



**BRUSH RESEARCH  
MANUFACTURING**

**INDUSTRIAL BRUSHES  
& FLEX-HONE® TOOLS**



**50  
YEARS** EXCELLENCE



## THE FLEX-HONE® SOLUTION

Brush Research Manufacturing has a long history of solving difficult finishing problems with brushing technology. Established in 1958, our tradition of research, innovation and manufacturing excellence has helped solve problems in the sophisticated environments of nuclear energy, aerospace and computer technology as well as industrial applications.

BRM has long been a leader in the art and science of abrasive surface finishing culminating in the Flex-Hone® Tool. BRM was one of the first companies to advocate the critical need for finer surface finishes to optimize machine performance.

Today BRM remains at the forefront of abrasive finishing technology. Our commitment to the advancement of surface finishing remains as strong as ever and we are constantly experimenting with new materials and applications.

As a full line manufacturer of power brushes, twisted wire brushes and the Flex-Hone® Tool we stand ready to assist you in finding the best solution to your finishing needs.

Our extensive network of both domestic and foreign stocking distributors and our trained staff of customer service specialists assures you of instant access to world wide solutions tailored to your individual needs.

**The Flex-Hone® is used in many different industries including:**

**AUTOMOTIVE**

**AEROSPACE**

**MARINE**

**GENERAL INDUSTRIAL**

**MANUFACTURING**

**OIL AND GAS APPLICATIONS**

**FIREARMS**

**MUSICAL INSTRUMENTS**

**FLUID AND POWER APPLICATIONS**



Brush Research Manufacturing is proud to be an ISO 9001:2008 certified company. Registration to ISO 9001:2008 demonstrates compatibility to an international set of standards for quality and continuous improvement. BRM is committed to meeting or exceeding our customer's expectations, this goes for the quality of our products as well as our service.



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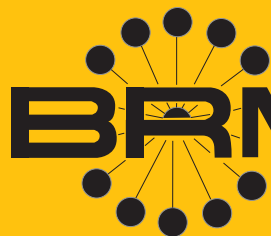
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**BRUSH RESEARCH  
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sales@brushresearch.com

**Note:** Safety information is located in the back of the catalog.

## TERMINOLOGY

- A** Outside Brush Diameter
- B** Trim Length
- C** Arbor Hole
- D** Face Width
- E** Number of Rows
- F** Shank Diameter
- G** Cup Diameter
- H** Brush Part Length
- I** Stem Diameter
- J** Overall Length

## BRUSH INFORMATION & TERMINOLOGY

### HOW TO ORDER CATALOG ITEMS

#### + Flex-Hone® Tools

The Flex-Hone® Tool is trademarked and registered in all major trading countries of the world.

The Flex-Hone® Tool is always used in an oversized condition. Our sizes are listed by the nominal bore in which the hone is intended to be used.

Example:

If you have a 4" bore, order a 4" Flex-Hone®

How to Create a Part Number:  
GBD-4" 120 S/C - GBD=style,  
4"=Diameter, 120=Grit Size,  
S/C=Silicon Carbide Abrasive

These selections will create the part number GBD40012.

#### + Power Brushes

Order by catalog number and specify wire size and arbor hole.

Example:

BTS-6 .014 1/2" AH  
add "S" for stainless steel:  
BTS-6S .014SS 1/2" AH

If an arbor, keyway or threaded nut other than those shown is required, please contact factory for availability.

#### + Twisted-in Wire Brushes

Order by Catalog Number and if required please specify stem type, i.e., cut end, ring handle, pipe nipple, wood handle.

Example:

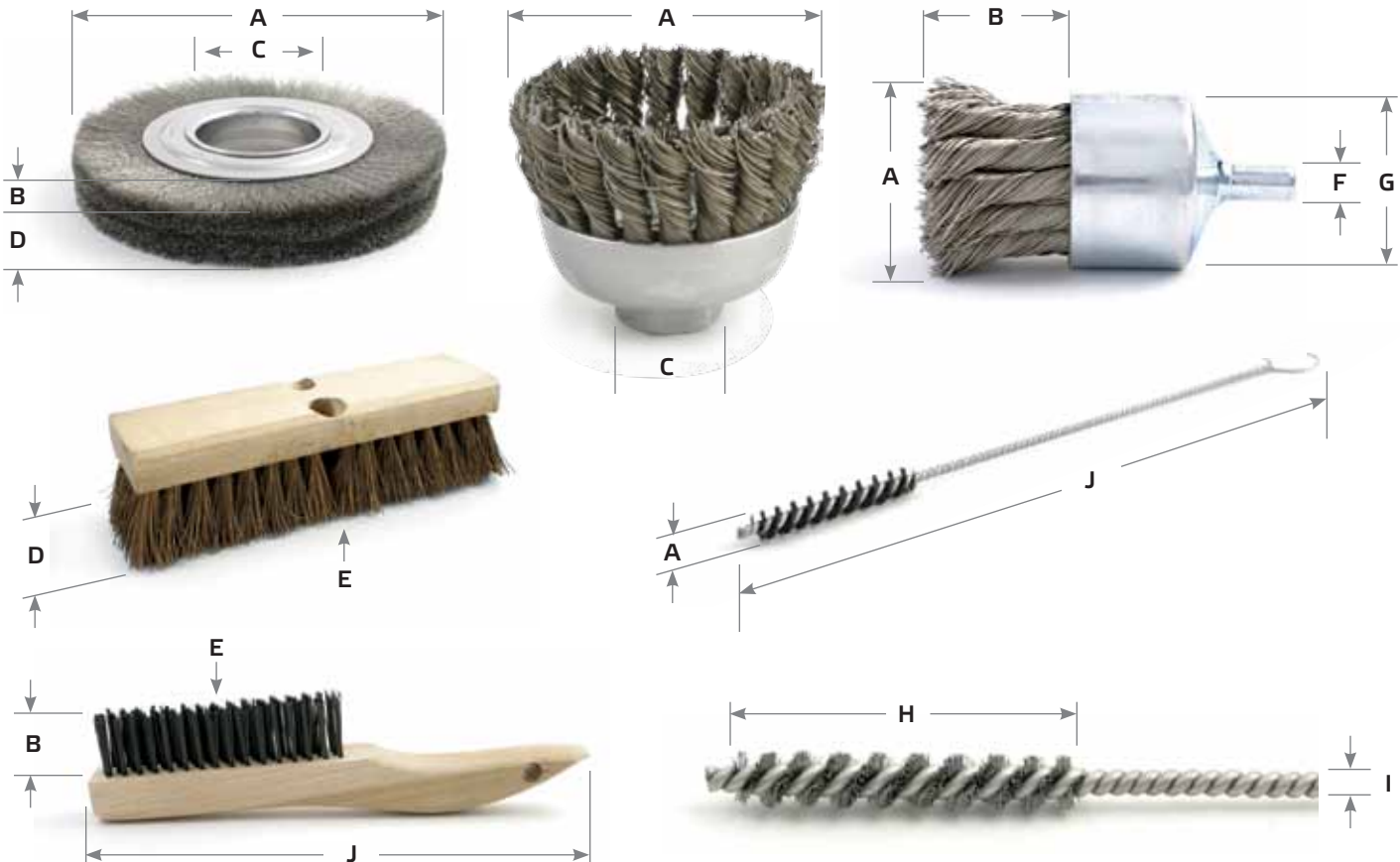
For plastic handle 85-N-500WH  
For ring handle 85-N-500RH

#### + Specials

Any item which is not shown in the Catalog will be considered a Special Order item. To order such an item:

1. Describe item fully
2. Furnish complete, detailed specifications
3. Send sample or blueprint

Please see our Price List for Terms and Conditions of Sale.



Brush Research provides cost-effective solutions for all of your application needs. With our many years of experience as brush manufacturers, we know that sometimes your application calls for brush tools with specific requirements and that is why we offer custom industrial brushes and brush tools. Our brush tools include the original Flex-Hone® Tool, twisted-in-wire brushes, automotive brushes and more! Custom brushes can be made to your exact specifications to ensure the perfect solution for your application.

There are a variety of ways to order your custom product:

#### CONTACT US OR PLACE AN ORDER ONLINE

Visit <http://www.brushresearch.com/custom-brushes.php> and choose one of the brush categories to fill out a custom order form online. You may also call our office at (323) 261-2193 to place an order over the phone. Our team is available to assist you and help you determine the best product for your needs. Our office hours are Monday–Friday, from 8:00 to 4:30 p.m. PST. You may also email us at [info@brushresearch.com](mailto:info@brushresearch.com).

#### FILL OUT A CUSTOM PART FORM

Brush Research has custom forms available for several brush categories including Flex-Hones®, Twisted-in-Wire, Strip Brushes, Radial Coil and Spiral Wound. Please fill out one of the forms located on pages 58-59 (custom Flex-Hone form located on page 9) to provide us with the exact specifications for your product. These forms may also be found online at the link above.

#### SEND IN YOUR PART

Brush Research Manufacturing also offers the option of sending us your components in order for us to evaluate them in our lab and determine the best custom tool for your needs. This allows us to test various elements and address issues such as cycle time and product lifespan without interrupting your production schedule.

#### OUR COMMITMENT TO EXCELLENCE

For over 50 years, BRM has been given the opportunity to help our customers with their polishing, metal surface finishing and deburring needs. At Brush Research, we understand that Quality and Performance are not a given. These are goals that we work towards everyday, with the primary focus being happy customers.

This Commitment to Excellence radiates all through the company, from our customer service to our production, to accounts receivable departments and on throughout our organization and distributors. We have always maintained the importance of keeping our manufacturing in the United States where we can ensure that our processes are followed exactly as they were designed. We also feel pride for supporting our local communities. We continually improve our systems through the implementation of our ISO quality program. Our customer service and tech support are available to our distributors and customers around the world and have their clientele's best interests at heart. BRM is continually reinvesting in ourselves by improving our tools and machinery as well as exploring new products that can be of benefit to our customers. We thank you for the past 50 years and look forward to making the next 50 even better.





## NEED MORE INFORMATION?

**VISIT US ONLINE!**

[www.brushresearch.com](http://www.brushresearch.com)



The Following Booklets Are Available Upon Request at No Charge

### The Use of Industrial Brushes



The most informative literature available on the use of industrial brushes for deburring, edge blending, edge radiusing, oxide or scale removal, weld cleaning, surface finishing, polishing or roughening.

### Brush Research's Gold Booklet



Our first booklet on some common practices in Cylinder Boring, Honing and Wall Finishing. An educational comparison of various rigid honed and Flex-Honed cylinder wall surfaces.

We have a wide array of resources and training videos available to assist you. Follow our blog here: [www.flexhoneblog.com](http://www.flexhoneblog.com)



<http://www.facebook.com/BrushResearch>



<http://www.twitter.com/brushresearch>



<http://www.linkedin.com/company/225267>

**Order your Instructional DVD on the Flex-Hone® Tools!**



DOWNLOAD AND VIEW VIDEOS ONLINE!

[www.brushresearch.com](http://www.brushresearch.com)



Check out our **instructional videos** on **YouTube®** to learn tips and procedures for proper equipment use!

The Following Booklets Are Available Upon Request at No Charge



**BRM and the Flex-Hone® Tool**



**The original Flex-Hone® Tool**



**How to use the Flex-Hone® Tool**



**Flex-Hone® Rotor & Brake Drum Tool**

**The Necessity Of A Plateaued Cylinder Wall Finish**

A detailed presentation of several test run engines with performance results of lower blow-by, increased compression, less ring and cylinder wall wear with the Flex-Hone® Process.



**A Study of Cylinder – Wall Micro-Structure**

An extensive study using a Scanning Electron Microscope to examine and compare the results of cylinder honing using rigid hones versus the Flex-Hone® Tool. Truly an expose of what the honed cylinder wall surface should and should not look like. Three different studies are presented USA, UK and France for comparison.



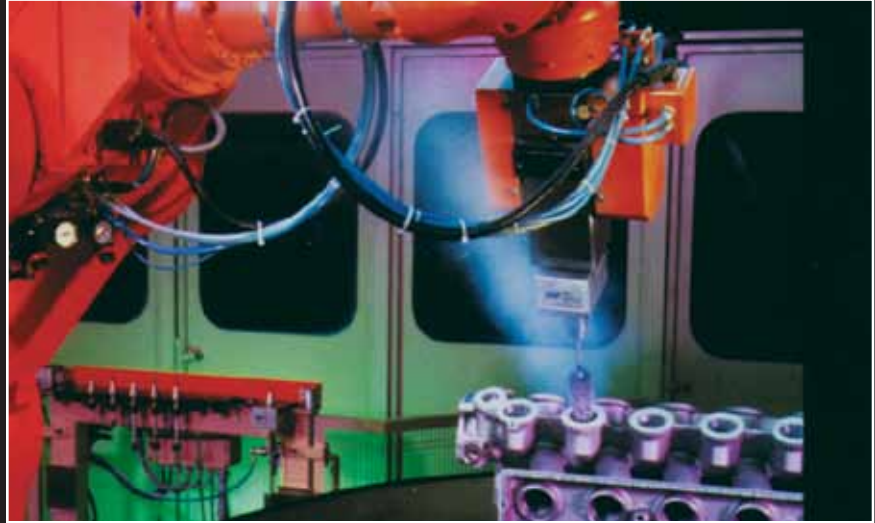


# FLEX-HONE

## FLEX-HONE® TOOL

### For Any Type and Size of Cylinder

The Flex-Hone® Process (Super finishing) produces a controlled surface condition unobtainable by any other method. It involves finish, geometry and metallurgical structure. A high percentage plateaued surface is produced free of cut, torn and folded metal.

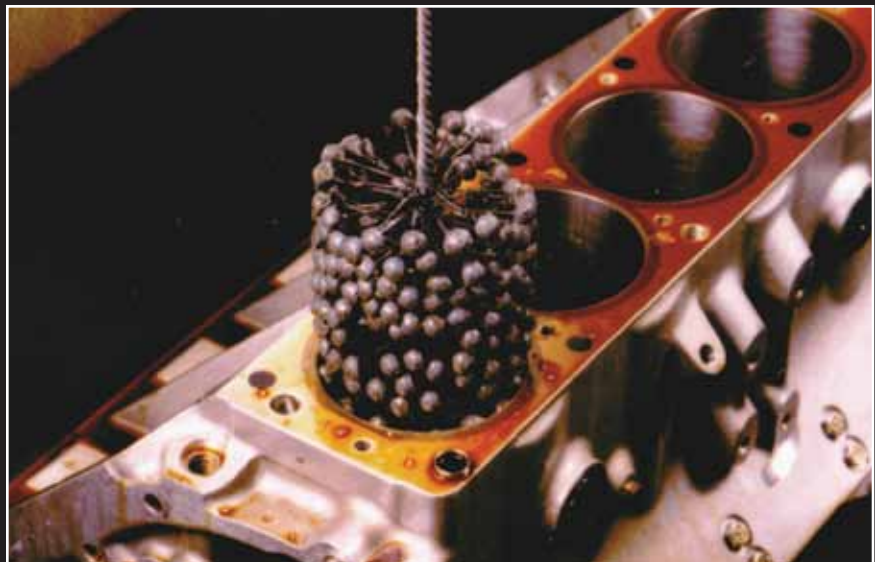


The Flex-Hone® Tool is a resilient, flexible, honing tool with a soft cutting action. The abrasive globules each have independent suspension that assures the Flex-Hone® to be self-centering, self-aligning to the bore, and self-compensating for wear.

Specifically, it is a low-temperature abrading process that exposes the undistributed base metal structure to produce a long wearing surface. It is a method of developing a surface on a metal part which is optically smooth and metallurgically free of any fragmented, amorphous or smeared metal from previous operations. It is accomplished at a low pressure where the "stones" float.

See and read the various booklets of actual tests covering almost every situation that will ensure a superior performance in situations depending on surface finish.

The particular type of Flex-Hone® crosshatch is extremely efficient in providing a multiplicity of oil grooves or valleys for oil retention as opposed to the often unidirectional or uneven valleys common to the conventional type rigid hone. A crosshatch remains as the cylinder wall has been wear-reduced by the Flex-Hone®.

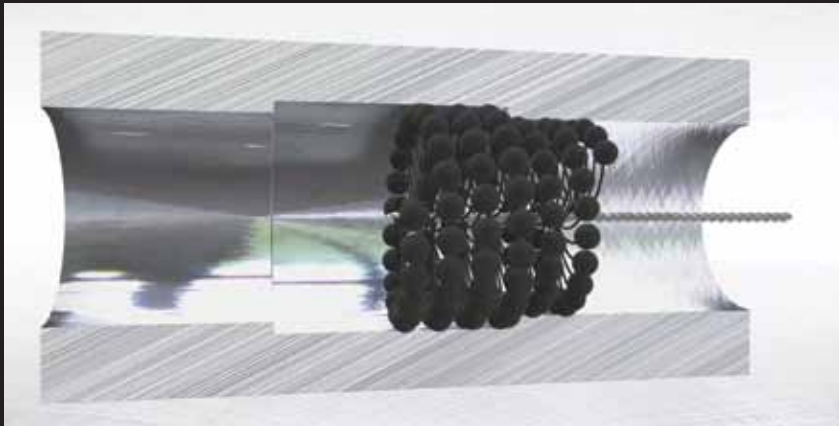




**Flex-Hone® Benefits Include:**

**+ Surface Finishing**

The Flex-Hone® Tool is available in a variety of abrasive types and grit selections to provide the optimum surface finish on any base material. The Flex-Hone® is commonly used to reduce Ra, Rk and Rpk values while maintaining Rvk and Vo volume for oil retention. Using the Flex-Hone® Tool for surface finishing allows the sizing tools to do their jobs quickly and accurately without fighting surface finish. The Flex-Hone® is also used in adhesive bonding applications where a rougher surface is desired for bonding integrity.



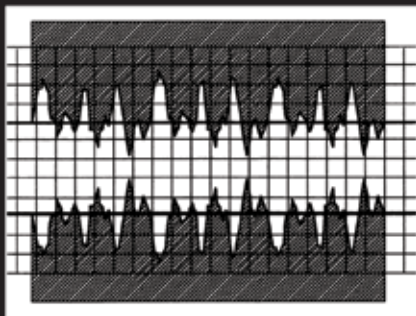
**+ Deburring**

Deburring of cross drilled holes is an expensive, time-consuming operation. The Flex-Hone® Tool can be used to remove burrs from cross drilled holes leaving a clean, radiused intersection. Because of its unique construction, the Flex-Hone® can be used online in machine tool applications or offline as a secondary operation.

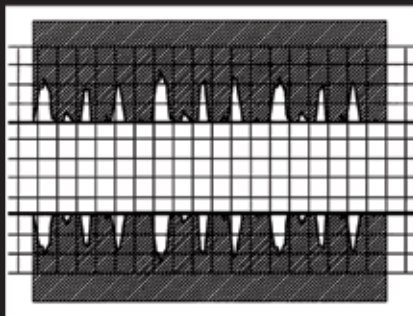
The tool is self-centering and self-aligning to the bore so elaborate, rigid set-ups are not required. It is advisable to use the tool in the main bore into which the cross holes break. Best results are obtained by rotating and stroking the tool a few strokes in a clockwise direction, removing the tool from the part, reversing the spindle and then rotating and stroking the tool in a counter-clockwise direction for a few more strokes. This forward and reverse rotation creates a more symmetrical deburring pattern.

**+ Plateau Finishing**

Brush Research pioneered the concept of a plateau finish and is a strong proponent of the benefits of a cross hatch, plateaued finish. The concept involves removing the peaks produced by prior machining operations and creating a substantially flat or plateau finish. A plateau finish created by the elimination of peaks allows rings and seals to seat without damaging their edges. The cross hatch pattern will aid in lubrication control and retention, reduce seepage in hydraulic and pneumatic applications and promote longer seal life.



**A: Before Flex-Hone®**



**B: After Flex-Hone®**

**If Your Specifications Call For:**

Developing a surface plateau of over 60%,  
Producing an oil holding cross-hatch pattern,  
Reducing Ra, Rpk and Rvk values, Increased bearing area...

**If You Want Benefits of:**

Lowered oil consumption,  
Less blow-by,  
Less friction,  
Improved sealing surface...

