond wheel brushes are available in 4 inch (100mm), 6 inch (150mm) and 8 inch (200mm) diameters. Larger diameter brushes are less aggressive and more flexible while shorter smaller diameter brushes are less flexible and more aggressive. Burr size, part shape and conformity, radius requirements, final finish requirements and the machinery the brush is used on are all factors affecting brush diameter selection.







BRUSH CONSTRUCTION

Composite hub brush construction features abrasive filled filaments set into molded cores that allows higher filament density. This unique, balanced construction puts more cutting tips at the point of attack which results in better brush performance, less filament breakage and more even brush wear. Composite hub wheel brushes are a safer alternative to wire wheels and with a performance advantage over non-woven abrasive brushes.

ABRASIVE NYLON WHEELS

DIAMETER	FACE WIDTH	TRIM LENGTH	ARBOR HOLE	GRIT	PART NUMBER
6" (152mm)	½"	1 - ½"	2"	.040/80 SC	CW61280SC
6" (152mm)	½"	1 - ½"	2"	.022/120 SC	CW612022120SC
6" (152mm)	½"	1 - ½"	2"	.040/120 SC	CW612040120SC
6" (152mm)	½"	1 - ½"	2"	.035/180 SC	CW612180SC
6" (152mm)	½"	1 - ½"	2"	.022/320 SC	CW612320SC
6" (152mm)	½"	1 - ½"	2"	.018/500 SC	CW612500SC
6" (152mm)	1"	1 - ½"	2"	.040/80 SC	CW6180SC
6" (152mm)	1"	1 - ½"	2"	.022/120 SC	CW61022120SC
6" (152mm)	1"	1 - ½"	2"	.040/120 SC	CW61040120SC
6" (152mm)	1"	1 - ½"	2"	.035/180 SC	CW61180SC
6" (152mm)	1"	1 - ½"	2"	.022/320 SC	CW61320SC
6" (152mm)	1"	1 - ½"	2"	.018/500 SC	CW61500SC
8" (203mm)	½"	2 - ½"	2"	.040/80 SC	CW81280SC
8" (203mm)	½"	2 - ½"	2"	.022/120 SC	CW812022120SC
8" (203mm)	½"	2 - ½"	2"	.040/120 SC	CW812040120SC
8" (203mm)	½"	2 - ½"	2"	.035/180 SC	CW812180SC
8" (203mm)	½"	2 - ½"	2"	.022/320 SC	CW812320SC
8" (203mm)	½"	2 - ½"	2"	.018/500 SC	CW812500SC
8" (203mm)	1"	2 - ½"	2"	.040/80 SC	CW8180SC
8" (203mm)	1"	2 - ½"	2"	.022/120 SC	CW81022120SC
8" (203mm)	1"	2 - ½"	2"	.040/120 SC	CW81040120SC
8" (203mm)	1"	2 - ½"	2"	.035/180 SC	CW81180SC
8" (203mm)	1"	2 - ½"	2"	.022/320 SC	CW81320SC
8" (203mm)	1"	2 - ½"	2"	.018/500 SC	CW81500SC

NAMPOWER WHEEL BRUSHES

DIAMOND WHEELS

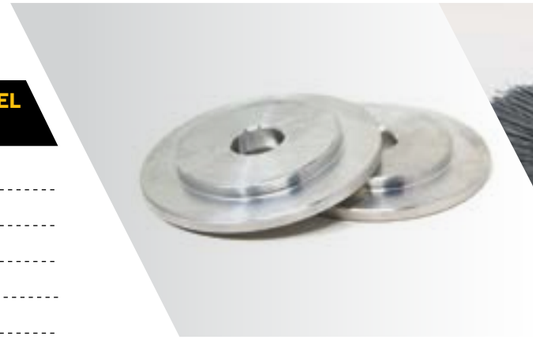
DIAMETER	FACE WIDTH	TRIM LENGTH	ARBOR HOLE	GRIT	PART NUMBER
100mm (3.94")	5mm	12.5mm	20mm	.012/600	DW100X5X600
150mm (5.91")	10mm	19mm	3-¼"	.012/600	DW150X10X600
150mm (5.91")	15mm	19mm	3-¼"	.012/600	DW150X15X600
200mm (7.87")	10mm	30mm	3-¼"	.012/600	DW200X10X600
200mm (7.87")	15mm	30mm	3-¼"	.012/600	DW200X15X600

For machine based or off-hand deburring processes, Nampower™ Composite Hub radial wheels offer a safe, durable alternative to wire wheels or non-woven abrasives. Their construction and flexibility provide a long lasting wheel with less filament breakage and superior performance.

