

The deburring solution demanded by worksites is here.

Proven, reliable results
you can feel at the production site



ATB BRUSH

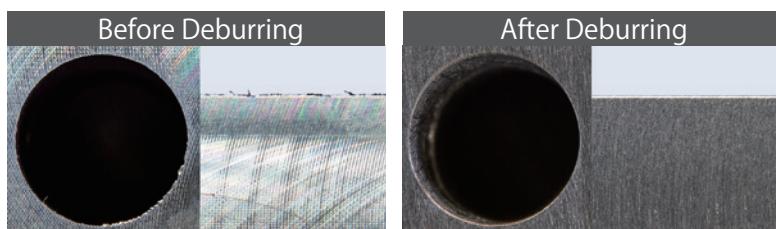
MRA Lite

Cup brush for deburring



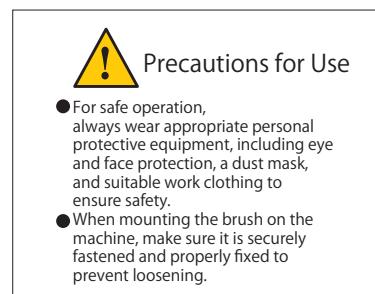
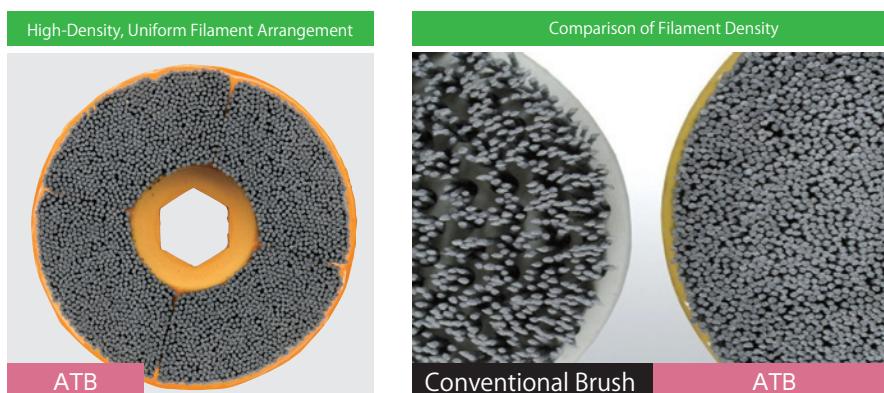
ATB DISK BRUSH SYSTEM Advanced Technology Brushing System

By incorporating proprietary technology, Osborne's ATB Brush enables highly efficient deburring operations on machining centers.

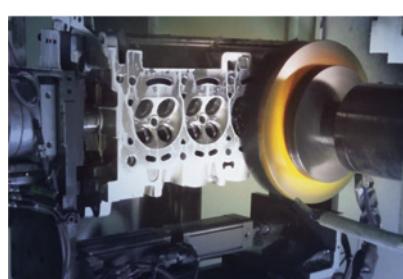
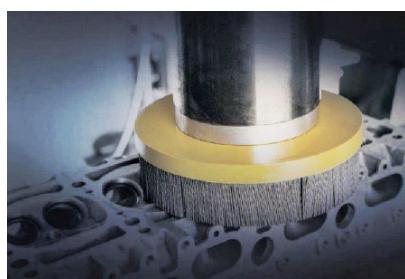


Features

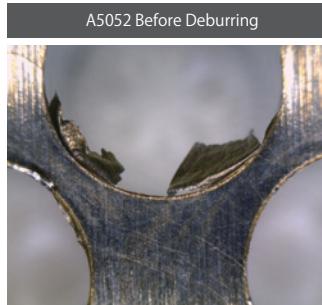
- A proprietary filament anchoring method achieves approximately four times the filament density compared with conventional brushes (such as punch brushes).
- The high-density filament structure suppresses filament flaring during rotation, ensuring stable and consistent deburring on machining centers.
- Uses nylon filaments impregnated with silicon carbide abrasive grains, delivering excellent material removal performance.
- By selecting different grit sizes, the brush can accommodate a wide range of workpiece shapes and materials.