**Then Flex-Hone® it!**



## INDUSTRY APPLICATIONS

The Flex-Hone® Tool provides the ideal surface finish in any type or size of cylinder. The benefits of the Flex-Hone® Tool are enjoyed across an extensive range of applications including:

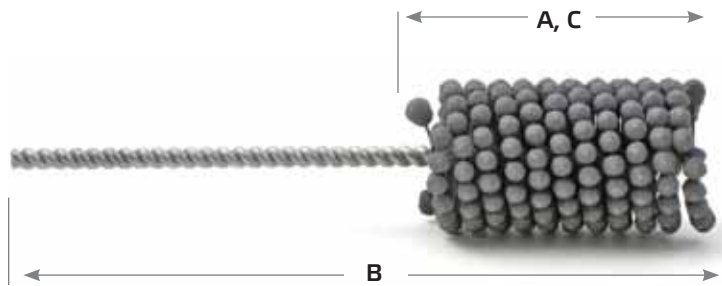
- + AUTOMOTIVE
- + MILITARY
- + AEROSPACE
- + MARINE
- + GENERAL INDUSTRIAL
- + MANUFACTURING
- + OIL AND GAS APPLICATIONS
- + FIREARMS
- + MUSICAL INSTRUMENTS
- + FLUID AND POWER APPLICATIONS
- + HYDRAULICS
- + ALUMINUM EXTRUSIONS
- + EARTH MOVING EQUIPMENT
- + ...AND MORE!





**BE CREATIVE!**

At Brush Research Manufacturing, we understand that some of your deburring and surface finishing applications require non-standard Flex-Hones®. This is why we're happy to provide you with custom Flex-Hone® Tools. With the outstanding reputation our standard Flex-Hones® have received, you can be sure that your custom Flex-Hone® will live up to that reputation as well. We will gladly manufacture Flex-Hone® Tools according to your exact specifications. To get started, fill out the project information below to supply us with the details we need to manufacture your custom Flex-Hone®.



**Please Provide All Dimensions**

Bore Diameter: \_\_\_\_\_

**Abrasive Type:**

- SC (Silicon Carbide)     AO (Aluminum Oxide)     BC (Boron Carbide)
- WC (Tungsten Carbide 50/50)     WC (Tungsten Carbide 100%)
- Z Grain 1525 (Alumina Zirconia)     Z Grain 1549 (Alumina Zirconia)
- LA (Levigated Alumina)     Diamond

**Grit Selection:**

- 20    40    60    80    120    180    240    320    400    600    800

A. Brush Part Length: \_\_\_\_\_ B. Overall Length: \_\_\_\_\_

C. Form:  Cylindrical    Tapered    Stepped    Segmented

Company: \_\_\_\_\_

Attention: \_\_\_\_\_

Mailing Address: \_\_\_\_\_

\_\_\_\_\_

Phone Number: \_\_\_\_\_ Fax Number: \_\_\_\_\_

Email: \_\_\_\_\_

**CUSTOM FLEX-HONE® SPECIFICATIONS**



**Flex-Hones® for Adhesion Applications**

Flex-Hones® can be manufactured in grits as coarse as 20. This is a fast and effective solution to roughen the surface for adhesive bonding.

## FLEX-HONE® APPLICATIONS



The Flex-Hone® Tool is always used in an oversized condition. Our sizes are listed by the nominal bore in which the hone is intended to be used. Order by bore size. For more information, please see the bottom of pg. 13.

## FLEX-HONE® TOOL

### Typical Applications Include:

#### Automotive Applications

- + Piston Pin Bore
- + Engine Cylinders
- + Block Liners
- + Valve Guides
- + Cam Bearing Bore
- + Crank Bores
- + Brake Cylinders
- + Clutch and Brake Master Cylinders
- + Brake Rotors
- + Connecting Rods

#### Marine Applications

- + Main Engines
- + Generator Engines
- + Hydraulic Cylinders
- + Air Intake Lines

#### Firearms Applications

- + Barrels
- + Chambers
- + Forcing Cones
- + Paintball Barrels

#### Industrial Applications

- + Air Compressors
- + Hydraulic Ram Cylinders
- + Hydraulic Motor Bodies
- + Pneumatic Cylinders
- + Valve Housings
- + Pump Housings
- + Surface Finishing of Boiler Components
- + Compressed Air Tool Bodies
- + Finishing of Stainless Steel Tubing
- + Mechanical Decontamination of Nuclear Tube Sheets
- + Roughening Hossel Holes in Golf Clubs for Adhesion

#### Musical Instruments

#### Oil and Gas Applications

#### Fluid and Power Applications

#### Aerospace Applications

NEW

## FLEX-HONE® ABRASIVE OPTIONS

Flex-Hone® now  
available in **DIAMOND!**

Abrasive Types	20	40	60	80	120	180	240	320	400	600	800
SC = Silicon Carbide	x	x	x	x	Standard				x	x	x
AO = Aluminum Oxide	x	x	x	x	x	x	x	x	x	x	x
BC = Boron Carbide	x	x	x	x	x	x	x	x	x	x	x
WC = Tungsten Carbide either 100% or 50/50	x	x	x	x	x	x	x	x			
Z Grain - Alumina Zirconia No. 1525 (25% Zirconia / 75% Alumina)			x	x	x	x	x				
Z Grain - Alumina Zirconia No. 1549 (40% Zirconia / 60% Alumina)					x	x	x	x			
Levigated Alumina	Available in extra fine grit only										
Diamond	Available in mesh 170/200, 800, 2500										

## FLEX-HONE® KITS



### Flex-Hone® Brake Cylinder Kits

#### + For Japanese and European Cars

- |                          |                     |
|--------------------------|---------------------|
| BC Kit A (18, 22, 29 mm) | 320 Aluminum Oxide  |
| BC Kit B (25, 29, 35 mm) | 320 Aluminum Oxide  |
| BC Kit C (41, 51, 60 mm) | 240 Silicon Carbide |

#### + For Compact, Medium and Large Cars

- |                                  |                               |
|----------------------------------|-------------------------------|
| BC Kit D (18, 20, 22, 25, 29 mm) | 180 Silicon Carbide           |
| BC Kit (22, 29, 35 mm)           | 120, 180, 240 Silicon Carbide |

### Flex-Hone® Disc Brake Caliper Kit

#### + For Japanese and European Cars and Light Trucks

- |                                 |                     |
|---------------------------------|---------------------|
| DBC Kit E (38, 45, 54, 64 mm)   | 320 Silicon Carbide |
| DBC Kit (45, 54, 64, 70, 79 mm) | 180 Silicon Carbide |

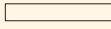
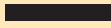





#### + Valve Guide Kits-Transmission Bodies

- |  |                     |
|--|---------------------|
| VGK Kit (6.4, 7, 8, 9, 9.5, 10, 11 mm) | 240 Silicon Carbide |
|--|---------------------|



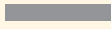

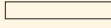


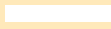




\*Kit has a savings of 10% over individual purchases.



**COLOR GUIDE**

Stem Marking	Type of Abrasive
No Color 	Silicon Carbide (SC)
Black 	Aluminum Oxide (AO)
Gold 	Boron Carbide (BC)
Tan 	Tungsten Carbide (WC)
Red 	Zirconia Alumina (Z-Grain #1525)
White 	Zirconia Alumina (Z-Grain #1549)
Yellow 	Diamond

*\*Order by actual cylinder I.D. All Flex-Hone® are produced oversized.*

End Marking	Grit Sizes	Mesh Sizes (Diamond)
Brown 	20	
Purple 	40	
Grey 	60	
Orange 	80	
Silver (no color) 	120	
Cardinal Red 	180	170/200
Navy Blue 	240	
White 	320	
Yellow 	400	800
Pink 	600	
Light Blue 	800	2500
Green 	Levigated Alumina available in extra fine grit only	

**Instructions For Use**

The Flex-Hone® Tool should be securely held in a collet, chuck, or similar holding device. It is best to use the shortest shank possible for your application. Always wear eye protection. The Flex-Hone® Tool should be well coated with a good quality cutting oil or honing fluid and rotating prior to entry and should continue rotating until fully removed from the part. RPM from 60 to 1200 depending on diameter. Never exceed 1200 RPM. Start with a spindle speed between 350-800 RPM. You may need to experiment to find the optimum speed for your application. The Flex-Hone® Tool should have a continuous stroke rate between 120 to 180 inches per minute. Final stroking may be accelerated to develop a 45° crosshatch finish. Use the minimum honing time needed to achieve the required finish. Average honing time is 10-45 seconds, (5-60 strokes). DO NOT over hone. Clean the cylinder after honing using hot, soapy water and brush the cylinder walls with a cleaning brush. Dry the cylinder and continue to clean with a lint free cloth coated with a light oil or mineral spirits. Continue to clean until the lint free cloth remains clean.

SEE OUR FLEX-HONE® RESOURCE GUIDE FOR MORE RPM RECOMMENDATIONS.

**Ordering a Flex-Hone®**

You can place an order by telephone, fax or direct from our website.

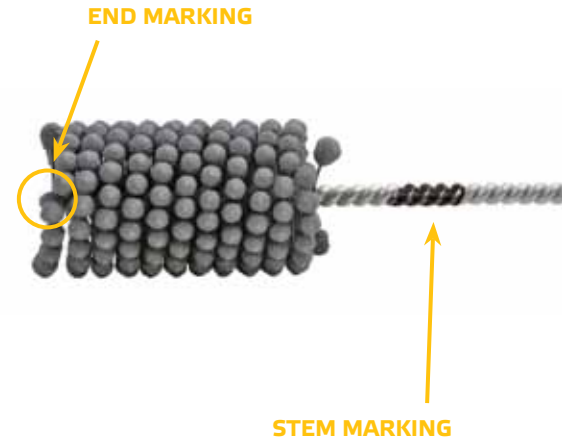
PHONE: (323) 261-2193

FAX: (323) 268-6587

Be sure to check out our video tutorial on the proper use of the Flex-Hone® Tool!

<http://www.brushresearch.com/videos.php>

**FLEX-HONE®  
COLOR GUIDE**



**FLEX-HONE®  
INSTRUCTIONS**

**HOW TO ORDER**

## SMALL DIAMETER STANDARD DUTY FLEX-HONES®

Order by Bore Size



## FLEX-HONE® TOOL

4mm - 3/16" are 6" OAL  
Balance 8" OAL

Catalog Number		Catalog Number		Catalog Number	
BC 4mm	(.157")	BC 1/2"	(12.7mm)	BC 1 3/4"	(45mm)
BC 4.5mm	(.177")	BC 14mm	(.552")	BC 1 7/8"	(48mm)
BC 3/16"	(4.75mm)	BC 5/8"	(16mm)	BC 2"	(51mm)
BC 5mm	(.197")	BC 18mm	(.709")	BC 2 1/8"	(54mm)
BC 5.5mm	(.217")	BC 3/4"	(19mm)	BC 2 1/4"	(57mm)
BC 6mm	(.234")	BC 20mm	(.787")	BC 2 3/8"	(60mm)
BC 6.4mm	(.250")	BC 7/8"	(22mm)	BC 2 1/2"	(64mm)
BC 7mm	(.276")	BC 15/16"	(23.8mm)	BC 2 5/8"	(67mm)
BC 8mm	(.315")	BC 1"	(25.4mm)	BC 2 3/4"	(70mm)
BC 9mm	(.354")	BC 1 1/8"	(29mm)	BC 2 7/8"	(73mm)
BC 9.5mm	(.375")	BC 1 1/4"	(31.8mm)	BC 3"	(76mm)
BC 10mm	(.394")	BC 1 3/8"	(35mm)		
BC 11mm	(.433")	BC 1 1/2"	(38mm)		
BC 12mm	(.472")	BC 1 5/8"	(41mm)		

## SOLUTION SHOWCASE

### CROSS HOLE DEBURRING



Before Deburring



After Deburring

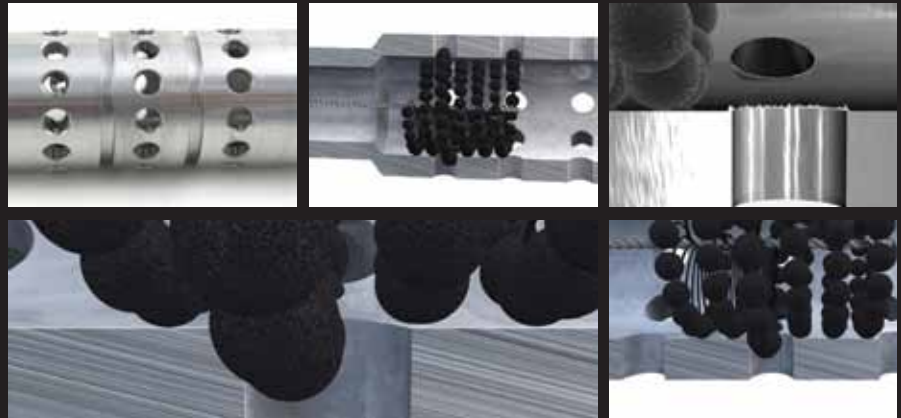


**PROBLEM:** Efficiently deburr dozens of cross drilled holes

**SOLUTION:** Standard Flex-Hones® deburr cross drilled holes simultaneously in a single set by inserting the tool through the main bore

Cross hole deburring has become a common set-back when finishing parts. Time is money and the deburring of each individual cross drilled hole can be very labor intensive. The Flex-Hone® can effectively deburr numerous crossed drilled holes in a single set up through the main bore.

**TIP:** Rotate the tool clockwise for several strokes, reverse the spindle, and then rotate the tool counter-clockwise. This will quickly and efficiently achieve a symmetrical deburring pattern.





**1 3/2" OAL**

Catalog Number		For Bore Sizes
GB 3 1/4"	(83mm)	3 1/4" to 3"
GB 3 1/2"	(89mm)	3 1/2" to 3 1/4"
GB 3 3/4"	(95mm)	3 3/4" to 3 1/2"
GB 4 1/8"	(105mm)	4 1/8" to 3 3/4"
GB 4 5/8"	(118mm)	4 5/8" to 4 1/8"

**3 Thru 4 1/2" Diameter are 1 3/2" OAL Bal. 1 7/2" OAL**

Catalog Number		For Bore Sizes
GBD 3"	(76mm)	3" to 2 3/4"
GBD 3 1/4"	(83mm)	3 1/4" to 3"
GBD 3 1/2"	(89mm)	3 1/2" to 3 1/4"
GBD 3 3/4"	(95mm)	3 3/4" to 3 1/2"
GBD 4"	(101mm)	4" to 3 3/4"
GBD 4 1/4"	(108mm)	4 1/4" to 4"
GBD 4 1/2"	(114mm)	4 1/2" to 4 1/4"
GBD 5"	(127mm)	5" to 4 1/2"
GBD 5 1/2"	(140mm)	5 1/2" to 5"
GBD 6"	(152mm)	6" to 5 1/2"
GBD 6 1/2"	(165mm)	6 1/2" to 6"
GBD 7"	(178mm)	7" to 6 1/2"
GBD 7 1/2"	(190mm)	7 1/2" to 7"
GBD 8"	(203mm)	8" to 7 1/2"

**STANDARD DUTY FLEX-HONES®**

Order by Bore Size



**HEAVY DUTY FLEX-HONES®**

Order by Bore Size



**SOLUTION SHOWCASE**

**FLEX-HONE® COOL TIPS**

- + Tool diameter is determined by bore size. The Flex-Hone® is always produced and used in an oversize condition. For example, a 1" Flex-Hone® is ordered if a 1" bore is to be finished and the tool is provided oversized. If the bore size is between standard Flex-Hone® sizes, the next larger standard Flex-Hone® should be selected.
- + The Flex-Hone® MUST be used with a lubricant.
- + For visual step-by-step instructions on how to properly use a Flex-Hone®, please check out our How-To Video located on our website.
- + For more detailed information on abrasive and grit selections, operating RPMs, potential applications and much more, please download a copy of our Flex-Hone® Resource Guide located in the literature section of our website.
- + Flex-Hone® Accessories-Extensions are an easy way to reach long bore applications.



## HEAVY DUTY FLEX-HONES®

Order by Bore Size



## FLEX-HONE® TOOLS

### 34" OAL STOCKED IN 120 & 180 SC

Catalog Number	3" Core (½" Hex Shaft)	Catalog Number	5" Core (⅝" Hex Shaft)
GBDH 8"	(203mm)	GBD 12½"	(318mm)
GBD 8½"	(216mm)	GBD 13"	(330mm)
GBD 9"	(228mm)	GBD 13½"	(344mm)
GBD 9½"	(241mm)	GBD 14"	(355mm)
GBD 10"	(254mm)	<b>6" Core (⅞" Hex Shaft)</b>	
<b>4" Core (½" Hex Shaft)</b>		GBD 15"	(381mm)
GBD 10½"	(267mm)	GBD 16"	(406mm)
GBD 11"	(280mm)	<b>8" Core (⅞" Hex Shaft)</b>	
GBD 11½"	(292mm)	GBD 17"	(432mm)
GBD 12"	(305mm)	GBD 18"	(457mm)

All Heavy Duty Wood Core Flex-Hones® (GBDH 8"-18") feature a steel hex drive shaft that is 34" OAL.

## SOLUTION SHOWCASE

### LARGE DIAMETER FLEX-HONES®



**PROBLEM:** Servicing large diameter bores in the field

**SOLUTION:** Large diameter Flex-Hones® are an affordable and portable solution

When it comes to servicing big bore diesel engines, the Flex-Hone® is a portable and low-cost tool that can be used to speed up cylinder servicing in the shop or in the field - deglazing, de-burring and cross-hatching in one smooth operation.

Clarence Mayers, coordinator for Diesel Supply Company (Odessa, Texas) says, "Getting top-to-bottom cylinder or liner wall coverage is difficult to do with other tools. The Flex-Hones® that we sell are approximately 12-18 inches wide. So, if the hone is ran two or three inches past the bottom of the liner, that's not a problem. Most of the hone is still inside the cylinder, so it can go down and complete the bottom of the piston travel area. The same applies to the top of the liner, where it gets chamfered because of where the top ring travel ends. The Flex-Hone® can blend that area quite easily."

In addition to diesel engines, large diameter hones are often used for decontamination of large pipes, finishing and cleaning of pumps, valves and generators. Flex-Hones® are available up to 36" standard.





**Available with 3/4" - 1 1/4" Shafts. All 120 SC**

Catalog Number	Drum Dia.	Section	# of Sections on Drum	Shaft Dia.
GBDX 19" (483mm)	11 1/2"	A	22	3/4"
GBDX 20" (508mm)	11 1/2"	B	22	3/4"
GBDX 21" (533mm)	11 1/2"	C	22	3/4"
GBDX 22" (559mm)	11 1/2"	D	22	3/4"
GBDX 23" (584mm)	15 1/2"	A	29	3/4"
GBDX 24" (610mm)	15 1/2"	B	29	3/4"
GBDX 25" (635mm)	15 1/2"	C	29	3/4"
GBDX 26" (660mm)	15 1/2"	D	29	3/4"
GBDX 27" (686mm)	19 1/2"	A	36	1"
GBDX 28" (711mm)	19 1/2"	B	36	1"
GBDX 29" (737mm)	19 1/2"	C	36	1"
GBDX 30" (762mm)	19 1/2"	D	36	1"
GBDX 31" (787mm)	19 1/2"	E	36	1"
GBDX 32" (813mm)	24 1/2"	A	44	1 1/4"
GBDX 33" (838mm)	24 1/2"	B	44	1 1/4"
GBDX 34" (864mm)	24 1/2"	C	44	1 1/4"
GBDX 35" (889mm)	24 1/2"	D	44	1 1/4"
GBDX 36" (914mm)	24 1/2"	E	44	1 1/4"

**GBDX Replacement Sections Available for Above GBDX Flex-Hone®**

Catalog Number		Grit Size	Overall Trim
GBDX-A	Section	120SC	4 1/8" (105mm)
GBDX-B	Section	120SC	4 5/8" (118mm)
GBDX-C	Section	120SC	5 1/4" (133mm)
GBDX-D	Section	120SC	5 3/4" (146mm)
GBDX-E	Section	120SC	6 3/8" (162mm)

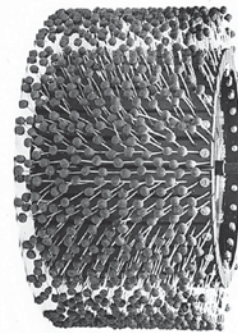
Flex-Hone® for Rotors utilizes the Flex-Hone® technology to produce the ideal surface finish on automotive and motorcycle disc brakes rotors, automotive fly wheels and clutch plates.