+ Higher filament density for longer brush life
+ Shorter parts cycle time and increased aggression
+ Less filament breakage
+ A virtually indestructible core
+ Wider hub thickness with uniformly distributed filaments
+ Balanced construction that reduces machine fatigue

ARBOR ADAPTERS

ARBOR SIZE	COMPOSITE WHEEL ADAPTER	DIAMOND WHEEL ADAPTER
1/2”	CWA2-12	DWA314-12
5/8”	CWA2-58	DWA314-58
3/4”	CWA2-34	DWA314-34
20mm	CWA2-20MM	DWA314-20MM
7/8”	CWA2-78	DWA314-78
1”	CWA2-1	DWA314-1
1-1/4”	CWA2-114	DWA314-114
1-1/2”	CWA2-112	DWA314-112



Brush Research produces arbor adapters in a variety of sizes. The adapters are reusable and machined from solid aluminum and designed to offer increased brush support, less brush vibration and longer brush life. DWA adapters are designed for diamond wheels and CWA adapters are designed for standard composite hub wheels.

CUT DEPTH

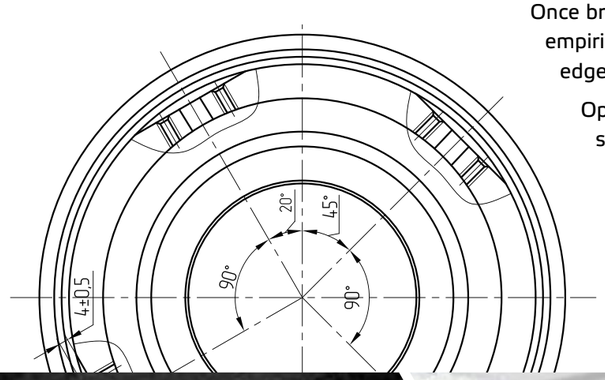
DIAMETER/GRIT	4” WHEEL	6” WHEEL	8” WHEEL
.012/600	0.050	0.070	0.110
.018/500		0.150	0.250
.022/320		0.150	0.250
.022/120		0.150	0.250
.035/180		0.075	0.125
.040/80		0.075	0.125
.040/120		0.075	0.125

*Standard setup is 10% penetration of the available trim length on the smaller diameter filaments and 5% penetration on larger diameter filaments.

SUGGESTED OPERATING PARAMETERS

WHEEL DIAMETER	RPM		
	DRY	WET	NOMINAL
4” / 100mm	3400	2400	2800
6” / 150mm	1500	2250	1750
8” / 200mm	1250	1650	1500

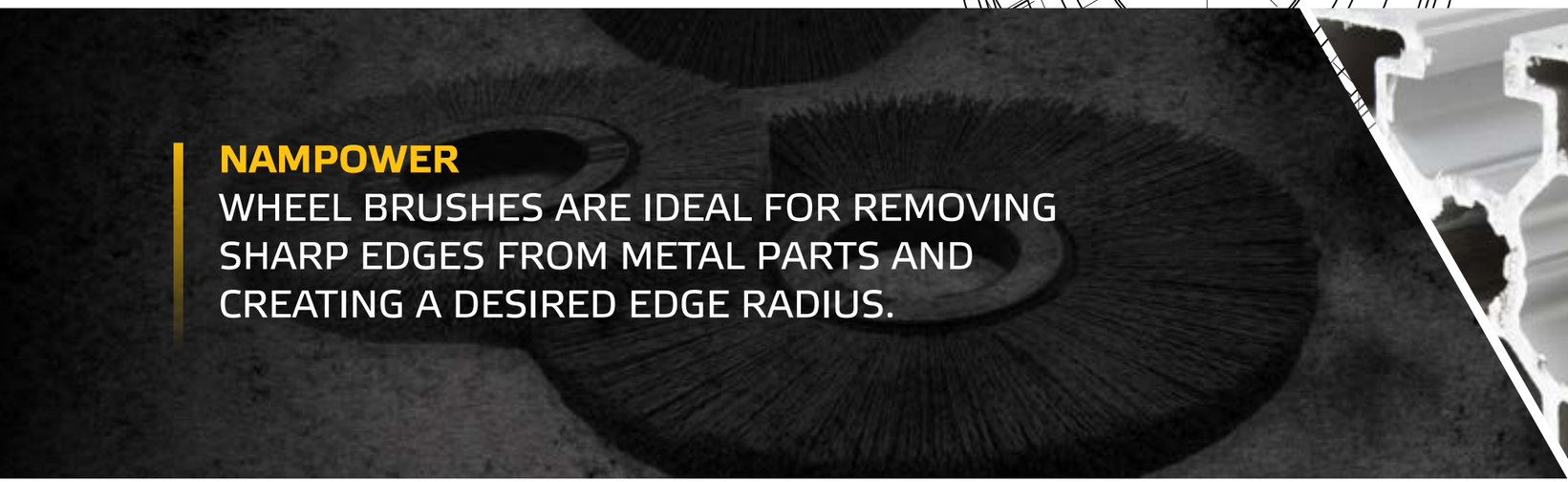
* It is suggested to stay under 2,500 SFPM in dry applications and 3,500 SFPM in wet applications



