

Deburring Conditions

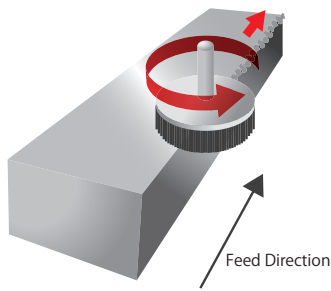
Brush diameter (ϕ mm)	Rotational speed(min ⁻¹)		Depth of cut(mm)			Feed rate(mm/min)		
	Semi-wet machining	Wet machining	Aluminum	Cast iron/ Steel	SS/ Alloy steel	Aluminum	Cast iron/ Steel	SS/ Alloy steel
70~100	1500~2000	1800~2200	0.3~0.5	0.5~1.0	0.75~1.5	1500~2000	1000~1500	500~1000
125~150	1200~1600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

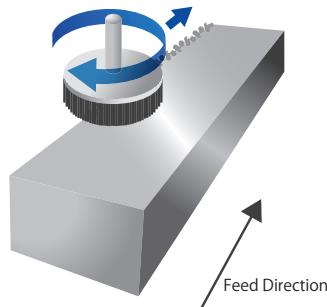
*Wet machining: Coolant is supplied intermittently during machining. While this provides a cooling effect, excessive coolant supply may reduce grinding performance. Proper coolant control is essential.

Recommended: Wet machining

Operating Instructions



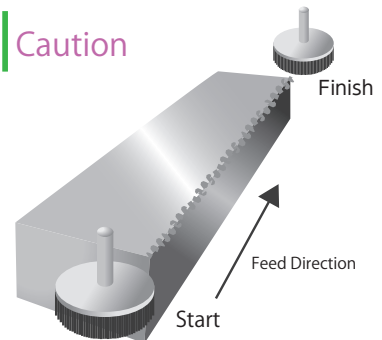
When burrs are on the right side (facing the tool):
Rotate **CCW** (counterclockwise)



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 (ϕ mm)	Grit Size (Filament Diameter) and Part Numbers					Trim length (mm)	Mounting accessory code
	#60 (ϕ 1.5)	#80 (ϕ 1.2)	#120 (ϕ 1.0)	#180 (ϕ 0.9)	#320 (ϕ 0.6)		
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

● ϕ 12 Straight Shank•For Arbor

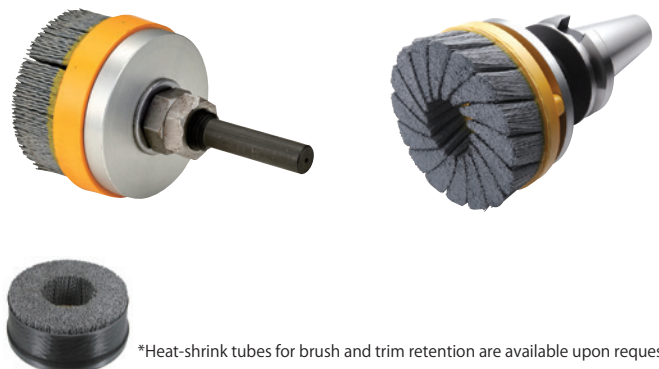
Part Number	Product Name	Code	
215B0003	ATB Brush Shank Set for ϕ 50	A	
215B0001	ATB Brush Shank Set for ϕ 70	B	
215B0002	ATB Brush Shank Set for ϕ 100	C	

● Face Mill•For FMA-25.4 Arbor

Part Number	Product Name	Code	
215B0006	ATB Brush Adapter Set for ϕ 125	D	
215B0007	ATB Brush Adapter Set for ϕ 150	E	
215B0008	ATB Brush Adapter Set for ϕ 175	F	
215B0005	ATB Brush Adapter Set for Turbine-Type	G	

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

● ϕ 12 Straight Shank•Arbor ● Face Mill•Arbor Mounting Example



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