- More rotors per hone than abrasive pads
- + Lowers Harmonic vibrations
- + Produces a non-directional pattern
- + Ideal for new and re-turned rotors and flywheels

Part Number	Item	Grit
RMFH60Z25	Flex-Hone® for Rotors	Course
RMFH120Z25	Flex-Hone® for Rotors	Medium
RMFH240Z25	Flex-Hone® for Rotors	Fine

**EXTRA HEAVY DUTY FLEX-HONES®**

Order by Bore Size



**FLEX-HONE® FOR ROTORS**



## FLEX-HONE® TOOLS FOR FIREARMS

### SHOTGUN FLEX-HONE® TOOLS



Gauge	Barrel Hones			Chamber Hones	
	180SC	400SC	800AO	400SC	800AO
10 Ga	00607	08260	00608	08301	00611
12 Ga	00048	05397	00049	06459	00054
16 Ga	00050	08261	00051	08302	00055
20 Ga	00052	08262	00053	08303	00056
.410	00609	08263	00610	08304	00612

All Barrel Flex-Hones® are 34" OAL. The stem wire is covered with a protective shrink tube coating to protect the barrel.

All Chamber Flex-Hones® are 12" OAL. The stem wire is covered with a protective shrink tube coating to protect the barrel.

Gauge	Forcing Cone Hones		
	180SC	400SC	800SC
12 Ga	02985	08004	02986
16 Ga	05611	08264	05612
20 Ga	05613	08265	05614

All Forcing Cone Flex-Hones® have a 1-5/8" abrasive part and are 10" OAL. Coarse, medium and fine grits are offered in each gauge (180SC/400SC/800AO)

#### Shotgun Port Cleaning Brush

1/8" 6" OAL - 06632  
3/16" 7" OAL - 06633

#### Shotgun Handled Chamber Brush

12Ga - 06629  
20Ga - 06630

#### Gas Ring Brush

06631

### REVOLVER/RIFLE/PISTOL FLEX-HONE® TOOLS



	Pistol Chamber Hones	
	400SC	800SC
.32	05470	05471
.357 MAG/.38	00899	00900
.41 MAG	00901	00902
.44 MAG	00903	00904
.45 ACP	00905	00906
.45 COLT	00907	00908
9MM	07584	08309

All Pistol Flex-Hones® have a 1 5/8" abrasive part and are 3" OAL.

**Universal Bolt Brush - 06627**

### SOLUTION SHOWCASE

#### FLEX-HONE® FOR FIREARMS



**PROBLEM:** Efficiently finish ammunition loading dies

**SOLUTION:** Flex-Hones® increase efficiency by an estimated 60-70%



For decades, our firearms tools have been trusted by hobbyist, gunsmiths and manufacturers worldwide. These honing tools have become a standard for finishing and polishing chambers, cylinders and shotgun barrels. The result is reduced jamming, sticking and brass scarring. In recent years, we have discovered the potential for this tool in other areas of the firearms industry.

RCBS, a member of ATK's Security & Sporting Group and a leading producer of high-quality ammunition reloading equipment for over 60 years, came to Brush Research for assistance in finishing their reloading dies. After incorporating the Flex-Hone® into their CNC equipment, Tim Taylor, a RCBS engineer said "the new automated process is a real game changer. It is probably 60-70% more efficient than doing it by hand. Also, there was a substantial increase in quality."





	400SC	800SC
1911 Main Spring Housing 4" OAL	00909	00910
1911 Main Lug Area 8" OAL		BC18M800
S&W, Beretta, SIG Internal Slide		BC12800

## AUTO PISTOL FLEX-HONE® TOOLS



	400SC	800SC
.17 CAL/.22 MAG	06380	08305
.223 Remington	06262	06263
.243	07643	08306
.357 MAG	08310	03309
25-06	07647	08307
30-06	07409	08308
.308	06498	08041
.44 MAG	08312	03310
.44 CAL	06381	08311
.45 COLT	08313	03311
50 BMG	07410	07411
5.56 NATO	09246	09247
6.8MM	09478	09479
7.62x39MM SAAMI	08949	08950
7.62x51MM NATO	09259	09260

## RIFLE CHAMBER FLEX-HONE® TOOLS



Handle Material	Handle Width	Rows	.006 Stainless	.018 Nylon	.006 Brass
No. 93-A Laminated	3/8"	2	93A-S250	93A-N250	93A-B250
Hardwood Plywood	7/16"	3	93A-S375	93A-N375	93A-B375
	1/2"	4	93A-S500	93A-N500	93A-B500

## HAND TOOLS



### Staple Set (Poly Handle- 7 1/4" OAL)

No. 93-AP	.006 Stainless Wire Fill
No. 93-APB	.006 Brass Fill
No. 93-APH	Horsehair Fill
No. 93-APP	.006 Phosphor Bronze Fill
No. 93-APN	.012 Nylon Fill

### Acid Brushes (Throw AwayType)

#1	3/8"	6" OAL
#2	1/2"	6" OAL

### Staple Set (Wire fill in Wood Handle)

No. 93-AW	.006SS Fill
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Finest horse hair fill, tinned metal handle. Nylon available.

### M-16 Cleaning Brush - 93DSN

Flex-Hone® Oil - Pint, Quart, Gallon

## FLEX-HONE® TOOL ACCESSORIES

### FLEX-HONE® OIL



#### TIP NOTE:

The Flex-Hone® Tool **always** requires the use of a lubricant. Solvents should be avoided.

Specifically formulated for use with the Flex-Hone® in honing all types of metals. Contains a blend of honing and lapping oils, a lard oil to prevent galling of aluminum, a moisture dispersant, a non ionic surfactant wetting agent to assure complete lubrication of the surface and a special additive to help keep the metal cuttings and containments in suspension. Emulsified, anti-bacteria agent.

Use sparingly, only a small amount needed on cylinder walls to create a slurry.

Clean the cylinder after honing with cloth or rags and clean motor oil until the cloth stays clean, then thoroughly wash cylinders with hot water and soap. Oil lightly afterwards to prevent rusting.

On hydraulic cylinders use only hydraulic brake fluid or a non-petroleum water-soluble lubricant.

#### Available In:

##### Part Number

FHP	½ Pint Bottle
FHQ	1 Quart Bottle
FHG	1 Gallon Bottle
FH5G	5 Gallon Bottle

### CYLINDER WASHING BRUSH



Made with 6-12 Nylon for efficient cleaning of cylinder walls after honing. Use with detergent and warm/hot water as recommended by Caterpillar, etc. Special diameters to 14".

##### Part Number

##### Diameter

03390	2" Dia.
03391	2½" Dia.
02640	3" Dia.
10A312	3½" Dia.
10A4	4" Dia.
10A412	4½" Dia.
10A5	5" Dia.
10A512	5½" Dia.
10A6	6" Dia.
10A612	6½" Dia.

### PIPE NIPPLE ADAPTORS & EXTENSIONS



Available for Flex-Hones®. Must be designated on order. Although available separately they are intended to be factory attached when ordered.

##### Part Number

##### Diameter

##### Flex-Hone® Sizes

832A	8-32 Adaptors	8mm - 11mm
18NPT	⅛" NPT	12mm - 3"
14NPT	¼" NPT	3" - 5½"
38NT	⅜" NPT	6" - 8"
12NPT	½" NPT	8" - 12"
34NPT	¾" NPT	12½" - 18"

##### Extensions for use with pipe nipple adaptors

18 x 18	⅛" NPT x 18" w/coupling
18 x 36	⅛" NPT x 36" w/coupling
14 x 18	¼" NPT x 18" w/coupling
14 x 36	¼" NPT x 36" w/coupling



## WHAT IS ABRASIVE NYLON?

The cutting action of the filaments of abrasive nylon brushes are unique compared to traditional metal filaments that are designed to cut on the filament tips. Abrasive grains encapsulated in the nylon are exposed on all surfaces of the brush filament. Abrasive action occurs on both the tip of the nylon brush filament as well as the nylon filament sides. In application, the lateral surface of the nylon filament is often drawn across the work surface, functioning much like a flexible abrasive file. Filaments of abrasive nylon brushes are composed of heat stabilized nylon and abrasive grain that are coextruded into monofilament brushes. The results are flexible, homogeneous nylon abrasive brushes that have approximately 30% abrasive loading by weight. Common abrasives used in this material include aluminum oxide, silicon carbide and diamond.

Filaments of nylon abrasive brushes are produced in a variety of filament diameters, abrasive grain types, abrasive grain sizes and abrasive loading. As abrasive grain size increases so does nylon filament diameter. Larger nylon diameter filament is required to effectively bond larger abrasive grains. Larger nylon diameter filaments are less flexible which make them more susceptible to brush filament fatigue and fracture. Smaller diameter filaments bend and recover more easily and more filaments can occupy a given area putting more brush abrasive in contact with the workpiece. Brushes made from abrasive nylon should not be run faster than 3500 SFM to avoid overheating and material transference. Abrasive nylon brushes are ideal for light deburring, surface finishing and finishing of irregular profiles.

### When Should I use Abrasive Nylon Brushes?

- + Smooth internal surface finish
- + Light to medium deburring on internal diameter (ID) and outside diameter (OD) applications
- + Internal thread cleaning
- + External thread cleaning
- + Cleaning and light edge blending
- + Polishing

### What are the Advantages of Abrasive Nylon Brushes?

- + These brushes are non oxidizing...so there is no reaction with metal
- + They are safer - No bristle fly out
- + They are fast working
- + They do not load
- + Unlike Wire Brushes where the tips of the wire do all the work, Abrasive Nylon Brushes use both the tips and the sides of the filament to do the work
- + Abrasive Nylon Brushes have flexible filaments that conform to part geometry
- + You have the ability to change cutting properties by changing grits
- + They can be run wet or dry....however, certain conditions may require the use of a coolant if the brush is put under stress resulting in heat. If the brush is exposed to excess heat, this can result in smearing of the nylon filament.
- + You have the ability to deburr and finish in one step
- + Abrasive Nylon Brushes are ideal for automated processes!



## NAMPOWER™ BRUSHES

**NEW**

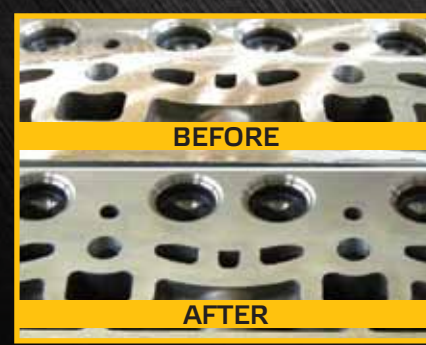
### NAMPOWER™ ABRASIVE DOT STYLE COMBINATION DISC BRUSH



Dot style disc brushes are general purpose tools used for edge deburring and surface finishing applications. Dot style brushes are excellent for light deburring applications when short cycle times are important. Dot style brushes provide greater flexibility and allow entry into small holes and spaces with ease.

Brush Diameter	Trim Length	Grit	MSFS	Part Number
100mm	18mm	80	2,200	ADD1001880
100mm	18mm	120	2,200	ADD10018120
100mm	18mm	180	2,200	ADD10018180
100mm	18mm	320	2,200	ADD10018320
100mm	38mm	80	2,200	ADD1003880
100mm	38mm	120	2,200	ADD10038120
100mm	38mm	180	2,200	ADD10038180
100mm	38mm	320	2,200	ADD10038320
125mm	18mm	80	2,000	ADD1251880
125mm	18mm	120	2,000	ADD12518120
125mm	18mm	180	2,000	ADD12518180
125mm	18mm	320	2,000	ADD12518320
125mm	38mm	80	2,000	ADD1253880
125mm	38mm	120	2,000	ADD12538120
125mm	38mm	180	2,000	ADD12538180
125mm	38mm	320	2,000	ADD12538320
150mm	18mm	80	1,800	ADD1501880
150mm	18mm	120	1,800	ADD15018120
150mm	18mm	180	1,800	ADD15018180
150mm	18mm	320	1,800	ADD15018320
150mm	38mm	80	1,800	ADD1503880
150mm	38mm	120	1,800	ADD15038120
150mm	38mm	180	1,800	ADD15038180
150mm	38mm	320	1,800	ADD15038320

For more detailed information on Nampower™ Tools, download a copy of our Nampower Brochure located in the literature section of our website.



**The highest quality abrasive brush products in the market!**

Turbine style disc brushes are ideal for performing medium to heavy deburring applications. These brushes contain a combination of Silicon Carbide and Ceramic filaments allowing them to cut faster and last longer than any other brush on the market.

Brush Diameter	Trim Length	Grit	MSFS	Part Number
100mm	18mm	80	2,200	ADT1001880
100mm	18mm	120	2,200	ADT10018120
100mm	18mm	180	2,200	ADT10018180
100mm	18mm	320	2,200	ADT10018320
100mm	38mm	80	2,200	ADT1003880
100mm	38mm	120	2,200	ADT10038120
100mm	38mm	180	2,200	ADT10038180
100mm	38mm	320	2,200	ADT10038320
125mm	18mm	80	2,000	ADT1251880
125mm	18mm	120	2,000	ADT12518120
125mm	18mm	180	2,000	ADT12518180
125mm	18mm	320	2,000	ADT12518320
125mm	38mm	80	2,000	ADT1253880
125mm	38mm	120	2,000	ADT12538120
125mm	38mm	180	2,000	ADT12538180
125mm	38mm	320	2,000	ADT12538320
150mm	18mm	80	1,800	ADT1501880
150mm	18mm	120	1,800	ADT15018120
150mm	18mm	180	1,800	ADT15018180
150mm	18mm	320	1,800	ADT15018320
150mm	38mm	80	1,800	ADT1503880
150mm	38mm	120	1,800	ADT15038120
150mm	38mm	180	1,800	ADT15038180
150mm	38mm	320	1,800	ADT15038320

**NAMPOWER™  
TURBINE STYLE  
ABRASIVE  
DISC BRUSH**

**NEW**



These specialty disc brush holders are compatible with any of the Dot and Turbine style disc brushes. Featuring an innovative "Flow Through Coolant Holder," the design allows coolant to pass through the center and sides of the brush and holder. Flow Through technology reduces heat generation, decreases oxide formation on the bristles and increases tool life. These high quality holders feature one piece construction for improved balance, are heat treated and precision ground and have a PVD coating for durability.

Part Number	Shank Diameter	Holder Type
ADHSMP	25mm	Standard Collet
ADHSMSL	25mm	Standard Side Lock

**HOLDERS FOR  
NAMPOWER™  
DISC BRUSHES**

**NEW**





## NAMPOWER™ ABRASIVE HEX-DRIVE™ TOOLS



### APPLICATIONS:

- + Deburring
- + Rust Removal
- + Gasket Cleaning & Removal
- + Roughing
- + Finishing prior to painting and plating
- + Removal of silicon glue, paper gaskets and flash from rubber and plastic
- + Pre-cast concrete mold cleaning
- + Spot finishing
- + Improve surface finish
- + Weld cleaning
- + Clean fiberglass
- + Plastic automotive parts

## NAMPOWER™ BRUSHES

These tools are designed for use in semi-automatic and fully automatic machinery, including NC, CNC and robotic machine tools. The unique Hex-Drive™ system allows the tools to be turned in both directions for 360 finishing. Typical applications include deburring, edge radiusing and general surface finishing.

Part Number	Dia.	Fil. Dia./Grit	Arbor	Trim Length	Max Safe RPM
AHX2046	2"	.060/46SC	¼"	¾"	10,000
AHX2060		.045/60SC		1"	
AHX2080		.040/80SC		1"	
AHX2120		.028/120SC		1"	
AHX2180		.035/180SC		1"	
AHX3046	3"	.060/46SC	¼"	¾"	10,000
AHX3060		.045/60SC	or	1"	
AHX3080		.040/80SC	⅜"	1"	
AHX3120		.028/120SC		1"	
AHX3180		.035/180SC		1"	
AHX4060	4"	.045/60SC	¼"	1"	10,000
AHX4080		.040/80SC	or	1"	
AHX4120		.028/120SC	⅜"	1"	
AHX4180		.035/180SC		1"	
AHX5060	5"	.045/60SC	⅜"	1"	6,000
AHX5080		.040/80SC		1"	
AHX5120		.028/120SC		1"	
AHX5180		.035/180SC		1"	

## DRIVE ARBORS FOR NAMPOWER™ HEX-DRIVE TOOLS



Part Number	Shank Arbor	Shank Dia.	Max Brush Dia.	Max Safe RPM
AHXD250	½"	¼"	4"	10,000
AHXD375	½"	⅜"	5"	10,000

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 because they are not pre-stressed
- + A virtually indestructible core
- + Wider hub thickness with uniformly distributed filaments
- + Balanced construction that reduces machine fatigue

Diameter	Part Number	Face Width	Trim Length	Arbor Hole	Grit
6"	CW61280SC	1/2"	1 - 1/2"	2"	40/80 SC
6"	CW612022120SC	1/2"	1 - 1/2"	2"	22/120 SC
6"	CW612040120SC	1/2"	1 - 1/2"	2"	40/120 SC
6"	CW612180SC	1/2"	1 - 1/2"	2"	35/180 SC
6"	CW612320SC	1/2"	1 - 1/2"	2"	22/320 SC
6"	CW612500SC	1/2"	1 - 1/2"	2"	18/500 SC
6"	CW6180SC	1"	1 - 1/2"	2"	40/80 SC
6"	CW61022120SC	1"	1 - 1/2"	2"	22/120 SC
6"	CW61040120SC	1"	1 - 1/2"	2"	40/120 SC
6"	CW61180SC	1"	1 - 1/2"	2"	35/180 SC
6"	CW61320SC	1"	1 - 1/2"	2"	22/320 SC
6"	CW61500SC	1"	1 - 1/2"	2"	18/500 SC
8"	CW81280SC	1/2"	2 - 1/2"	2"	40/80 SC
8"	CW812022120SC	1/2"	2 - 1/2"	2"	22/120 SC
8"	CW812040120SC	1/2"	2 - 1/2"	2"	40/120 SC
8"	CW812180SC	1/2"	2 - 1/2"	2"	35/180 SC
8"	CW812320SC	1/2"	2 - 1/2"	2"	22/320 SC
8"	CW812500SC	1/2"	2 - 1/2"	2"	18/500 SC
8"	CW8180SC	1"	2 - 1/2"	2"	40/80 SC
8"	CW81022120SC	1"	2 - 1/2"	2"	22/120 SC
8"	CW81040120SC	1"	2 - 1/2"	2"	40/120 SC
8"	CW81180SC	1"	2 - 1/2"	2"	35/180 SC
8"	CW81320SC	1"	2 - 1/2"	2"	22/320 SC
8"	CW81500SC	1"	2 - 1/2"	2"	18/500 SC

Note: MSFS is 3,600

**NAMPOWER™  
COMPOSITE HUB  
ABRASIVE  
NYLON WHEELS**

**NEW**



## ABRASIVE NYLON BRUSHES

### SOLID END BRUSHES



Catalog Number	Brush Diameter	Trim Length	Shank Dia.	Stocked Abrasive	Max. Safe Free Speed (RPM)
BNS-4AY	½"	7/8"	¼"	180AO	20,000
BNS-6AY	¾"	7/8"	¼"	180AO	20,000
BNS-10AY	1"	7/8"	¼"	180AO	20,000

### COPPER CENTER WHEEL BRUSHES



Catalog Number	Brush Diameter	Trim Length	Arbor Hole	Stocked Abrasive	Max. Safe Free Speed (RPM)
CY-1"	1"	⅛"	⅜"	600AO	20,000
CY-1¼"	1¼"	¼"	⅜"	600AO	20,000
CY-1½"	1½"	⅜"	⅜"	600AO	20,000
CY-2"	2"	½"	½"	500AO	20,000
CY-2½"	2½"	¾"	½"	500AO	20,000
CY-3"	3"	1"	½"	500AO	20,000
CY-3½"	3½"	1 ⅜"	⅝"	320AO	20,000
CY-4"	4"	1 7/16"	⅝"	320AO	20,000

### MANDREL MOUNTED COPPER CENTER WHEEL BRUSHES



Catalog Number	Brush Diameter	Trim Length	Shank Dia.	Stocked Abrasive	Max. Safe Free Speed (RPM)
BMC-12AY	1¼"	⅛"	¼"	500AO	25,000
BMC-13AY	1 ⅜"	⅜"	¼"	500AO	25,000
BMC-14AY	1½"	¼"	¼"	500AO	25,000
BMC-16AY	1 ¾"	⅜"	¼"	500AO	25,000
BMC-20AY	2"	½"	¼"	500AO	25,000
BMC-25AY	2½"	1 1/16"	¼"	500AO	25,000
BMC-30AY	3"	1 3/16"	¼"	500AO	25,000
BMF-14AY	1½"	¼"	¼"	500AO	25,000
BMF-16AY	1 ¾"	⅜"	¼"	500AO	25,000
BMF-20AY	2"	½"	¼"	500AO	25,000
BMF-25AY	2½"	1 1/16"	¼"	500AO	25,000
BMF-30AY	3"	1 3/16"	¼"	500AO	25,000

### FILAMENTS ON SPECIAL ORDER

Available for ALL  
Abrasive Nylon tools

	.012/600	.018/500	.022/320	.040/120	.040/80
Aluminum Oxide	X	X	X	X	X
Silicon Carbide		X	X	X	X
Silicate	Mild Abrasive; .008 LV Filament				



Catalog Number	Brush Diameter	Trim Length	Arbor Hole	Abrasive Options	Max. Safe Free Speed (RPM)
NY-6	6"	1 ½"	2"	80-500AO&SC	6,000
NY-8	8"	1 7/8"	3 ¼"	80-500AO&SC	5,000

Note: Use ALA type adaptors for NY-6". Use MA3 adaptor for NY-8". For more information, see pg. 55.