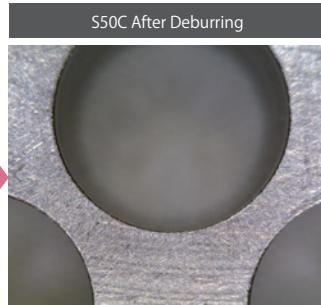
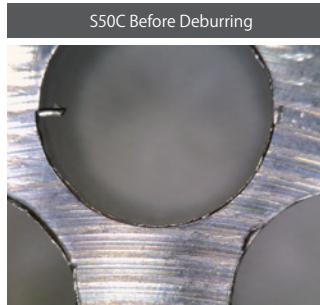
Applications



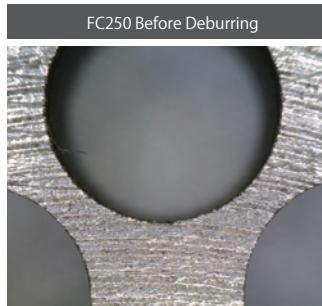
Deburring Conditions



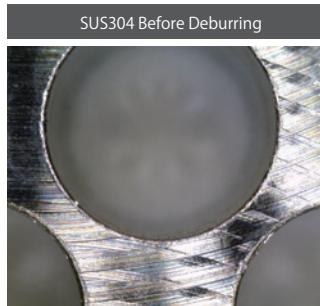
Workpiece material	Grit size	Depth of cut	Rotational speed	Feed rate	Number of passes (reciprocating)
A5052	#120	0.5mm	2,000min ⁻¹	F1000	1



Workpiece material	Grit size	Depth of cut	Rotational speed	Feed rate	Number of passes (reciprocating)
S50C	#80	1.5mm	2,000min ⁻¹	F800	4

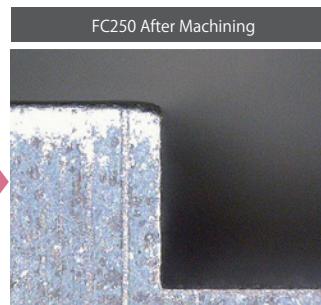
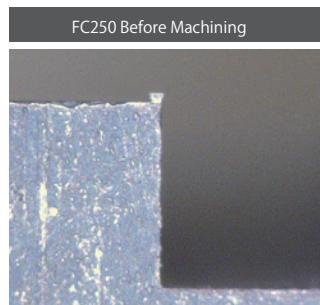
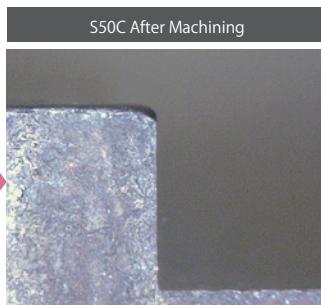


Workpiece material	Grit size	Depth of cut	Rotational speed	Feed rate	Number of passes (reciprocating)
FC250	#120	1mm	2,000min ⁻¹	F1000	2



Workpiece material	Grit size	Depth of cut	Rotational speed	Feed rate	Number of passes (reciprocating)
SUS304	#80	2mm	2,000min ⁻¹	F500	8

Edge Condition and Surface Roughness



Ra : 0.715 μm
Rz : 1.145 μm

Ra : 0.261 μm
Rz : 0.692 μm

Ra : 0.906 μm
Rz : 1.364 μm

Ra : 0.320 μm
Rz : 0.644 μm

Deburring Conditions

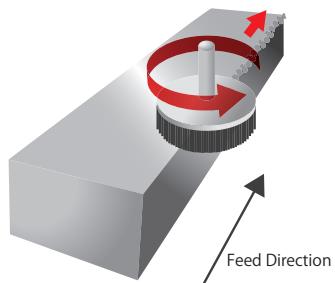
Brush diameter (φmm)	Rotational speed(min ⁻¹)		Depth of cut(mm)			Feed rate(mm/min)		
	Semi-wet machining	Wet machining	Aluminum	Cast iron/Steel	SS/Alloy steel	Aluminum	Cast iron/Steel	SS/Alloy steel
70~100	1500~2000	1800~2200	0.3~0.5	0.5~1.0	0.75~1.5	1500~2000	1000~1500	500~1000
125~150	1200~1600	1500~1800	0.3~0.5	0.5~1.0	0.75~1.5	1500~2000	1000~1500	500~1000
175~200	1000~1300	1100~1500	0.3~0.5	0.5~1.0	0.75~1.5	1500~2000	1000~1500	500~1000

*Semi-wet machining: A grinding process performed with the workpiece in a pre-wetted condition. Coolant is not supplied during machining; instead, the existing moisture is utilized.