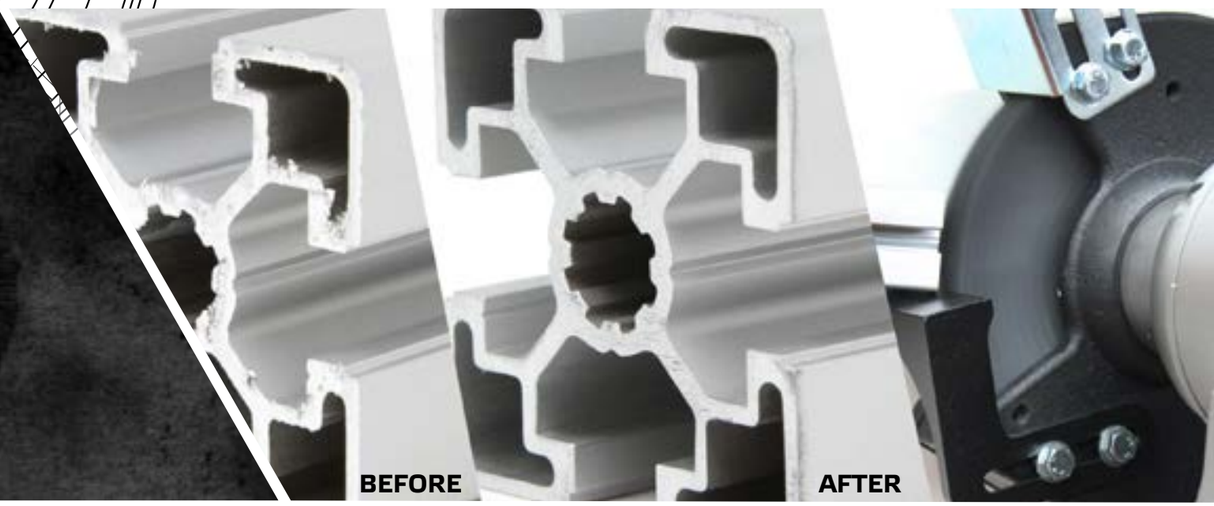
FEED RATE

Once brush diameter, grit selection, RPM and depth of cut are established the feed rate can determined empirically. Set the feed rate at the fastest rate that will produce the desired level of deburring/ edge radiusing.

Optimal brush life and finishing properties are obtained by finding the proper balance between brush speed (RPM), part penetration, and line speed. Lower speeds and lighter pressure give longer brush life, generate less heat, and require less power. Where higher brush speeds and pressures are required, it is recommended to use a more aggressive brush tool. Heat adversely affects the life and performance of the nylon filaments. Applying coolant whenever available is recommended.



NAMPOWER
WHEEL BRUSHES ARE IDEAL FOR REMOVING SHARP EDGES FROM METAL PARTS AND CREATING A DESIRED EDGE RADIUS.



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BRUSH RESEARCH
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Part ID-**RGNP**
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