Catalog Number	Cup Diameter	Trim Length	Shank Dia.	Stocked Abrasive	Max. Safe Free Speed (RPM)
BNH-16AY	1 ¾"	½"	¼"	320AO	10,000
BNH-26AY	2 ¾"	¾"	¼"	320AO	8,000

**Operator Safety:**

1. Always wear eye protection.
2. Observe maximum safe speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.

## WHEEL BRUSHES



## CUP BRUSHES



## SOLUTION SHOWCASE

### NYLON BRUSH TIPS

Is your brush not aggressive enough? Try one of these options:

- + Increase surface speed by increasing spindle RPM
- + Use a coarser grit abrasive
- + Increase brush diameter
- + Increase fill density
- + Decrease trim/filament length
- + Increase pressure

Is your brush too aggressive? Try one of these options:

- + Decrease surface speed by decreasing spindle RPM
- + Use a finer grit abrasive
- + Increase trim/filament length
- + Decrease filament diameter
- + Reduce pressure

## SERIES 81-AY MINIATURE ABRASIVE NYLON DEBURRING BRUSHES

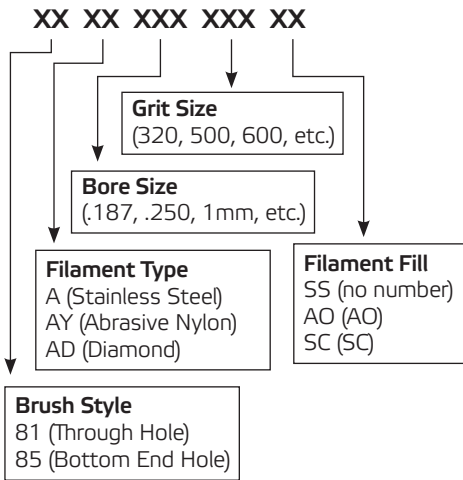
For through hole applications

### Miniature Cross Hole Deburring System

- + Stainless Steel Stem Wire
- + Abrasive Nylon
- + Single Stem-Single Spiral



### How to Order BRM Miniature Brushes:



Examples: 81AY250500AO  
81AY25M600AO

## ABRASIVE NYLON TWISTED-IN-WIRE

Catalog Number	Hole Dia.	Brush Dia.	Brush Part	Overall Length	Stem Diameter	Stocked Abrasive
*81-AY .032"	.032	.035	5/8"	3"	.016	Silicate
*81-AY .047"	.047	.052	3/4"	3"	.026	Silicate
*81-AY .054"	.054	.059	3/4"	3"	.026	Silicate
*81-AY .063"	.063	.069	3/4"	3"	.034	600 AO
*81-AY .079"	.079	.087	3/4"	3"	.034	600 AO
*81-AY .094"	.094	.103	3/4"	3"	.043	600 AO
*81-AY .109"	.109	.120	3/4"	3"	.055	600 AO
*81-AY .125"	.125	.138	1"	3"	.055	600 AO
*81-AY .142"	.142	.156	1"	3"	.072	600 AO
*81-AY .156"	.156	.172	1"	3"	.072	600 AO
*81-AY .172"	.172	.189	1"	3"	.083	600 AO
*81-AY .189"	.189	.208	1"	3"	.083	600 AO
*81-AY 7/32"	.219	.241	1 1/2"	3"	.097	600 AO
*81-AY 1/4"	.250	.275	1 1/2"	3"	.110	500 AO
81-AY 5/16"	.313	.344	1 1/2"	3"	.125	500 AO
81-AY 3/8"	.375	.413	1 1/2"	3"	.140	500 AO
81-AY 7/16"	.438	.481	1 1/2"	3"	.140	500 AO
81-AY 1/2"	.500	.550	1 1/2"	3"	.168	500 AO

### Metric Series

*81-AY 1mm	.039	.043	5/8"	3"	.016	Silicate
*81-AY 1.5mm	.059	.065	5/8"	3"	.026	Silicate
*81-AY 2mm	.079	.087	3/4"	3"	.034	600 AO
*81-AY 2.5mm	.098	.108	3/4"	3"	.043	600 AO
*81-AY 3mm	.118	.130	1"	3"	.055	600 AO
*81-AY 3.5mm	.138	.152	1"	3"	.055	600 AO
*81-AY 4mm	.157	.173	1"	3"	.072	600 AO
*81-AY 4.5mm	.177	.195	1"	3"	.072	600 AO
*81-AY 5mm	.197	.217	1"	3"	.072	600 AO
*81-AY 5.5mm	.217	.238	1"	3"	.110	600 AO
*81-AY 6mm	.236	.260	1"	3"	.110	600 AO
*81-AY 6.5mm	.256	.281	1"	3"	.110	600 AO

Refer to Safety Instructions on pg. 61

NEW

## SERIES 81-AD IN DIAMOND

### NEW! Diamond Filament Brushes Available

\*Stocked in 800 mesh diamond. Available in other sizes upon request. Please see Series 81 AY chart for available sizes for Diamond Abrasive Nylon brushes.

## FILAMENTS ON SPECIAL ORDER

Available for ALL Abrasive Nylon tools

	.012/600	.018/500	.022/320	.040/120	.040/80
Aluminum Oxide	X	X	X	X	X
Silicon Carbide		X	X	X	X
Silicate	Mild Abrasive; .008 LV Filament				
Diamond	Stocked in 800 grit (.010/800); other grits avail. upon request				

**Regular Deburring Tools**

Catalog Number	Hole Dia.	Brush Dia.	Brush Part	Overall Length	Stem Dia. Inches	Stocked Abrasive
*85-AY125	.125	.138	1"	4"	.073	600 A0
*85-AY156	.156	.172	1"	4"	.097	600 A0
*85-AY187	.187	.206	1"	4"	.097	600 A0
*85-AY219	.219	.241	1"	4"	.112	600 A0
*85-AY250	.250	.275	1¼"	4½"	.112	500 A0
*85-AY281	.281	.309	1¼"	4½"	.125	500 A0
*85-AY312	.312	.343	1¼"	4½"	.140	500 A0
*85-AY344	.344	.378	1¼"	4½"	.140	500 A0
*85-AY375	.375	.413	1¼"	4½"	.140	500 A0
85-AY406	.406	.447	1¼"	4½"	.168	500 A0
85-AY437	.437	.481	1¼"	4½"	.168	500 A0
85-AY469	.469	.516	1¼"	4½"	.168	500 A0
85-AY500	.500	.550	1½"	5"	.168	500 A0
85-AY562	.562	.618	1½"	5"	.190	500 A0
85-AY625	.625	.688	1½"	5"	.190	500 A0
85-AY687	.687	.756	1½"	5"	.220	500 A0
85-AY750	.750	.825	1½"	5"	.220	500 A0
85-AY812	.812	.893	1½"	6"	.220	500 A0
85-AY875	.875	.963	1½"	6"	.220	500 A0
85-AY937	.937	1.031	1½"	6"	.220	500 A0
85-AY1000	1.000	1.100	2"	6"	.220	500 A0
85-AY1250	1.250	1.375	2½"	6½"	.245	500 A0
85-AY1500	1.500	1.650	2½"	6½"	.245	500 A0
85-AY1750	1.750	1.925	3"	7"	.292	500 A0
85-AY2000	2.000	2.200	3"	8"	.292	320 A0
85-AY2500	2.500	2.750	3½"	9"	.292	320 A0
85-AY3000	3.000	3.300	4"	10"	.292	320 A0

**NEW! Diamond Filament Brushes Available**

\*Stocked in 800 mesh diamond. Available in other sizes upon request. Please see Series 85 AY chart for available sizes for Diamond Abrasive Nylon brushes.

**Heavy Duty Deburring Tools**

Catalog Number	Hole Dia.	Brush Dia.	Brush Part	Overall Length	Stem Dia. Inches	Stocked Abrasive
90-AY750	0.750	0.825	1½"	6"	.280	500 A0
90-AY875	0.875	0.963	1½"	6"	.280	500 A0
90-AY1000	1.000	1.100	2"	8"	.280	500 A0
90-AY1250	1.250	1.375	2"	8"	.310	500 A0
90-AY1500	1.500	1.650	2"	8"	.310	500 A0
90-AY1750	1.750	1.925	2"	8"	.310	500 A0
90-AY2000	2.000	2.200	3"	10"	.310	320 A0
90-AY2250	2.250	2.475	3"	10"	.310	320 A0
90-AY2500	2.500	2.750	3"	10"	.310	320 A0
90-AY2750	2.750	3.025	3"	10"	.310	320 A0
90-AY3000	3.000	3.300	4"	10"	.310	320 A0
90-AY3500	3.500	3.850	4"	10"	.310	320 A0

**SERIES 85-AY  
ABRASIVE NYLON**

- + Galvanized Steel Stem Wire
- + Abrasive Nylon Fill
- + Single Stem-Single Spiral
- + Bottom End Construction
- + Specify grit type and size when ordering

See page 26 for abrasive nylon chart



**TOOL TIP:**

Abrasive Nylon Twisted-in-Wire brushes are an excellent solution to mild surface finishing and thread deburring. For diameters over 4mm, the Flex-Hone® is a faster, more efficient solution for finishing and crosshole deburring. Flex-Hones® are not recommended for threaded applications.

**SERIES 85-AD  
ABRASIVE NYLON  
IN DIAMOND**

**NEW**

**SERIES 90-AY  
ABRASIVE NYLON**

- + Galvanized Steel Stem Wire
- + Rigid Double Stem-Double Spiral





## MINIATURE CROSSHOLE DEBURRING BRUSHES

### SERIES 81A

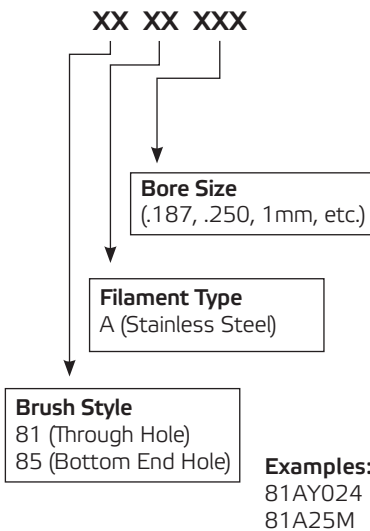
For through hole applications

#### Miniature Cross Hole Deburring System

+ Available in stainless  
steel filament



#### How to Order BRM Miniature Wire Brushes:



Catalog No. (Diameter)	Wire Size	Brush Part	Stem Diameter	Overall Length
81-A .024	.003	¼"	.015	3"
81-A .032	.002	⅝"	.016	3"
81-A .047	.002	¾"	.026	3"
81-A .054	.002	¾"	.026	3"
81-A .063	.003	¾"	.034	3"
81-A .079	.003	¾"	.034	3"
81-A .094	.003	¾"	.043	3"
81-A .109	.003	¾"	.055	3"
81-A .125	.003	1"	.055	3"
81-A .142	.003	1"	.072	3"
81-A .156	.003	1"	.072	3"
81-A .172	.003	1"	.083	3"
81-A .189	.003	1"	.083	3"
81-A 1mm	.002	⅝"	.016	3"
81-A 1.5mm	.002	⅝"	.026	3"
81-A 2mm	.003	¾"	.034	3"
81-A 2.5mm	.003	¾"	.043	3"
81-A 3mm	.003	1"	.055	3"
81-A 3.5mm	.003	1"	.055	3"
81-A 4mm	.003	1"	.072	3"
81-A 4.5mm	.003	1"	.083	3"
81-A 5mm	.003	1"	.083	3"
81-A 5.5mm	.003	1"	.110	3"
81-A 6mm	.003	1"	.110	3"
81-A 6.5mm	.003	1"	.110	3"
81-B 7/32	.003	1½"	.097	3"
81-B ¼	.003	1½"	.110	3"
81-B 5/16	.004	1½"	.125	3"
81-B 3/8	.004	1½"	.140	3"
81-B 7/16	.004	1½"	.140	3"
81-B ½	.005	1½"	.168	3"

**NEW**

### PIN VISES - TOOL HOLDERS FOR MINIATURE BRUSHES

BRM pin vises offer a secure method of holding small diameter miniature deburring brushes when stem diameters are too small for automated machining. Using pin vises reduces operator fatigue and improves efficiency. Model PV460 is double ended, has a hexagonal locking collet and comes with 2 reversible 4-jaw chucks for ultimate versatility. Model PV467 offers a unique swivel action that allows for precise and consistent control during deburring and finishing. Our high quality pin vises are made from chrome plated brass and have a solid feel.



Catalog Number	Type	Stem Diameters	Brush Diameters
PV460	Pin Vise - Hexagonal Type	0.109 Max. to any Min.	up to 7/32"
PV467	Pin Vise - Swivel Type	0.125 Max. to any Min.	up to 5/16"

Brush Dia.	Fill Sizes				Brush Part	Overall Length	Catalog Numbers			
	C.S.	S.S.	Brass	Nylon			Stainless	Carbon	Brass	Nylon
¼"	.006	.004	.005	.008	1½"	4½"	83-S250	83-C250	83-B250	83-N250
⅓"	.006	.004	.005	.010	1½"	4½"	83-S312	83-C312	83-B312	83-N312
⅔"	.006	.005	.005	.010	1½"	4½"	83-S375	83-C375	83-B375	83-N375
⅞"	.006	.005	.005	.010	1½"	5"	83-S437	83-C437	83-B437	83-N437
½"	.006	.006	.005	.010	1½"	5"	83-S500	83-C500	83-B500	83-N500
⅝"	.006	.006	.005	.010	1½"	5"	83-S562	83-C562	83-B562	83-N562
⅚"	.008	.008	.008	.012	1¾"	5"	83-S625	83-C625	83-B625	83-N625
¾"	.008	.008	.008	.014	1¾"	5"	83-S750	83-C750	83-B750	83-N750
⅞"	.008	.008	.008	.014	2"	6"	83-S875	83-C875	83-B875	83-N875
1"	.008	.008	.008	.017	2"	6"	83-S1000	83-C1000	83-B1000	83-N1000
1¼"	.010	.010	.010	.022	2½"	6"	83-S1250	83-C1250	83-B1250	83-N1250
1½"	.010	.010	.010	.022	2½"	6"	83-S1500	83-C1500	83-B1500	83-N1500
1¾"	.010	.010	.010	.022	3"	7"	83-S1750	83-C1750	83-B1750	83-N1750
2"	.010	.012	.012	.028	3"	7"	83-S2000	83-C2000	83-B2000	83-N2000

SERIES 83



These brushes can be used for thread deburring, tube cleaning, de-scaling and rust removal. They are cut for power and can be made with carbon steel, stainless steel, brass or nylon filament to provide a solution to a variety of cleaning applications.



**SOLUTION SHOWCASE**  
**MINIATURE BRUSHES**

Small parts requiring deburring, edge blending or other surface finishing operations can present particular production challenges to manufacturers. Often production is taken off-stream resulting in reduced productivity and inconsistent product quality.

A miniature deburring brush can solve both the productivity and quality challenges involved when manufacturing parts of various small sizes, contours and materials. Precision Planting, Inc. (Tremont, IL), an industry leader in agricultural seed planting equipment, manufactures a variety of systems that are designed to solve exact seed spacing and placement issues.

"One of our newest systems has tubes that are injection molded, and we had great concern about removing the residual flash that was created by the molding process," explains Precision Planting engineer Derek Sauder. "It may only be only .002 to .005 in. Using BRM's miniature brushes have "allowed our products to become the most accurate planting equipment in the market," he says. "Our product is well-known and has a fine reputation in the marketplace. And this process helps us attain that. It is economical and gives us good results."



# TUBE BRUSHES

## METRIC CONVERSION TABLES

Fractional Inches to Decimal Inches and Millimeters			Inches to Millimeters				Millimeters to Inches						
in.	in.	decimi. mm	in.	in.	decimi. mm	in.	mm	in.	mm	inches	mm	inches	
1/64	0.015625	0.397	41/64	0.640625	16.272	1 1/32	26.194	2 9/32	57.944	3/4	0.0098	38	1.4961
1/32	0.03125	0.794	21/32	0.65626	16.669	1 1/16	26.988	2 5/16	58.738	1/2	0.0197	39	1.5354
3/64	0.046875	1.191	43/64	0.671875	17.066	1 3/32	27.781	2 11/32	59.531	3/8	0.0295	40	1.5748
1/16	0.0625	1.588	11/16	0.6875	17.462	1 1/8	28.575	2 3/8	60.325	1	0.0394	41	1.6142
5/64	0.078125	1.984	45/64	0.703125	17.859	1 5/32	29.369	2 13/32	61.119	2	0.0787	42	1.6535
3/32	0.09375	2.381	23/32	0.71875	18.256	1 3/16	30.162	2 7/16	61.912	3	0.1181	43	1.6929
7/64	0.109375	2.778	47/64	0.734375	18.653	1 7/32	30.956	2 15/32	62.706	4	0.1575	44	1.7323
1/8	0.125	3.175	3/4	0.75	19.050	1 1/4	31.750	2 1/2	63.500	5	0.1969	45	1.7717
9/64	0.140625	3.572	49/64	0.765625	19.447	1 9/32	32.544	2 17/32	64.294	6	0.2362	46	1.8110
5/32	0.15625	3.969	25/32	0.78125	19.844	1 5/16	33.338	2 9/16	65.088	7	0.2756	47	1.8504
11/64	0.171875	4.366	51/64	0.796875	20.241	1 11/32	34.131	2 19/32	65.881	8	0.3150	48	1.8898
3/16	0.203125	4.762	13/16	0.8125	20.638	1 3/8	34.925	2 5/8	66.675	9	0.3543	49	1.9291
19/64	0.21875	5.159	53/64	0.828125	21.034	1 13/32	35.719	2 21/32	67.469	10	0.3937	50	1.9685
7/32	0.234375	5.556	27/32	0.84375	21.431	1 7/16	36.512	2 11/16	68.262	11	0.4331	51	2.0079
15/64	0.234375	5.953	55/64	0.859375	21.828	1 15/32	37.306	2 23/32	69.056	12	0.4724	52	2.0472
1/4	0.25	6.350	7/8	0.875	22.225	1 1/2	38.100	2 3/4	69.850	13	0.5118	53	2.0866
17/64	0.265625	6.747	57/64	0.890625	22.622	1 17/32	38.894	2 25/32	70.644	14	0.5512	54	2.1260
9/32	0.28125	7.144	29/32	0.90625	23.019	1 9/16	38.688	2 13/16	71.438	15	0.5906	55	2.1654
19/64	0.296875	7.541	59/64	0.921875	23.416	1 19/32	40.481	2 27/32	72.231	16	0.6299	56	2.2047
5/16	0.3125	7.938	15/16	0.9375	23.819	1 5/8	41.275	2 7/8	73.025	17	0.6693	57	2.2441
21/64	0.328125	8.334	61/64	0.953125	24.209	1 21/32	42.069	2 29/32	73.819	18	0.7087	58	2.2835
11/32	0.34375	8.731	31/32	0.96875	24.606	1 11/16	42.862	2 15/16	74.612	19	0.7480	59	2.3228
23/64	0.359375	9.128	63/64	0.984375	25.003	1 23/32	43.656	2 31/32	75.406	20	0.7874	60	2.3622
3/8	0.375	9.525	1	1.0	25.400	1 3/4	44.450	3	76.200	21	0.8268	61	2.4016
25/64	0.390625	9.922				1 25/32	45.244			22	0.8661	62	2.4409
13/32	0.40625	10.319				1 13/16	46.038			23	0.9055	63	2.4803
27/64	0.421875	10.716				1 27/32	46.831			24	0.9449	64	2.5197
7/16	0.4375	11.112				1 7/8	47.625			25	0.9843	65	2.5591
29/64	.0453125	11.509				1 29/32	48.419			26	1.0236	66	2.5984
31/32	.046875	11.906				1 15/16	49.212			27	1.0630	67	2.6378
31/64	0.484375	12.303				1 31/32	50.006			28	1.1024	68	2.6772
1/2	0.5	12.700				2	50.800			29	1.1417	69	2.7165
33/64	0.515625	13.097				2 1/32	51.594			30	0.0098	70	2.7559
17/32	0.53125	13.494				2 1/16	52.388			31	1.2205	71	2.7953
35/64	0.546875	13.891				2 3/32	53.181			32	1.2598	72	2.8346
9/16	0.5625	14.288				2 1/8	53.975			33	1.2992	73	2.8740
37/64	0.578125	14.684				2 5/32	54.769			34	1.338	74	2.9134
19/32	0.59375	15.081				2 3/16	55.562			35	1.3780	75	2.9528
39/64	0.609375	15.478				2 7/32	56.356			36	1.4173	76	2.9921
5/8	0.625	15.875				2 1/4	57.150			37	1.4567	77	3.0315



Ring handles may be cut off for power applications.