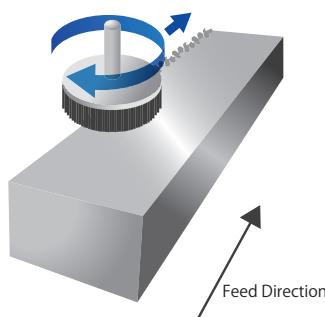
*Wet machining: Coolant is supplied intermittently during machining. While this provides a cooling effect, excessive coolant supply may reduce grinding performance. Proper coolant control is essential.

Recommended: Wet machining

Operating Instructions



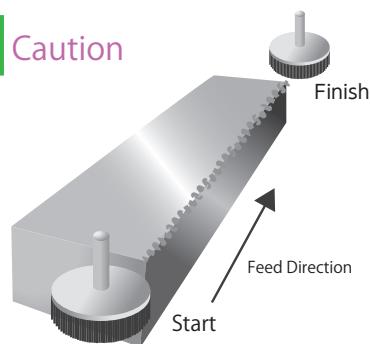
When burrs are on the right side (facing the tool):
Rotate **CCW** (counterclockwise)



When burrs are on the left side (facing the tool):
Rotate **CW** (clockwise)

The brush must always rotate in an up-cut direction (lifting the burr).
Down-cut rotation will cause the burrs to be pressed down and cannot remove them effectively.

Caution



Always start machining from a position completely clear of the workpiece, and finish machining after the brush has fully exited the workpiece.

Never stop the feed while the brush is in contact with the workpiece. Stopping may generate frictional heat, causing the nylon filaments to melt and adhere to the surface.

Line Up

Brush diameter (φmm)	Grit Size (Filament Diameter) and Part Numbers					Trim length (mm)	Mounting accessory code
	#60 (φ1.5)	#80 (φ1.2)	#120 (φ1.0)	#180 (φ0.9)	#320 (φ0.6)		
50	604 912-1501	604 912-4001	604 912-4211	604 912-4311	604 912-1511	25	A
70	604 913-3001	604 913-3101	604 913-3201	604 913-3301	604 913-3401	25	B
100	604 914-3001	604 914-3101	604 914-3221	604 914-3321	604 914-3401	35	C
125	604 916-3501	604 916-3101	604 916-3201	604 916-3311	604 916-3401	40	D
150	604 916-3021	604 916-3111	604 916-3211	604 916-4311	604 916-3411	40	E
175	604 916-3041	604 916-3131	604 916-3231	604 916-3341	604 916-3431	40	F

Mounting accessory/ Arbor

- φ12 Straight Shank•For Arbor

Part Number	Product Name	Code	
215B0003	ATB Brush Shank Set for φ50	A	
215B0001	ATB Brush Shank Set for φ70	B	
215B0002	ATB Brush Shank Set for φ100	C	

- Face Mill•For FMA-25.4 Arbor

Part Number	Product Name	Code	
215B0006	ATB Brush Adapter Set for φ125	D	
215B0007	ATB Brush Adapter Set for φ150	E	
215B0008	ATB Brush Adapter Set for φ175	F	
215B0005	ATB Brush Adapter Set for Turbine-Type	G	

*Face mill arbors are not included with the above products.

- φ12 Straight Shank•Arbor

- Face Mill•Arbor Mounting Example



*Heat-shrink tubes for brush and trim retention are available upon request.

MRA Lite

Made in
Japan



*You're not getting away,
Burr!*



Cup brush for deburring

MURAKI



Abrasive-filled

Cup brush for deburring



Feature

- Made in JAPAN
- Remove burrs with a polishing sensation.
- Ideal for deburring large surfaces.
- Lineup of powerful type with grain size #46.

■ Nylon filaments with embedded abrasive — Silicon carbide

Part number	Size (φmm)	Thread Size (mm)	Grit size	Trim length (φmm)	Max RPM (min ⁻¹)
 MRA-MXC0046150	75	M10×1.5	46	25	13,000
 MRA-MXC0120100	75	M10×1.5	120	25	13,000
 MRA-MXC0500045	75	M10×1.5	500	25	13,000

■ Nylon filaments with embedded abrasive — Ceramic

Compared to silicon carbide abrasive, it delivers higher cutting performance and longer service life.

Part number	Size (φmm)	Thread Size (mm)	Grit size	Trim length (φmm)	Max RPM (min ⁻¹)
 MRA-MXBK0120100	75	M10×1.5	120	25	13,000

※Specifications and price are subject to change without prior notice.

※All prices shown are excluding consumption tax.



Sole Agent:
MURAKI LTD.
Machine Tool Dept.



<https://www.muraki-ltd.co.jp/>