**Fill Sizes**

**Catalog Numbers**

Dia.	Brass	C.S.	6-12 Nylon	S.S.	Brush Part	Overall Length	Type 302 Stainless	Hi-Temp. Carbon	Brass	6-12 Nylon	Natural Bristle
1/8"	.003	.003	.005	.003	1 1/4"	8"	84-S125	84-C125	84-B125	84-N125	84-H125
3/16"	.003	.003	.005	.003	1 1/2"	8"	84-S187	84-C187	84-B187	84-N187	84-H187
1/4"	.005	.006	.008	.004	2"	8"	84-S250	84-C250	84-B250	84-N250	84-H250
5/16"	.005	.006	.008	.004	2"	8"	84-S312	84-C312	84-B312	84-N312	84-H312
3/8"	.005	.006	.010	.004	2"	8"	84-S375	84-C375	84-B375	84-N375	84-H375
7/16"	.005	.006	.010	.004	2 1/2"	10"	84-S437	84-C437	84-B437	84-N437	84-H437
1/2"	.005	.006	.012	.005	2 1/2"	10"	84-S500	84-C500	84-B500	84-N500	84-H500
9/16"	.005	.006	.012	.006	2 1/2"	10"	84-S562	84-C562	84-B562	84-N562	84-H562
5/8"	.008	.008	.014	.008	2 1/2"	10"	84-S625	84-C625	84-B625	84-N625	84-H625
3/4"	.008	.008	.017	.008	2 1/2"	10"	84-S750	84-C750	84-B750	84-N750	84-H750
7/8"	.010	.010	.017	.010	3"	12"	84-S875	84-C875	84-B875	84-N875	84-H875
1"	.010	.010	.017	.010	3"	12"	84-S1000	84-C1000	84-B1000	84-N1000	84-H1000
1 1/8"	.010	.010	.017	.010	3"	12"	84-S1125	84-C1125	84-B1125	84-N1125	84-H1125
1 1/4"	.010	.010	.022	.010	3"	12"	84-S1250	84-C1250	84-B1250	84-N1250	84-H1250
1 3/8"	.010	.010	.022	.010	3"	12"	84-S1375	84-C1375	84-B1375	84-N1375	84-H1375
1 1/2"	.010	.010	.022	.010	3"	12"	84-S1500	84-C1500	84-B1500	84-N1500	84-H1500
1 5/8"	.010	.010	.022	.010	3 1/2"	18"	84-S1625	84-C1625	84-B1625	84-N1625	84-H1625
1 3/4"	.012	.012	.022	.012	3 1/2"	18"	84-S1750	84-C1750	84-B1750	84-N1750	84-H1750
2"	.012	.012	.022	.012	3 1/2"	18"	84-S2000	84-C2000	84-B2000	84-N2000	84-H2000
2 1/4"	.012	.012	.025	.012	4"	18"	84-S2250	84-C2250	84-B2250	84-N2250	84-H2250
2 1/2"	.012	.012	.025	.012	4"	18"	84-S2500	84-C2500	84-B2500	84-N2500	84-H2500
2 3/4"	.012	.012	.025	.012	4"	18"	84-S2750	84-C2750	84-B2750	84-N2750	84-H2750
3"	.012	.012	.025	.012	4"	18"	84-S3000	84-C3000	84-B3000	84-N3000	84-H3000

## SERIES 84 - FOR THRU HOLES



### SOLUTION SHOWCASE

#### TUBE BRUSH TIPS

- + Never reverse a twisted in wire brush while in the bore. This will result in filament unraveling
- + Change the handle—most tube brushes can be manufactured with various handle types. If looped or wooden handles are not providing the proper cleaning, request cutting the handles for power.

#### Turned End vs. Cut End



Turned ends are for bottom end or closed hole applications. The turned end protects the part from being damaged.

Available Turned End Brushes: Series 85, 89, 90 and 92



Cut ends are used for through hole applications.

Available Cut End Series 81, 83 and 84

## SERIES 85 BOTTOM END - FOR CLOSED HOLES



Available in Carbon Steel,  
Stainless Steel, Brass, Nylon  
and Natural Bristle

- + Usually cut for power
- + Add "RH" to Cat. No. for Ring Handle
- + Add "WH" to Cat. No. for Plastic Handle
- + Heavy Duty Style Available on Request
- + Consult factory for Price and Availability

## TUBE BRUSHES

Dia.	Carbon Steel	Brass	S.S.	6-12 Nylon	Brush Part	Overall	Catalog Numbers				
							Type 302 Stainless	Hi Temp. Carbon	Brass	6-12 Nylon	Natural Bristle
1/8"			.002		1"	4"	85-S2-125				
1/8"	.003	.003	.005	1"	4"	85-S3-125		85-B125	85-N125	85-H125	
5/32"	.003	.003	.005	1"	4"	85-S156		85-B156	85-N156	85-H156	
3/16"	.003	.003	.005	1"	4"	85-S187		85-B187	85-N187	85-H187	
7/32"	.003	.003	.008	1"	4"	85-S219		85-B219	85-N219	85-H219	
1/4"	.006	.005	.004	.008	1 1/4"	4 1/2"	85-S250	85-C250	85-B250	85-N250	85-H250
9/32"	.006	.005	.004	.008	1 1/4"	4 1/2"	85-S281	85-C281	85-B281	85-N281	85-H281
5/16"	.006	.005	.004	.008	1 1/4"	4 1/2"	85-S312	85-C312	85-B312	85-N312	85-H312
11/32"	.006	.005	.004	.008	1 1/4"	4 1/2"	85-S344	85-C344	85-B344	85-N344	85-H344
3/8"	.006	.005	.004	.010	1 1/4"	4 1/2"	85-S375	85-C375	85-B375	85-N375	85-H375
13/32"	.006	.005	.004	.010	1 1/4"	4 1/2"	85-S406	85-C406	85-B406	85-N406	85-H406
7/16"	.006	.005	.004	.012	1 1/4"	4 1/2"	85-S437	85-C437	85-B437	85-N437	85-H437
15/32"	.006	.005	.005	.012	1 1/4"	4 1/2"	85-S469	85-C469	85-B469	85-N469	85-H469
1/2"	.006	.005	.005	.012	1 1/2"	5"	85-S500	85-C500	85-B500	85-N500	85-H500
9/16"	.006	.005	.006	.014	1 1/2"	5"	85-S562	85-C562	85-B562	85-N562	85-H562
5/8"	.008	.008	.008	.014	1 1/2"	5"	85-S625	85-C625	85-B625	85-N625	85-H625
11/16"	.008	.008	.008	.014	1 1/2"	5"	85-S687	85-C687	85-B687	85-N687	85-H687
3/4"	.008	.008	.008	.017	1 1/2"	5"	85-S750	85-C750	85-B750	85-N750	85-H750
13/16"	.010	.010	.010	.017	1 1/2"	6"	85-S812	85-C812	85-B812	85-N812	85-H812
7/8"	.010	.010	.010	.017	1 1/2"	6"	85-S875	85-C875	85-B875	85-N875	85-H875
15/16"	.010	.010	.010	.017	1 1/2"	6"	85-S937	85-C937	85-B937	85-N937	85-H937
1"	.010	.010	.010	.017	2"	6"	85-S1000	85-C1000	85-B1000	85-N1000	85-H1000
1 1/4"	.010	.010	.010	.022	2 1/2"	6 1/2"	85-S1250	85-C1250	85-B1250	85-N1250	
1 1/2"	.010	.010	.010	.022	2 1/2"	6 1/2"	85-S1500	85-C1500	85-B1500	85-N1500	
1 3/4"	.012	.012	.012	.022	3"	7"	85-S1750	85-C1750	85-B1750	85-N1750	
2"	.012	.012	.012	.022	3"	8"	85-S2000	85-C2000	85-B2000	85-N2000	
2 1/2"	.012	.012	.012	.025	3 1/2"	9"	85-S2500	85-C2500	85-B2500	85-N2500	
3"	.012	.012	.012	.025	4"	10"	85-S3000	85-C3000	85-B3000	85-N3000	

## SERIES 86 - TUFTED END BRUSHES



Available on Special Order.

- + Used in clean-room operations.
- + Made with loop handles and stainless steel or nylon fill.
- + Tied tufts prevent scratches by the stem ends.
- + Contact factory with your specifications.

## SERIES 87 - CENTER BRUSHES



Available on Special Order.

- + Power one end - Bearing the other.
- + Use in automated set-ups.
- + Contact factory with your specifications.

**Available on Special Order.**

- + Custom made to your tapered requirements.
- + For power operation or handle may be added for hand use.
- + Contact factory with your specifications.

**½" to 4" diameters**

Four wire single spiral with or without pipe nipple. Recommended for removing soft deposits (mud, algae, etc.) in straight tubes. Available in Stainless Steel, Carbon Steel, 6-12 Nylon and Brass.

- + 5/16" - 18 I.D. threaded nipple on ½" to 5/8" diameter.
- + 1/8" Pipe Nipple on 3/4" diameter.
- + 1/4" Pipe Nipple on 7/8" diameter and larger.

*Nipples will be attached unless otherwise specified.*

Four wire, Double Spiral, with or without nipple.

- + 1/8" Pipe Nipple on ½" to 3/4" diameter.
- + 1/4" Pipe Nipple on 7/8" diameter and larger.

*Nipples will be attached unless otherwise specified.*

Brush Dia.	BP	OAL	All 302 Stainless	Stainless Fill	Hi-Temp. Carbon St.	Wire Size	6-12 Nylon	Nylon Size	Brass Fill	Wire Size
½"	4"	7"	90-SS500	90-S500	90-C500	.008	90-N500	.018	90-B500	.008
5/8"	4"	7"	90-SS625	90-S625	90-C625	.010	90-N625	.018	90-B625	.010
¾"	4"	7"	90-SS750	90-S750	90-C750	.010	90-N750	.018	90-B750	.010
7/8"	4"	7"	90-SS875	90-S875	90-C875	.010	90-N875	.018	90-B875	.010
1"	4 ½"	7 ½"	90-SS1000	90-S1000	90-C1000	.012	90-N1000	.022	90-B1000	.012
1 ¼"	4 ½"	7 ½"	90-SS1250	90-S1250	90-C1250	.012	90-N1250	.022	90-B1250	.012
1 ½"	4 ½"	7 ½"	90-SS1500	90-S1500	90-C1500	.012	90-N1500	.028	90-B1500	.012
1 ¾"	4 ½"	7 ½"	90-SS1750	90-S1750	90-C1750	.012	90-N1750	.028	90-B1750	.012
2"	4 ½"	7 ½"	90-SS2000	90-S2000	90-C2000	.012	90-N2000	.028	90-B2000	.012
2 ¼"	4 ½"	7 ½"	90-SS2250	90-S2250	90-C2250	.012	90-N2250	.032	90-B2250	.012
2 ½"	4 ½"	7 ½"	90-SS2500	90-S2500	90-C2500	.012	90-N2500	.032	90-B2500	.012
2 ¾"	4 ½"	7 ½"	90-SS2750	90-S2750	90-C2750	.012	90-N2750	.032	90-B2750	.012
3"	4 ½"	7 ½"	90-SS3000	90-S3000	90-C3000	.014	90-N3000	.032	90-B3000	.012
3 ½"	4 ½"	7 ½"	90-SS3500	90-S3500	90-C3500	.014	90-N3500	.045	90-B3500	.018
4"	5"	8"	90-SS4000	90-S4000	90-C4000	.016	90-N4000	.045	90-B4000	.018

**8-32 Thread**

Brush Dia.	Stainless Fill	Hi-Temp. Carbon St.	6-12 Nylon	Brass Fill
5/16"	92-S312	92-C312	92-N312	92-B312
11/32"	92-S344	92-C344	92-N344	92-B344
3/8"	92-S375	92-C375	92-N375	92-B375
7/16"	92-S437	92-C437	92-N437	92-B437
½"	92-S500	92-C500	92-N500	92-B500
9/16"	92-S562	92-C562	92-N562	92-B562
19/32"	92-S594	92-C594	92-N594	92-B594

**SERIES 88 - TAPERED BRUSHES**



**SERIES 89 - CONDENSER TUBE**



**SERIES 90 - FLUE BRUSHES**



**SERIES 92 - ADAPTOR TYPE**





## BUTTERFLY TYPE



### More Product Description:

Available for all popular screw thread sizes from 1/4" thru 1 1/4" diameters, these butterfly type brushes are made in carbon steel, stainless steel, brass and nylon filaments. These brushes are ideal for thread cleaning and deburring and can be used on tapered screw threads.

## THREAD CLEANING BRUSHES

### Carbon Steel Wire Fill

Catalog Number	Dia.	Fill Size	Brush Part	Stem Dia.	Catalog Number	Dia.	Fill Size	Brush Part	Stem Dia.
BR-1/4	1/4"	.003 .006	9/16"	3/32"	BR-5/8	5/8"	.003 .006	5/8"	1/8"
BR-9/32	9/32"	.003 .006	9/16"	3/32"	BR-3/4	3/4"	.003 .006	5/8"	1/8"
BR-5/16	5/16"	.003 .006	9/16"	3/32"	BR-7/8	7/8"	.006 .008	5/8"	1/8"
BR-11/32	11/32"	.003 .006	9/16"	3/32"	BR-15/16	15/16"	.006 .008	5/8"	1/8"
BR-3/8	3/8"	.003 .006 .008	9/16"	3/32"	BR-1	1"	.006 .008	5/8"	1/8"
BR-13/32	13/32"	.003 .006 .008	9/16"	3/32"	BR-1 1/16	1 1/16"	.006 .008	5/8"	1/8"
BR-7/16	7/16"	.003 .006 .008	9/16"	3/32"	BR-1 1/8	1 1/8"	.006 .008	5/8"	1/8"
BR-15/32	15/32"	.003 .006 .008	9/16"	3/32"	BR-1 3/16	1 3/16"	.006 .008	5/8"	1/8"
BR-1/2	1/2"	.003 .006 .008	9/16"	3/32"	BR-1 1/4	1 1/4"	.006 .008	5/8"	1/8"
BR-9/16	9/16"	.003 .006 .008	5/8"	1/8"	BRR-3/8	3/8"	.006	5/8"	1/8"
					BRR-7/16	7/16"	.006	5/8"	1/8"
					BRR-1/2	1/2"	.006	5/8"	1/8"

## BUTTERFLY ADAPTORS



Adaptors:  
BR-8H Adaptor for 3/32" stem.  
BR-12H Adaptor for 1/8" stem.  
Order by Catalog Number + Fill Size

### Stainless Steel Wire Fill

Catalog Number	Dia.	Fill Size	Brush Part	Stem Dia.
BS-1/4	1/4"	.005	9/16"	3/32"
BS-15/16	15/16"	.005	9/16"	3/32"
BS-3/8	3/8"	.005	9/16"	3/32"
BS-7/16	7/16"	.005	9/16"	3/32"
BS-1/2	1/2"	.005	9/16"	3/32"
BS-9/16	9/16"	.005	5/8"	1/8"
BS-5/8	5/8"	.005	5/8"	1/8"
BS-3/4	3/4"	.005	5/8"	1/8"
BS-7/8	7/8"	.005	5/8"	1/8"
BS-1	1"	.005	5/8"	1/8"
BS-1 1/4	1 1/4"	.005	5/8"	1/8"

### Brass Wire Fill

Catalog Number	Dia.	Fill Size	Brush Part	Stem Dia.
BB-1/4	1/4"	.003	9/16"	3/32"
BB-5/16	5/16"	.003	9/16"	3/32"
		.005		
BB-3/8	3/8"	.003	9/16"	3/32"
		.005		
BB-7/16	7/16"	.005	9/16"	3/32"
BB-1/2	1/2"	.005	9/16"	3/32"
BB-7/8	7/8"	.005	5/8"	1/8"

### Nylon Fill

BN-1/4	1/4"	.010	9/16"	3/32"
BN-3/8	3/8"	.010	9/16"	3/32"
BN-1/2	1/2"	.010	9/16"	3/32"
BN-3/4	3/4"	.010	5/8"	1/8"
BN-7/8	7/8"	.010	5/8"	1/8"

Miniature brushes are ideal for a variety of small, precision deburring and finishing applications. Suitable for use in a Dremel-type tool.

### Miniature Wheels

Catalog Number	Brush Dia.	Fill	Hole Dia.	Catalog Number	Brush Dia.	Fill	Hole Dia.
82A-401	3/4"	medium bristle	1/8"	82A-402-1	1"	stiff bristle	1/8"
82A-401-1	1"	medium bristle	1/8"	82A-402-125	1 1/4"	stiff bristle	1/8"

### Miniature Cups

Catalog Number	Approx Dia. at flared end	Fill	Shank Dia.	Catalog Number	Appro Dia. at flared end	Fill	Shank Dia.
82B-403	9/16"	.005 crimped steel	3/32"	82B-407-1	9/16"	stiff bristle	1/8"
82B-404	1/2"	.003 crimped steel	3/32"	82B-407-3	1/2"	stiff bristle	3/32"
82B-405	5/8"	.003 crimped steel	1/8"				

### Mandrel Mounted

Catalog Number	Dia.	Fill	Shank	Thick-ness	Catalog Number	Dia.	Fill	Shank	Thick-ness
82C-408	3/4"	.003 cr. steel	1/8"	single	82C-418	1"	.005 cr. brass	3/32"	double
82C-411	1"	.003 lv. steel	3/32"	single	82C-419	1"	.005 cr. brass	1/8"	single
82C-412	1"	.003 cr. steel	1/8"	single	82C-420	3/4"	stiff bristle	3/32"	single
82C-413	1"	.005 cr. steel	3/32"	single	82C-421	3/4"	stiff bristle	1/8"	single
82C-414	1"	.005 cr. steel	1/8"	single	82C-422	1"	stiff bristle	3/32"	single
82C-415	3/4"	.003 cr. brass	3/32"	single	82C-427	3/4"	.005 cr. stainless	1/8"	single
82C-416	3/4"	.005 cr. brass	1/8"	single	82C-428	1"	.005 cr. stainless	1/8"	double
82C-417	1"	.003 lv. brass	3/32"	single					

### Miniature End

Catalog Number	Dia.	Fill	Shank	OAL	Catalog Number	Dia.	Fill	Shank	OAL
82D-429	3/16"	.003 straight steel	1/8"	2"	82D-431	3/16"	stiff bristle	1/8"	2"
82D-430	3/16"	.003 straight brass	1/8"	2"	82D-432	3/16"	soft bristle	1/8"	2"

## OPEN DEBURRING - SERIES 82



## PARTS WASH BRUSHES

PW-4P with Tube



PW-4PNT



PW-1P with Tube



PW-1PNT



PW-A with Tube



PW-ANT



PW-34



## PARTS WASH BRUSHES

Brush Research Mfg. is proud to offer the best parts wash brush on the market today. Injection molded Polypropylene handles, synthetic filaments for resistance to most solvent cleaners. Designed to be used in either petroleum-based or water based cleaning solutions. All metal parts are either stainless steel or brass for corrosion resistance. These are superior tools that will make each and every job easier and faster, saving both time and money. All tube fittings are manufactured to allow use on the most popular recirculating parts washers such as Enco, KlearFlo, Safety Kleen and others. The ergonomic styles will reduce any wrist strain and allow for increased pressure during cleaning.

- + Non-Slip Grip
- + Guaranteed not to mushroom
- + Heavy Duty Construction
- + Penetrating Tip

### Part No.

- PW-A** Flow thru with tube  
**PW-ANT** Flow thru without tube  
**PW-C** Non flow thru

The absolute best parts wash brush on the market today! Designed with the professional in mind. Made with synthetic filaments to resist most solvent type cleaners. Supplied with or without a 2 ft. tube designed to fit 0.500 to 0.600 O.D. parts washer nozzles.

### Part No.

- PW-6P** Flow thru with tube  
**PW-6PNT** Flow thru without tube

A totally new concept in parts washing brushes. The ergonomic handle design reduces wrist fatigue. Made with Polypropylene handles with synthetic filaments to resist most solvent type cleaners.

### Part No.

- PW-1P** Flow thru with valve and tube  
**PW-1PNT** Flow thru valve and without tube  
**PW-4P** Flow thru with valve and tube  
**PW-4PNT** Flow thru valve and without tube

Both brushes incorporate a unique flow control system that allows you to control the amount of cleaning fluid desired. The large brushing area of the PW-1P makes the cleaning of large areas faster and easier than ever before. The PW-4P is designed for the automotive brake mechanics.

### Part No.

- PW- 3/4** 3/4" diameter aluminum handle  
 Non flow thru scraper end

Our most popular selling parts wash brush, the PW-34, comes with polypropylene fill.



**CUSTOM BRUSHES FOR DIESEL**

**Cummins Group**

Stainless Steel wire with plastic handle to be used when changing injector while in truck.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
NH1	.005 SS	1.175	1 1/2"	14 1/2"
V861	.006 SS	1.155	2 1/8"	10 1/2"
JC1	.006 SS	1.200	2 1/8"	10 1/2"
L1	.006 SS	2.050	3 5/8"	12"

Stainless Steel wire cleans or polishes entire copper. Best used as a bench tool. Cut for power.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
NH2	.006 SS	1.625	4 1/4"	10"
V862	.006 SS	1.125	2 1/8"	10"
JC2	.006 SS	1.350	3 3/8"	10"
L2	.006 SS	2.250	6 1/2"	12"

Carbon Steel wire to be used as a seat brush to insure perfect seating of newly installed coppers. Cut for power.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
NH3N	.005 SS	1.175	1 1/2"	8 1/2"
L3N	.008 SS	2.125	1 3/4"	10"
V863	.010 C/S	1.250	2 1/8"	10"
JC3	.012 C/S	1.500	3 1/4"	10"
L30	.012 C/S	2.500	6 1/2"	12"

Cummins Injector Cup Retainer PTD cleaner brush, of .005 SS fill, shaped to fit ID.

**Part No.** PTD-1

Cummins Injector Cup for PTD (diameter 5/16" by 1/2" trim length).

Tapered-Brass Bridle

**Part No.** PTD- 2

Cummins Injector Cup for PTB 3/8" dia. by 5/8" trim. Tapered-Brass-Bridle

**Part No.** PTB- 1

Cummins Plunger Bore cleaner brush of medium soft 6-12 type nylon with handle.

**Part No.** PB

PB then specify diameter wanted. Diameters .400, .450, .500, .550, .850, 1".

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
PTD1	.006 SS	0.975	2"	10 1/2"
PTD2	.005 SS	0.312	1"	6 1/2"
PTB1	.005 SS	0.375	1 1/4"	6 1/2"

**COPPER CLEANING AND SEATING**



## DETROIT DIESEL



DD-1 (149)

DD-1 (53/71/92)



DD-3 (149)

DD-3/ NEW STYLE

DD-3 (53/71/92)

## CATERPILLAR



## INJECTOR CAVITY SEATING BRUSH



## AUTOMOTIVE BRUSHES

### SPECIALS FOR DIESEL OVERHAUL

Stainless Steel wire with plastic handle to be used when changing injector while in truck.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
DD1 (149)	.006 SS	1.400	2 ¾"	10½"
DD1 (53/71/92)	.006 SS	1.000	2 ¾"	10½"

Stainless Steel wire cleans or polishes entire copper. Best use as a bench tool. Cut for power.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
DD2 (149)	.006 SS	1.625	4 ¾"	10"
DD2 (53/71/92)	.006 SS	1.200	3 ¾"	10"

Carbon Steel wire to be used as a seat brush to insure perfect seating of newly installed coppers. Cut for power.

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
DD3 (149)	.012 C/S	1.675	5"	10"
DD3 (53/71/92)	.012 C/S	1.300	3 ⅝"	10"

For Direct Injection Nozzles

Clean Pre-Combustion Chambers of 1693, 333, 342, 345, 348, 353

Part Number	Wire Size	Major Dia.	Brush Part	Overall Length
CAT 1	.005 SS	0.900	7/8"	10 ½"
CAT 2	.005 SS	0.625	5/8"	10 ½"

To clean the shoulder/washer area. Two small diameter end brushes with .005 stainless steel wire with a brass bridle.

Part Number	Diameter	Brush Part
SB1	¼"	½"
SB2	5/16"	5/8"

**DIESEL ENGINE OVERHAUL**

Part Number	Diameter	Wire Size	Description
FB5	1/2"	.005 SS	Flat Bottom
FB75	3/4"	.005 SS	Flat Bottom

CSN Set of 1 each 6-12 Nylon 5/16" and 7/32 x 2 x 10  
CSS Same set in stainless steel wire

5 1/2" diameter brush of extra heavy .079 nylon filaments for fast and efficient cleaning of "O"-Ring grooves. Comes with small stainless steel hand tool for removing old "O"-Ring and scraping groove when replacing wet sleeves. (John Deere) Other sizes available (consult factory for pricing).

**Catalog Number 10-SJD**

3" Diameter crimped polypropylene fibers.

**Catalog Number SPOKE**

New style using a 7/32" shank for cleaning valve guides and other small holes.

Part Number	Fill Material	Brush Dia.	Brush Part	Overall Length
VGC312	.008 CS	5/16"	2 1/2"	9 1/2"
VGC344	.008 CS	11/32"	2 1/2"	9 1/2"
VGC375	.008 CS	3/8"	2 1/2"	9 1/2"
VGC438	.008 CS	7/16"	2 1/2"	9 1/2"

Nylon and stainless steel available on special request.

**INTERNATIONAL HARVESTER**



**CRANKSHAFT OIL HOLES**



**BLOCK "O" RING GROOVE CLEANER**



**SPOKE BRUSH**



**VALVE GUIDE BRUSHES**



**Interested in Valve Guide Kits?**

Please see our available kits on page 40.



## DEEP WELL END BRUSHES



DEB-2

DEB-5

## AUTOMOTIVE BRUSHES AND KITS

The Deep Well End Brushes are excellent for detailing. They have been designed so that when the end wears away, the body may be cut back to expose a new brush surface.

Part Number	Size	Brush Part	Fill Material	Body
DEB-1	¼"	4"	.012 Stainless Steel	Brass Tube
DEB-2	¾"	6"	.017 Stainless Steel	Brass Tube
DEB-5	½"	2 ½"	.020 Carbon Steel	Spring Cup

*Do not use on high speed drill motors. 1200 M.S.F. S.*

## KITS



### OIL LINE KIT BRUSHES:

A kit of 9 brushes made in 6-12 Nylon for cleaning the Oil Lines.

Each kit contains:

- + 1 ea. - #1 (1/4" dia.)
- + 2 ea. - #2 (5/16" dia.)
- + 6 ea. - #3 (3/8" dia.).

### 1 Oil Gallery Kit Contains:

A Kit of 5 brushes made in 6-12 Nylon for cleaning the Oil Galleries.

Each kit contains:

- + 1 ea. - 5 (5/8" x 3" x 34")
- + 1 ea. - 7 (3/4" x 3" x 34")
- + 1 ea. - 8 (3/4" x 3" x 40")
- + 1 ea. - 38 (3/8" x 3" x 34")
- + 1 ea. - 42 (1/2" x 2 3/4" x 34")

### 1 E Kit Contains:

- + 3 ea. - #1, 1a, 2, 2a / 6 ea. - #3
- + 1 ea. - #4, 5, 6, 7, 8, 9, 38, 41, 42, 46, 10a(5")
- + Total of 29 brushes (Savings on reg. price)

**VGNK (Nylon Valve Guide Kit) Contains:** 1, 2, 3, 44N, 47N, 48N, 49N

**VGCK (Carbon Steel Valve Guide Kit) Contains:** 11C, 13C, 14C, 44C, 47C, 48C, 49C

You can't have a clean engine with just a hot tank and an air hose with water. You need something to take out the old metal chips, the grinding compounds, the sludge and the dirt from the parts you can't see - the oil passageways. We use the finest-quality high-density 6-12 Nylon in our Nylon Brushes.

## NYLON

Catalog Number	Dia.	x	Brush Part	x	OAL	Description: 6-12 Nylon
1	¼	x	2	x	10	Small Stiff Brush for Feed Line Holes
1a						Same as #1 but with light fill and flexible stem
2	5/16	x	2 ½	x	12	Stiff Brush for Crankshaft Holes and Valve Guides
2a						Same as #2 but with light fill and flexible stem
3	3/8	x	2 ½	x	12	Same as #2
4	5/8	x	3	x	12	For Feed Lines and Main Bearings
5	5/8	x	3	x	34	Same as #4, but with extra length
6	¾	x	3	x	12	For larger size of Lifter Holes
7	¾	x	3	x	34	For Main Oil Galleries
8	¾	x	3	x	40	For Main Oil Galleries
9	1 1/8	x	3	x	14	For Lifter Holes
38	3/8	x	3	x	34	For Oil Galleries
41	½	x	2 ½	x	12	For Valve Guides
42	½	x	2 ½	x	34	For Main Oil Galleries
44	½	x	2 ½	x	12	Same as #41 but with light fill and flexible stem
46	1 ¼	x	4	x	12	For Tapered Pin Fitter
47	11/32	x	2 ½	x	12	For Valve Guides
48	19/32	x	2 ½	x	12	For Valve Guides
49	7/16	x	2 ½	x	12	For Valve Guides



Catalog Number	Dia.	x	Brush Part	x	OAL	Description: Carbon Steel
11-C	¼	x	2	x	10	Same as #1, but in Carbon Steel Wire
13-C	5/16	x	2 ½	x	12	For Cam Bearing Feed Lines and Valve Guides
14-C	3/8	x	2 ½	x	12	For Cam Bearing Feed Lines and Valve Guides
15	5/8	x	3	x	12	For Push Rod Holes
16	5/8	x	3	x	30	For Oil Galleries
6-C	¾	x	3	x	12	For Larger size Lifter Holes
7-C	¾	x	3	x	34	For Main Oil Galleries
8-C	¾	x	3	x	40	For Main Oil Galleries
18	1 1/8	x	3	x	14	For Lifter Holes
38-C	3/8	x	3	x	34	For Oil Galleries
44-C	½	x	2 ½	x	12	Same as #41, but in Carbon Steel Wire
45	½	x	2 ½	x	34	Same as #42, but in Carbon Steel Wire
46-C	1 ¼	x	4	x	12	For Tapered Pin Fitter
47-C	11/32	x	2 ½	x	12	For Valve Guides
48-C	19/32	x	2 ½	x	12	For Valve Guides
49-C	7/16	x	2 ½	x	12	For Valve Guides

## CARBON STEEL (FOR THE ROUGH SPOTS)

## MEDIUM FACE - STANDARD TWIST



B-464 Keyway

### Common Applications:

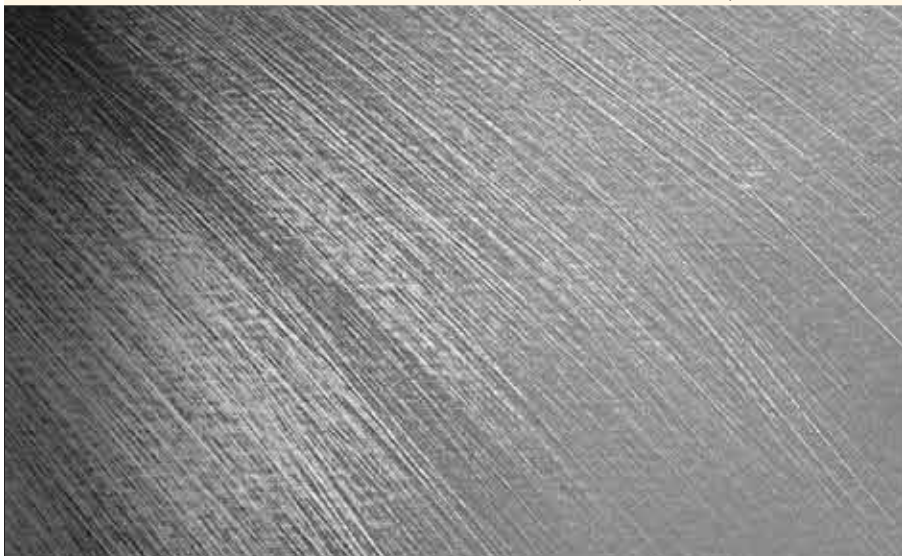
- + Rust and Scale Removal
- + Edge Blending
- + Deburring
- + Surface Preparation Before Painting and Plating
- + Finishing
- + Polishing

## WIDE FACE - STANDARD TWIST



## KNOTTED WIRE WHEEL BRUSHES

Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BTS-3	3"	.0118 .014 .020	.0118SS .014SS .020SS	3/8", 1/2"	1/2"	7/16"	20,000
BTS-4	4"	.0118 .014 .016 .020	.0118SS .014SS .016SS .020SS	3/8", 1/2" or 5/8" - 11"	13/16"	1/2"	20,000
BTS-6	6"	.0118 .014 .016 .023 .030	.0118SS .014SS .016SS	1/2", 5/8"	1 7/16"	5/8"	8,000
BTS-7	7"	.014	.016	1/2", 5/8"	1 11/16"	5/8"	8,000
BTS-8	8"	.0118 .014 .016 .023 .030	.0118SS .014SS .016SS	1/2", 5/8" 3/4"	1 11/16"	3/4"	6,000
B-462	6"	.016		1" w/ 2 keyways (similar to BTS-6)			8,000
B-464	8"	.016		1" w/ 2 keyways (similar to BTS-8)			6,000



Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
TW-8	8"	.0118 .016 .025		2"	1 3/4"	1 1/8"	6,000
TW-10	10"	.0118 .016		2"	2 1/4"	1 3/8"	4,500

**Note: For TW-8" - TW-10" use ALA adaptors. For more information, see pg. 55.**



Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BTC-4	4"	.014 .020	.014SS .020SS	3/8", 1/2" or 5/8" -11"	1 13/16"	3/8"	20,000
BTC-6	6"	.023 .030	.023SS .030SS	1/2", 5/8"	1 7/16"	7/16"	8,000
BTC-7	7"	.023 .030		1/2", 5/8"	1 11/16"	1/2"	7,000
BTC-8	8"	.023 .030		1/2", 5/8" 3/4"	1 11/16"	9/16"	6,000

Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BSTCM-102	4"	.020	.020SS	5/8" -11"	7/8"	3/16"	20,000
BSTCM-115	4 1/2"	.020		5/8" -11"	1 3/16"	3/16"	12,500
BSTCM-170	6 7/8"	.020	.020SS	5/8" -11"	1 1/4"	3/16"	9,000

Add S to Cat. No. for Stainless Steel

**Operator Safety:**

1. Always wear eye protection.
2. Observe maximum safe free speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.

## MEDIUM FACE - CABLE TWIST



## STRINGER BEAD - CABLE TWIST



**Specific Applications:**

- + Machined Parts
- + Gears
- + Turbine Blades
- + Weld Slag Removal

## TOOL TIPS

### WIRE BRUSHES

**Are you noticing that your brush action/marks are not uniform?**

- + Increase trim length/wire length
- + Decrease fill density and brush face
- + Automate the process to eliminate irregularities produced by human error

**Are you looking for longer brush life?**

- + Increase fill density or brush face width
- + Decrease wire size
- + Use less pressure - Wire Brushes SHOULD NOT BE PUT UNDER EXCESSIVE PRESSURE

**Are you having trouble with wire breakage?**

- + Use less pressure - Wire Brushes SHOULD NOT BE PUT UNDER EXCESSIVE PRESSURE
- + Decrease wire size



**Troubleshooting:**

If you're encountering any of these challenges with your wire brushes, try one of these recommended options  
(cont'd on page 45)

## MULTI-DUTY NARROW FACE



### Brush Characteristics

- + Narrow brushing face
- + High flexibility - long trim
- + Highest quality oil tempered crimped wire
- + Fine to medium coarse brushing action

## CRIMPED WIRE WHEEL BRUSHES

Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BDM-3	3"	.006	.006SS	3/8" - 1/2"	1/2"	3/8"	6,000
		.0104	.0118SS				
		.0118	.014SS				
BDM-4	4"	.006	.006SS	3/8" - 1/2"	7/8"	3/8"	6,000
		.008	.008SS				
		.0104	.0104SS				
		.0118	.0118SS				
BDM-6	6"	.006	.006SS	2"	1 1/8"	1/2"	4,500
		.008	.008SS				
		.0104	.0104SS				
		.0118	.0118SS				
BDM-6B	6"	.005		5/8" - 1/2"	1 1/16"	1/2"	6,000
		Brass					
BDM-8	8"	.006	.006SS	2"	1 1/2"	1/2"	4,500
		.008					
		.0104	.0104SS				
		.0118					
		.014	.014SS				

**Use AL type adaptors for BDM-6" and BDM-8". For more information, see pg. 55.**

## STANDARD DUTY MEDIUM FACE



### Brush Characteristics

- + Premier of medium face wire wheels
- + Absolute lowest end-of-service cost
- + Maximum desirable wire points at brush face
- + Highest quality oil tempered crimped wire
- + Low flexibility
  - fast cutting action
  - long life
- + Uniform brushing action

Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BDA-6	6"	.006	.006SS	2"	1 1/8"	7/8"	4,500
		.008	.008SS				
		.0104					
		.0118	.0118SS				
		.014	.014SS				
BDA-7	7"	.006		2"	1 5/8"	7/8"	4,500
		.0118					
		.014	.014SS				
BDA-8	8"	.006	.006SS	2"	1 1/2"	7/8"	4,500
		.0104	.0104SS				
		.0118	.0118SS				
		.014	.014SS				
BDA-10	10"	.006		2"	2"	1 1/8"	3,600
		.0104					
		.0118	.014SS				
		.014	.020				
BDA-12	12"	.0118		2"	3"	1 1/4"	3,000
		.014					
		.020					

**Note: BDA-6" - BDA-8" use AL adaptors. For BDA-10" - BDA-12" use ALA adaptors. For more information, see pg. 55.**

Catalog Number	Dia.	Wire Size		Arbor Holes	Trim Length	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel				
BDH-6	6"	.006	.006SS	2"	1 1/8"	1 3/8"	4,500
		.008					
		.0104					
		.0118	.0118SS				
		.014	.014SS				
BDH-7	7"	.0118		2"	1 5/8"	1 3/8"	4,500
		.014					
BDH-8	8"	.006	.006SS	2"	1 1/2"	1 3/8"	4,500
		.0104					
		.0118					
		.014	.014SS				
		.020					
BDH-10	10"	.0104		2"	2 1/8"	1 3/4"	3,600
		.014					
		.020					
BDH-12	12"	.0118		2"	3"	2"	3,000
		.014					
		.020					

**Note: BDH-6" - BDH-8" use AL adaptors. For BDH-10" - BDH-12" use ALA adaptors. For more information, see pg. 55.**

Order by catalog number and specify wire size and arbor hole. When ordering stainless steel wire be sure to add the letter S to the catalog number.

**Operator Safety:**

1. Always wear eye protection.
2. Observe maximum safe free speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.

## HEAVY DUTY WIDE FACE



**Brush Characteristics**

- + Wide brushing face
- + Low flexibility
  - fast cutting action
  - long life
- + Highest quality oil tempered crimped wire
- + Heavily filled
- + Uniform brushing action



## TOOL TIPS

### WIRE BRUSHES

**Is your brush not aggressive enough?**

- + Increase surface speed
- + Increase wire size
- + Decrease trim length
- + Increase fill density or brush face width

**Is your brush too aggressive?**

- + Decrease wire size
- + Decrease RPM
- + Decrease face width and fill density
- + Choose a brush with longer wire length

**Are you looking for a smoother finish?**

- + Switch to an Abrasive Nylon Brush
- + Decrease wire size
- + Choose a brush with longer wire length
- + Increase RPM
- + Increase fill density or brush face width

**Are you looking for a rougher finish?**

- + Increase wire size
- + Decrease RPM
- + Decrease face width and fill density
- + Decrease trim length

**Are you having problems with rolling or peening burrs instead of removing them?**

- + Switch to an Abrasive Nylon Brush
- + Increase brush diameter
- + Increase wire size

**Are you noticing that your brush action/marks are not uniform?**

- + Increase trim length/wire length
- + Decrease fill density and brush face.
- + Automate the process to eliminate irregularities produced by human error

**Troubleshooting:**

If you're encountering any of these challenges with your wire brushes, try one of these recommended options  
*(cont'd from page 43)*



## TAMPICO & NYLON WHEEL BRUSHES

### TAMPICO WHEEL BRUSHES



Catalog Number	Diameter	Arbor Holes	Face Width	Maximum Safe Free Speed (RPM)
CT-2	2"	½"	¾"	20,000
CT-2½	2½"	½"	¾"	20,000
CT-3	3"	½"	¾"	20,000
CT-3½	3½"	½"	½"	20,000
TWA-6	6"	2"	17/32"	6,000
TWA-8	8"	3¼"	17/32"	5,000
TWA-10	10"	3¼"	17/32"	4,500

**Note:** TWA-6" use ALA adaptors. For TWA-"8 -TWA-10" use MA adaptors. For more information, see pg. 55.

1. Used for polishing chrome and decorative surfaces
2. Oil and heat resistant
3. Can be used wet or dry
4. Often used in conjunction with a grease-type abrasive or polishing compounds.

### NYLON WHEEL BRUSHES



Catalog Number	Diameter	Arbor Holes	Nylon Size	Face Width	Maximum Safe Free Speed (RPM)
CN-1	1"	¼"	.006	¼"	20,000
CN-1 ¾"	1 ¾"	¼" or ¾"	.010	¼"	20,000
CN-1 ½"	1 ½"	¼" or ¾"	.010	¼"	20,000
CN-1 ¾"	1 ¾"	¼" or ¾"	.006 .010 .016	¼"	20,000
CN-2	2"	½" or 5/8"	.006 .010 .016	¾"	20,000
CN-2½	2½"	½" or 5/8"	.006 .010 .016	½"	20,000
CN-3	3"	½" or 5/8"	.006 .010 .016	½"	20,000
CN-3½	3½"	½" or 5/8"	.006 .010 .016 .020	½"	20,000
CN-4	4"	½" or 5/8"	.006 .010 .016 .020	½"	20,000
NWA-6	6"	2"	.006 .016 .022	½"	6,000
NWA-8	8"	2"	.006 .016 .022	½"	4,800

**Note:** For NWA-6" and 8" use ALA adaptors. For more information, see pg. 55.

Specify catalog number, filament size and arbor hole when ordering.

#### Operator Safety:

1. Always wear eye protection.
2. Observe maximum safe free speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.

- + Used for light deburring, brushing, cleaning, polishing and surface finishing
- + Excellent fatigue life and resistance to most solvents

Catalog Number	Diameter	Arbor Hole	Wire Size		Maximum Safe Free Speed (RPM)
			Carbon Steel	Stainless Steel	
C-1 ¼	1 ¼"	¾"	.006 .008		20,000
C-1 ⅜	1 ⅜"	¾"	.006 .008 .0104 .0118 .014		20,000
C-1 ½	1 ½"	¾"	.006 .008 .0104 .0118	.006SS	20,000
C-2	2"	½"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0104SS .0118SS .014SS	20,000
C-2 ½	2 ½"	½"	.006 .008 .0104 .0118 .014 .020	.006SS .0104SS .0118SS .014SS	20,000
C-2 ½	2 ½"	⅝"	.006 .008 .0104 .0118 .014 .020	.006SS .0104SS .0118SS .014SS	20,000
C-3	3"	½"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0118SS .014SS	20,000
C-3	3"	⅝"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0118SS .014SS	20,000
C-3 ½	3 ½"	½"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0104SS .0118SS .014SS	20,000
C-4	4"	½"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0104SS .0118SS .014SS	20,000
C-4	4"	⅝"	.006 .008 .0104 .0118 .014 .020	.006SS .008SS .0104SS .0118SS .014SS	20,000

## COPPER CENTER WHEEL BRUSHES



### Brush Characteristics

- + Small diameter brushing tools
- + Narrow brushing faces
- + Can be mounted in multiples
- + Designed to operate at high speeds
- + Light duty applications

### Popular Applications

- + Deburring
- + Edge blending
- + Cleaning - Rust removal
- + Roughing for adhesion
- + Finishing for appearance

Copper center wheels are also available in nylon, tampico, abrasive nylon and encapsulation (see pages 24, 46 & 53).

## CRIMPED (LIGHT DUTY USE)



## KNOT TYPE - SINGLE ROW



## KNOT TYPE - CABLE TWIST



## KNOT TYPE - DOUBLE ROW



## WIRE CUP BRUSHES

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUC-3	3"	.014	.014SS	5/8" - 11	1"	14,000
BUC-4	4"	.0118 .014 .020	.0118SS .014SS	5/8" - 11	1 1/4"	9,000
BUC-5	5"	.014 .020		5/8" - 11	1 1/4"	9,000
BUC-6	6"	.014 .020	.014SS	5/8" - 11	1 3/8"	6,600

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUS-3	2 3/4"	.014		5/8" - 11	7/8"	14,000
BUS-4	4"	.0118 .014 .020	.0118SS .014SS	5/8" - 11	1 1/4"	9,000
BUS-5	5"	.014 .020		5/8" - 11	1 1/4"	7,000
BUS-6	6"	.014 .020 .025	.014SS	5/8" - 11	1 3/8"	6,600

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUSC-3	2 3/4"	.020	.020SS	5/8" - 11	1"	14,000

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUDX-4	4"	.014 .020	.020SS	5/8" - 11	1 1/4"	9,000

### Operator Safety:

1. Always wear eye protection.
2. Observe maximum safe free speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.



## SOLID END

Catalog Number	Diameter	Wire Size		Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel		
BNS-4	½"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-6	¾"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-10	1"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		



General purpose end brushes used for cleaning castings, blending, polishing dies and removing carbon deposits on piston heads, cylinders and valve seats.

Also available with Nylon, or Brass Fill Material. For Abrasive Nylon see pg. 24.

## SOLID END - BANDED

Catalog Number	Diameter	Wire Size		Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel		
BNS-4T	½"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-6T	¾"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-10T	1"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		



## SOLID END - COATED CUP PROTECTOR

Catalog Number	Diameter	Wire Size		Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel		
BNS-4C	½"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-6C	¾"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		
BNS-10C	1"	.006	.006SS	7/8"	20,000
		.0104	.0104SS		
		.014	.014SS		
		.020	.020SS		



## KNOT TYPE END



## KNOT TYPE END - BANDED



## SMALL DIAMETER CUP



### Brush Characteristics

- + Wide range of sizes and shapes
- + Densely filled
- + Long life
- + Safe high speed operation

### Typical Applications

- + Weld cleaning
- + Mold cleaning
- + Polishing tools, discs and molds
- + Spot facing

## WIRE END BRUSHES

### Wire Size

Catalog Number	Dia.	Carbon Steel	Stainless Steel	Trim Length	Maximum Safe Free Speed (RPM)
BNH-6	¾"	.014 .020	.0145S .0205S	7/8"	20,000
BNH-12	1 1/8"	.014 .020	.0145S .0205S	7/8"	20,000

### Wire Size

Catalog Number	Dia.	Carbon Steel	Stainless Steel	Trim Length	Maximum Safe Free Speed (RPM)
BNH-6T	¾"	.014 .020	.0145S .0205S	7/8"	20,000
BNH-12T	1 1/8"	.014 .020	.0145S .0205S	7/8"	20,000

Cup protectors available on knotted end brushes on special request.

### Wire Size

Catalog Number	Dia.	Carbon Steel	Stainless Steel	Maximum Safe Free Speed (RPM)
BNH-16	1 3/4"	.006 .0104 .0118	.0065S .01185S	10,000
BNH-26	2 3/4"	.0118		8,000

Add S to Cat. No. for Stainless Steel.

Also available in Nylon or Brass fill material. For Abrasive Nylon see pg. 24.

### Operator Safety:

1. Always wear eye protection.
2. Observe maximum safe free speed requirements.
3. Keep machine guards in place.
4. Wear appropriate safety clothing.

Catalog Number	Dia.	Wire Size		Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel	
BNF-10	1"	.006 .008 .020	.006SS .008SS	20,000
BNF-12	1 ¼"	.006 .008 .020	.006SS	20,000
BNF-14	1 ½"	.006 .008 .014 .020	.006SS .008SS .020SS	20,000
BNF-26	2 ¾"	.008 .014 .020	.008SS	15,000
BNF-30	3"	.006 .008 .0104 .014 .020	.006SS .008SS .020SS	15,000
BNF-40	4"	.008	.008SS	15,000

## CIRCULAR END



### Product Description:

Available in sizes from 1 inch to 4 inches. The circular end type brush provides side cutting action. Will not score the bottom of blind holes. Ideal for use on a drill press or high speed portable tools.

The DEB-3, 3x, 4 and 4x Flare Brushes have a cobalt base hard facing which is flame-coated to the ends of stainless steel aircraft cable.

### DEB-3

- + 3-Prong Heavy Duty
- + Use with slow RPM drill motor for chipping operation. Suitable for carbon removal from ports, etc.
- + Will cover IDs up to 1 ½"

### DEB-4

- + 5-Prong Light Duty.
- + Will flare out at 2,000 RMP for rust and scale removal from pipe IDs. Long life as it does not get hung-up, which will twist cables.
- + Will cover IDs up to 5"

### DEB-3x

- + Similar to DEB-3 except with longer prongs up to 4" IDs.
- + For rust removal from pipe IDs at 2,000 RPM.

### DEB-4x

- + Similar to DEB-4 except made with longer prongs up to 7" IDs.

**Note: Available with threaded stem on special request.**

## FLARE BRUSHES

DEB 3



DEB 4





## MANDREL MOUNTED COPPER CENTER



### General Applications:

- + Slug and Scale Removal
- + Flash Removal
- + Rust and Paint Removal
- + Carbon Cleaning
- + Weld Cleaning

## MANDREL MOUNTED COPPER CENTER WHEEL BRUSHES

Catalog Number	Dia.	Wire Size		Approx. Running Face Width	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel		
BMC-12	1 ¼"	.006 .008	.006SS .008SS	¾"	25,000
BMC-13	1 ¾"	.006 .008 .0104	.006SS .008SS .0104SS	¾"	25,000
BMC-14	1 ½"	.006 .008 .0104	.006SS .008SS .0104SS	¼"	25,000
BMC-16	1 ¾"	.006 .008 .0118 .014	.006SS .008SS .0118SS	⅝"	25,000
BMC-20	2"	.006 .008 .0104 .0118 .014	.006SS .008SS .0104SS	⅝"	25,000
BMC-25	2 ½"	.008 .0104 .0118 .014		⅝"	25,000
BMC-30	3"	.008 .0104 .0118 .014		⅝"	25,000

**Note:** Speeds greater than 8,000 RPM do not enhance operation of brushes rated at 25,000 max. safe free speed.

## MANDREL MOUNTED FLARED



Constructed on ¼" diameter stems. Eliminates the need for separate adaptors when installing in chucks or collects of portable tools or drill presses. These brushes are ideal for internal pipe cleaning, carbon removal, and light rust and scale removal.

Catalog Number	Dia.	Wire Size		Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel	
BMF-14	1 ½"	.006 .008 .0104	.006SS .008SS .0104SS	25,000
BMF-16	1 ¾"	.006 .008 .0118 .014	.006SS .008SS .0118SS	25,000
BMF-20	2"	.006 .008 .0104 .0118 .014	.006SS .008SS .0104SS	25,000
BMF-25	2 ½"	.008 .0104 .0118 .014		25,000
BMF-30	3"	.008 .0104 .0118 .014		25,000

**Note:** Speeds greater than 8,000 RPM do not enhance operation of brushes rated at 25,000 max. safe free speed.

## PILOT BONDING AND ENCAPSULATED BRUSHES

Used for cleaning paint, dirt, rust, and varnish from around rivet and bolt holes. By placing the pilot pin in the rivet or bolt hole the cleaning action is confined. Assures a positive electrical contact to eliminate static electricity buildup.

Catalog Number	Pilot Diameter	Brush Diameter	Wire Size	Brush Part Length
06721	3/32"	1/2"	.005SS	3/8"
06741	1/8"	1/2"	.005SS	3/8"
06761	5/32"	1/2"	.005SS	3/8"
06781	3/16"	1/2"	.005SS	3/8"
06801	1/4"	1/2"	.005SS	3/8"

Stem Diameter - 1/4" max. safe free speed 20,000 RPM.

Encapsulated wire wheel and end brushes provide remarkably strong brushing action for fast burr removal and uniform surface blending. The encapsulation material creates the short wire trim configuration that gives the fast cutting action characteristic with minimum pressure. Substantially increased safety factor.

Avoid application to surfaces over 180° F. Excessive temperature will soften or melt the encapsulation material.

Type	Catalog Number	Diameter	Wire Size	Arbor Holes	Approx. Running Face Width	Maximum Safe Free Speed (RPM)
End	BNS-6E	3/4"	.0104 .020	1/4"		20,000
Wheel	CE-1 1/2	1 1/2"	.008 .0118	3/8"	7/32"	20,000
Wheel	CE-2	2"	.0104 .014	1/2"	9/32"	20,000
Wheel	CE-3	3"	.0118 .014	5/8"	5/16"	20,000

### PILOT BONDING



### ENCAPSULATED BRUSHES



### SOLUTION SHOWCASE

#### END BRUSH TIPS

End brushes are an excellent solution for applications where space is an issue. An end brush is typically used with a high speed hand-held tool for applications including cleaning, polishing, deburring and surface preparation.

#### Looking for a more aggressive solution?

Try our Banded End Brushes

#### Concerned about marring and scratching your work piece?

Try our End Brushes With Cup Protectors. These protectors eliminate the marring and scratching of adjoining surfaces in deep well applications.



### KNOT TYPE CUP - STANDARD TWIST, SINGLE ROW



### KNOT TYPE CUP - CABLE TWIST, SINGLE ROW



### KNOTTED WHEEL - STANDARD TWIST



### KNOTTED WHEEL - CABLE TWIST



### KNOTTED WHEEL - STRINGER BEAD



## MINI-GRINDER CUP & WHEEL BRUSHES

Every major tool company has a series of mini grinders. Most of these have metric threaded spindles and the distributor has been required to carry an extensive inventory of mini grinder brushes. Not anymore. Brush Research Manufacturing has a method to reduce this unnecessary inventory. An adaptor nut which fits any combination of mini brushes to mini grinders. All you need to carry are mini grinder brushes with a  $\frac{5}{8}$ " -11 threaded arbor. Reduce your inventory and capital invested. Simply carry a few of the reusable adaptor nuts and make life easier.

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUS-3	2 $\frac{3}{4}$ "	.014		$\frac{5}{8}$ " - 11	$\frac{7}{8}$ "	14,000

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BUSC-3	2 $\frac{3}{4}$ "	.020		$\frac{5}{8}$ " - 11	1"	14,000

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BTS-4	4"	.014	.014SS	$\frac{5}{8}$ " - 11	$\frac{13}{16}$ "	20,000
		.020	.020SS	$\frac{5}{8}$ " - 11	$\frac{13}{16}$ "	20,000

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BTC-4	4"	.014	.014SS	$\frac{5}{8}$ " - 11	$\frac{13}{16}$ "	20,000
		.020	.020SS	$\frac{5}{8}$ " - 11	$\frac{13}{16}$ "	20,000

Catalog Number	Dia.	Wire Size		Arbor Hole	Trim Length	Maximum Safe Free Speed (RPM)
		Carbon Steel	Stainless Steel			
BSTCM-102	4"	.020	.020SS	$\frac{5}{8}$ " - 11	$\frac{7}{8}$ "	20,000
BSTCM-115	4 $\frac{1}{2}$ "	.020		$\frac{5}{8}$ " - 11	$\frac{13}{16}$ "	12,500



Catalog Number	Arbor Adaptor	OAL	Stem Dia.	Adaptor Type	Max. Brush Diameter
1300	½"	1 7/8"	¼"	Left Hand Threaded	4"
AT1	½"	2 1/2"	¼"	Right Hand Threaded	4"
UA1	½"	2 5/16"	¼"	Left Hand Threaded	4"
UA2	3/8"	2 1/8"	¼"	Chuck Type Mandrel	4"
UA3	¼"	2 1/8"	¼"	Chuck Type Mandrel	2"
UA4	3/8"	1 5/8"	¼"	Left Hand Threaded	4"

**AL Type:** For use with BDM-6" – 8", BDA-6" – 8" and BDH-6" - 8"

Catalog Number	Diameter	Arbor Hole
AL ½	2"	½"
AL 5/8	2"	5/8"
AL 5/8 - ½	2"	5/8 - ½"
AL ¾	2"	¾"
AL 7/8	2"	7/8"
AL1	2"	1"
AL1¼	2"	1 ¼"
AL1½	2"	1 ½"

**ALA Type:** For use with BDA-10" – 12", BDH-10" – 12", TWA-6", TW-8" – 10", NWA-6" -8" and NY-6"

Catalog Number	Diameter	Arbor Hole
AL12A	2"	½"
AL1A	2"	1"
AL34A	2"	¾"
AL5812A	2"	5/8 - ½"
AL58A	2"	5/8"
AL78A	2"	7/8"

**MA Type:** For use with TWA-8", TWA-10" and NY-8"

Catalog Number	Fits Inside Diameter	Stocked Arbor Hole	Maximum Arbor Hole
MA3	3 ¼"	5/8"	2"

Specify arbor hole size on Plastic Snap-Out Adaptors

Catalog Number	Diameter	Arbor Hole	For Use with Single Section Brushes
SA-1214	½"	¼"	Copper Center Brushes
SA-1238	½"	3/8"	Copper Center Brushes Knot type 3" and 4" dia.
SA-5812	5/8"	½"	Copper Center and Wheel thru 8" dia. Knot type 6" thru 8" dia.

Catalog Number	O.D. Thread	"Adapt To" Thread
TNA-3824	5/8" - 11	3/8" - 24
TNA-10125	5/8" - 11	M-10 x 1.25
TNA-10150	5/8" - 11	M-10 x 1.50

**THREADED ADAPTORS**



**METAL ADAPTORS**



**SNAP-OUT ADAPTORS**



**THREADED NUT ADAPTORS**



## HAND SCRATCH BRUSHES

### CURVED HANDLE



Catalog Number	Number of Rows	Block Width	Overall Length	Trim Length
<b>Carbon Steel Wire</b>				
B-40	3 x 19	1"	13¾"	1 1/8"
B-41	4 x 19	1 1/8"	13¾"	1 1/8"
B-47 w/ scraper	4 x 19	1 1/8"	14"	1 1/8"
<b>Stainless Steel Wire</b>				
B-740	3 x 19	1"	13¾"	1 1/8"
B-741	4 x 19	1 1/8"	13¾"	1 1/8"
<b>Bronze Wire</b>				
B-840	3 x 19	1"	13¾"	1 1/8"
<b>Nylon</b>				
BN-49	4 x 19	1 1/8"	13¾"	1"
<b>Tampico Fibre</b>				
BT-49	4 x 18	1 1/8"	13¾"	1"
<b>Platers Fine Wire Brushes .006 Stainless Steel Wire</b>				
B-49S	4 x 19	1 1/8"	14"	1"
<b>.006 Brass Wire</b>				
B-39B	3 x 19		13¾"	1 1/8"
B-49B	4 x 19		13¾"	1 1/8"

### BLOCK BRUSH



B-200 Chip Removal Brush

Catalog Number	Number of Rows	Block Width	Overall Length	Trim Length
<b>Fine Brass Scrub Brush</b>				
B-210	4 x 11	1 1/8"	3 1/4"	9/16"
<b>Stiff Brass Scrub Brush, paddle handle</b>				
B-61	9 x 10	2 5/8"	8 7/8"	5/8"
<b>Chip Removal Brush, carbon steel wire, loop handle</b>				
B-200		1 1/4"	5 1/2"	1 1/2"

### SHOE HANDLE



Catalog Number	Number of Rows	Block Width	Overall Length	Trim Length
<b>Carbon Steel Wire</b>				
B-44	4 x 16	1 1/8"	10 1/4"	1 1/8"
<b>Bronze Wire</b>				
B-844	4 x 16	1 1/8"	10 1/4"	1 1/8"
<b>Platers Fine Wire Brushes .006 Stainless Steel Wire</b>				
B-46S	4 x 16	1 1/8"	10"	1"
<b>.006 Brass Wire</b>				
B-46B	4 x 16		10 1/4"	1 1/8"
<b>Fine Brass Scrub Brush</b>				
B-52	2 x 17	1/2"	10"	1 1/4"

### TOOTH BRUSH STYLE



<b>Hand-Drawn-Wire Fill</b>					
Handle Material	Handle Width	Rows	.006 Stainless	.018 Nylon	.006 Brass
No. 93-A Laminated	3/8"	2	93A-S250	93A-N250	93A-B250
Hardwood Plywood	7/16"	3	93A-S375	93A-N375	93A-B375
	1/2"	4	93A-S500	93A-N500	93A-B500
<b>Staple Set in Poly Handle-7 1/4" OAL</b>			<b>Staple Set in Wood Handle</b>		
No. 93-AP	.006 Stainless Wire fill		No. 93-AW	.006SS Fill	
No. 93 APB	.006 Brass fill				
No. 93 APH	Horsehair fill				
No. 93-APP	.006 Phosphor Bronze fill				
No. 93 APN	.012 Nylon fill				

**NOTE:** Toothbrushes available in standard packages of 12 or 100.

Catalog Number	Block Size	Fill Material	Trim Length	Suggested Handle
Ruffneck-18	18"	Palmyra	4"	H-19

All Handles Sold Separately - Handles suggested are 5"

Catalog Number	Diameter	Length	Handle Finish	Handle End
H-250	1 <sup>5</sup> / <sub>16</sub> "	5'	clear lacquered	threaded metal tip
H-19	1 <sup>5</sup> / <sub>16</sub> "	5'	clear lacquered	threaded end

Catalog Number	Block Size	Fill Material	Trim Length	Handle Style
<b>Prolene Plastic Fill Scrub Brushes</b>				
622-S/H	5 x 5"	Prolene Plastic	2"	Short Handle
622-L/H	5 x 5"	Prolene Plastic	2"	Long Handle

Catalog Number	Block Size	Fill Material	Trim Length
King-8	8"	Horsehair blend	2 1/2"

Catalog No.	Size	Length	Width	Pack	Trim Style	Handle	Ferrule
601W	*1/2"	1 3/4"	5/16"	36	Square	Unfinished Wood	Bright Tin
	*3"	1 11/16"	5/16"	24			
	*4"	2"	1 1/16"	6			
601G	1/2"	1 1/2"	1/4"	36	Square	Unfinished Wood	Bright Tin
	1"	1 5/8"	5/16"	36			
	1 1/2"	1 5/8"	5/16"	36			
	2"	1 5/8"	5/16"	36			
	2 1/2"	1 3/4"	3/8"	12			
	3"	1 3/4"	3/8"	12			
	4"	1 3/4"	3/8"	12			

#1      3/8"      6" OAL  
 #2      1/2"      6" OAL

Finest horse hair fill, tinned metal handle. Nylon available.

Style 4843 / Size 1/4" Flat Camel Hair  
 Style 1091 / Size 1 Camel Hair

.003 Natural Nylon Fill  
 1/8" SS Stem with Delrin Handle  
 5130-2 90 Degree

## GARAGE & PATIO SWEEPING



Handles Available

## SCRUB BRUSHES



## COUNTER BRUSH



## NATURAL BRISTLE VARNISH BRUSHES



## ACID BRUSH, THROW-AWAY TYPE



## ECONOMY PAINT TOUCH-UP



## ELECTRONICS APPLICATOR BRUSH





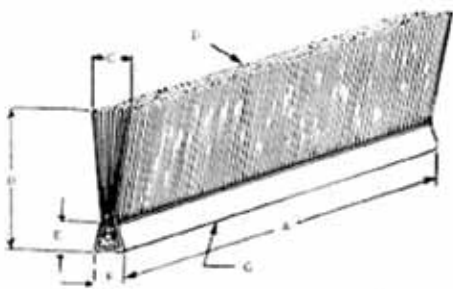
# STRIP BRUSHES

## STRIP BRUSHES

Catalog Number	Overall Trim	Fill Material	Length	Channel
S-15-06	1½"	.006 Crimped Steel Wire	72"	7
S-15-08	1½"	.008 Crimped Steel Wire	72"	7
S-15-10	1½"	.010 Crimped Steel Wire	72"	7
S-15-14	1½"	.014 Crimped Steel Wire	72"	7
S-25-06	2½"	.006 Crimped Steel Wire	72"	7
S-25-10	2½"	.010 Crimped Steel Wire	72"	7
S-25-14	2½"	.014 Crimped Steel Wire	72"	7
S-2-T	2"	Tampico	72"	7
S-3-T	3"	Tampico	72"	7
S-2-08N	2"	.008 Crimped Black Nylon	72"	7
S-2-10N	2"	.010 Crimped Black Nylon	72"	7
S-2-12N	2"	.012 Crimped Black Nylon	72"	7
S-2-14N	2"	.014 Crimped Black Nylon	72"	7
S-3-20N	3"	.022 Crimped Black Nylon	72"	7
S-1-HH	1"	Stiff Black Horsehair	72"	7
S-25-HH	2½"	Stiff Black Horsehair	72"	7
S-35-Poly Mix	3½"	.014 / .030 Polypropylene Mix	46½"	7
S-5-Poly	5"	.035 Crimped Polypropylene	60"	12

*Minimums may apply*

## CUSTOM STRIP BRUSH SPECIFICATIONS



**Please Provide All Dimensions**

Application: \_\_\_\_\_

Quantity: \_\_\_\_\_

A. Brush Length: \_\_\_\_\_ E. Backing Height: \_\_\_\_\_

B. Brush Overall Trim: \_\_\_\_\_ F. Backing Width: \_\_\_\_\_

C. Brush Face (if applicable): \_\_\_\_\_ G. Backing Material: \_\_\_\_\_

**D. Fill Material**

Type: \_\_\_\_\_ Diameter: \_\_\_\_\_ H. Backing Ends Deburred: \_\_\_\_\_  
(nylon, poly, wire, etc.) (Yes or No)

Color: \_\_\_\_\_ Style: \_\_\_\_\_  
(crimped or level)

*Strip Sizes Available*

**Approx. Formed Dimensions**

Channel Number	Unformed Strip Width	Width	Height
12	1½"	<sup>35</sup> / <sub>64</sub> "	<sup>9</sup> / <sub>16</sub> "
10	1¼"	<sup>7</sup> / <sub>16</sub> "	<sup>5</sup> / <sub>32</sub> "
8	1"	<sup>5</sup> / <sub>16</sub> "	<sup>3</sup> / <sub>8</sub> "
7	<sup>7</sup> / <sub>8</sub> "	<sup>5</sup> / <sub>16</sub> "	<sup>5</sup> / <sub>16</sub> "
5	<sup>5</sup> / <sub>8</sub> "	<sup>7</sup> / <sub>32</sub> "	<sup>1</sup> / <sub>4</sub> "
4	<sup>1</sup> / <sub>2</sub> "	<sup>3</sup> / <sub>16</sub> "	<sup>3</sup> / <sub>16</sub> "
3	<sup>3</sup> / <sub>8</sub> "	<sup>5</sup> / <sub>32</sub> "	<sup>5</sup> / <sub>32</sub> "

**Please Provide All Dimensions**

Application: \_\_\_\_\_  
 \_\_\_\_\_

Quantity: \_\_\_\_\_

A. Brush Face: \_\_\_\_\_ I. End Fixtures:  Steel  Aluminum

B. Brush O.D.: \_\_\_\_\_  Stainless  Other

C. Fill Material J. Set back (if required): \_\_\_\_\_

Type: \_\_\_\_\_ Diameter: \_\_\_\_\_ K. Method Brush is Fastened to Core:  
 (nylon, poly, wire, etc.)  Tangs  J-Bolts  Weld

Color: \_\_\_\_\_ Style: \_\_\_\_\_  Other  
 (crimped or level)

L. Operating RPM: \_\_\_\_\_

D. Coil Spacing M. Wet or Dry Application: \_\_\_\_\_

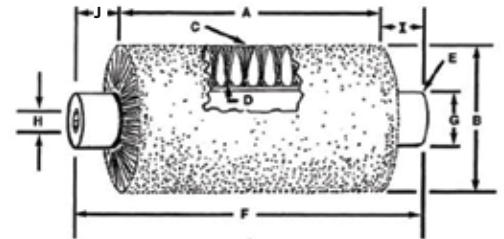
E. Core Material:  Steel  Aluminum N. Additional Information: \_\_\_\_\_  
 Stainless  Other \_\_\_\_\_

F. Core Length: \_\_\_\_\_

G. Core O.D.: \_\_\_\_\_

H. Bore & Key Size: \_\_\_\_\_

**RADIAL COIL BRUSHES**



Application: \_\_\_\_\_  
 \_\_\_\_\_

Quantity: \_\_\_\_\_

A. Brush Face: \_\_\_\_\_ C. Brush I.D.: \_\_\_\_\_

B. Brush O.D.: \_\_\_\_\_ G. Operating RPM: \_\_\_\_\_

E. Fill Material H. Wet or Dry Application: \_\_\_\_\_

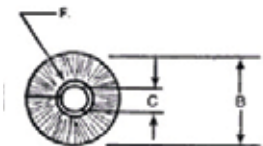
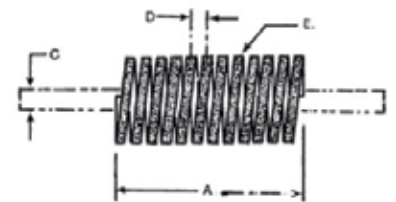
Type: \_\_\_\_\_ Diameter: \_\_\_\_\_ I. Additional Information: \_\_\_\_\_  
 (nylon, poly, wire, etc.)

Color: \_\_\_\_\_ Style: \_\_\_\_\_  
 (crimped or level)

D. Coil Spacing: \_\_\_\_\_

F. Backing Strip Size & Material: \_\_\_\_\_  
 \_\_\_\_\_

**SPIRAL WOUND BRUSH - COIL ONLY**



# POWER BRUSH ENGINEERING GUIDE



## Horsepower Required To Drive Brushes

### Four Common Factors Governing the Horsepower Necessary to Drive a Power Brush

1. Brushing pressure required.
2. Resistance between work surface and brush (trim length).
3. Speed of the brush.
4. Brush face width.

### Horsepower Approximation Guide

(Based upon the medium brushing action for 1" brush face)

Brush Dia.	Motor Size	RPM
4"	1/4 hp	3450
6"	1/2 hp	3450
8"	3/4 hp	3450
10"	1 hp	1750
12"	1 hp	1750
15"	1½ hp	1750

Wider face brushes require additional horsepower dependent upon the relative brush load. Long trim brushes can usually be operated with less horsepower than short trim brushes.

### Recommended Surface Speeds for Brushing Applications

Application	Surface Ft. / Minute
Removing Burrs	5500 to 7500
Removing Scale	7500 to 10000
Cleaning Welds	7200 to 9400
Edging Blending	4700 to 7500
Cleaning DRY	4000 to 5000
Cleaning WET	1900 to 4000
Surface Polishing	6400 to 8000
Surface Blending	8000 to 10000

## Brushing Action

There are many variables in Power Brushing conditions. In many cases, one or more Power Brushes may accomplish the same results; however, if one brush does not accomplish the desired results, follow the suggestions below:

### Desired Change in Results

+ Suggested Change in Brush

### Faster Action

- + Run brush faster
- + Use heavier wire or filament
- + Use brush with shorter trim length
- + Use larger diameter brush

### Finer Finish

- + Use finer wire or filament
- + Try tampico or abrasive nylon filament brush

### Reach Irregular Surface Area

- + Use Brush with longer trim length for greater flexibility

### Longer Life

- + Use finer wire and longer trim

### Remove Burr Instead Of Roughing or Preening It

- + Increase brush speed
- + Use brush with shorter trim
- + Check brushing pressure to determine if tips are cutting not wiping.

**Note:** The speed at which the brush rotates is an extremely important factor. (See Table of Surface Speeds).

### Portable Tools

The maximum recommended diameter brush to use with electric or air portable tools is 6".



### Table of Surface Speeds (Peripheral Speed in Ft./Min.)

RPM	1" Dia	2" Dia	3" Dia	4" Dia	6" Dia	7" Dia	8" Dia	10" Dia	12" Dia	14" Dia	15" Dia
900	236	471	707	942	1414	1649	1885	2356	2827	3299	3534
1150	301	602	903	1204	1806	2107	2409	3011	3613	4215	4516
1200	314	628	942	1257	1885	2199	2513	3142	3770	4398	4712
1500	393	785	1178	1571	2356	2749	3142	3927	4712	5498	5891
1750	458	916	1374	1833	2749	3207	3665	4582	5498	6414	6872
2000	524	1047	1571	2094	3142	3665	4189	5236	6283	7330	7854
2400	628	1257	1885	2513	3770	4398	5027	6283	7540	8796	9425
2800	733	1466	2199	2932	4398	5131	5864	7330	8796	10263	10996
3000	785	1571	2356	3142	4712	5498	6283	7854	9425	10996	11781
3200	838	1676	2513	3351	5027	5864	6702	8378	10053	11729	12566
3400	890	1780	2670	3560	5341	6231	7121	8901	10681	12462	13352
3750	982	1964	2945	3927	5891	6872	7854	9818	11781	13745	
4000	1047	2094	3142	4189	6283	7330	8378	10472	12566		
4500	1178	2536	3534	4712	7069	8247	9425	11781	14137		
5000	1309	2618	3927	5236	7854	9163	10472	13090			
5400	1414	2827	4241	5655	8482	9896	11310				
6000	1571	3142	4712	6283	9425	10996	12566				



### Power Brush Safety Requirements

**Warning** In normal power brushing operations, the material being removed, such as burrs, scale, dirt, weld slag, or other residue, will fly off the brush with considerable force along with brush filaments which break off due to fatigue.

**The potential for serious injury exists** for both the brush operator and others in the work area (possible 50 or more feet from the brush). To protect against this hazard, **wear safety goggles or full face shields worn over safety glasses with side shields, along with protective clothing.**

You must follow all operator and safety instructions, as well as all common safety practices which reduce the likelihood of physical injury, or reduce its severity.

### Summary of Power Brush Safety Requirements

**Safety Goggles** Safety goggles or full face shields worn over safety glasses with side shields **must be worn by ALL operators and others in the area** of power brush operations. Comply with the requirements of ANS Z87.1-1979 "Occupational Eye and Face Protection"

**Guards** Keep all machine guards in place.

**Speeds** Observe all speed restrictions indicated on brushes, containers, labels, or printed in pertinent literature. "MSFS" means Maximum Safe Free Speed (RPM) - spinning free with no work applied. For reasons of safety "MSFS" should not be exceeded under any circumstances.

**Safety Standard** Comply with the Safety Standards of the Industrial Division of the American Brush Manufacturers Association and the American National Standards Institute ANSI B165.1 - 1985 - Safety Requirements - Power Brushes and ANSI B165.2 - 1982 "Safety Requirements - Power Brushes - Wood, Plastic, or Composition Hubs."

**Protective Equipment** Appropriate protective clothing and equipment must be used where there is a possibility of injury that can be prevented by such clothing or equipment.

**\*Warning!** Failure to observe safety precautions may result in injury.

### Brush Usage Recommendations

**Pressure** Avoid excessive pressure when using a power brush. Excessive pressure causes over-bending of the filaments and heat build up resulting in filament breakage, rapid dulling, and reduced brush life. Instead of greater pressure on a brush, it is suggested that you try:

1) a brush with a more aggressive cutting action (increased wire size decrease

filament length, change to a different brush type, i.e., knot type instead of crimped wire type), or

2) higher speed (increased R.P.M., increased brush diameter.)

**\*Important Note:** Never exceed the recommended Maximum Safe Free Speed R.P.M. (MSFS) rating of the brush.

### Brushing Problems Do Not Allow Unsafe Conditions To Continue.

Occasionally, due to worn bearings, a bent spindle, an unusual application, operator abuse, or inappropriate use, a brush may fail. A brush which is not received in acceptable condition for trouble-free operation may also fail. Do not use or continue to use a failed brush or one which is functioning improperly (i.e., throwing filaments, out-of balance etc.) as this increases the possibility for further brush failure and hazard of injury. The cause of the failure should be evaluated and corrected.

This information is based on the collective experience of the ABMA Industrial Division members and provided solely as a public service for the guidance of the users of the members' products. These recommendations are not necessarily complete with respect to any particular application and common sense safety considerations should be adhered to generally. Any applicable federal, state, local law or regulation, must be strictly adhered to, and is controlling over any recommendation contained herein.

### Safety Instructions for Flex-Hone® and Twisted-In-Wire Brushes

The Flex-Hones® and Twisted-In-Wire brushes, used under power, shall be securely held in a collet, chuck or similar holding device.

The operator shall secure the unit being honed or brushed and position all guards before starting the tool. The arrangement of the workplace shall ensure rotation of the brush on the true centerline to avoid deflection that may instantly multiply to destructive bending.

The shank of a Twisted-In-Wire brush and/or Flex-Hone®, because of its basic construction, is not inherently as strong as the shank on most other brushes.

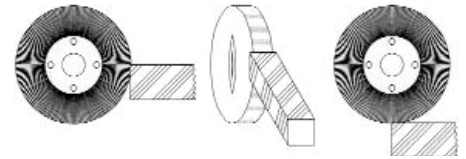
Therefore, it is even more important that the tool length be no longer than necessary to perform the work, and that other conditions of use avoid load applications and speed of rotation that will cause the shank to deflect, and therefore bend, instantly resulting in total destruction of the brush and creating an unsafe condition for the operator.

## SAFETY FIRST

Failure to observe any requirements shown in the safety section will create safety hazards and can cause injury.

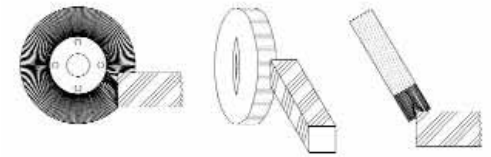
### Correct

Tips doing the work



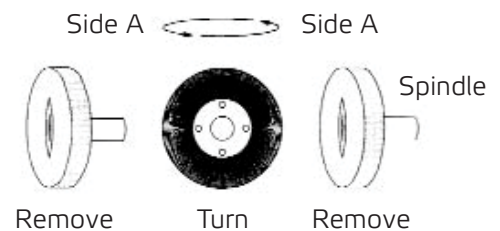
### Incorrect

Excessive pressure can cause wire breakage



### Self-Sharpening

When using wire wheel brushes, periodically reverse the direction of rotation to take advantage of the self-sharpening action that will result. This may be accomplished by removing the brush from the spindle and turning it side for side, and remounting securely.



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