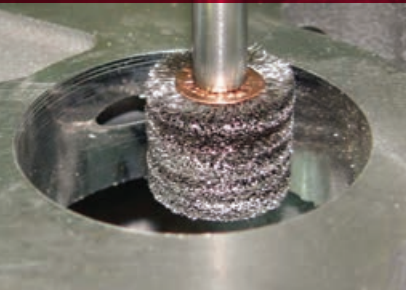


# BORE-RX™ CROSSHOLE DEBURRING BRUSHES



Deburring intersecting oil passages in an engine block.

**MADE IN  
USA**

Designed for automated use in CNC machining centers and dedicated equipment. They are densely filled for high aggression and long tool life and feature a 3/8" diameter steel stem with a flat for use in a collet or end-mill holder.

Bore-Rx brushes are ideal tools for removing burrs from internal edges. Since they can eliminate manual deburring operations, these internal brushing tools help to improve part-to-part consistency and reduce direct labor costs. Bore-Rx brushes are available in sizes ranging from 3/4" to 4" in diameter, and they are designed to be interpolated within bore sizes that are larger than the brush diameter.

## Operating Parameters For Wire Bore-Rx Brushes

Brush Diameter	Recommended RPM	Recommended Feed Rate
5/8" - 7/8"	8,000	20"/min
1" - 1-1/2"	8,000	20"/min
2" - 2-1/2"	6,000	20"/min
3" - 4"	3,000	20"/min

## Tool Paths for Crosshole Deburring

An effective tool path for most crosshole deburring jobs is circular interpolation using the following guidelines to determine diameter of interpolation. The interpolation should be performed at a depth where the center of the brush face is at the center of the intersecting hole.

- Diameter of Interpolation = Hole Diameter - Brush Diameter



**BORE-RX BRUSHING TOOLS - Crimped wire fill** - Feature dense wire fill for aggressive deburring action on ductile metals and other hard-to-deburr materials.



17205



17218

Diameter	Wire Size	Face Width	Overall Length	Max. RPM	Standard Pack	Item Number
						Steel*
3/4"	.005	3/8"	4-3/8"	8,000	1	17202
		3/4"	4-3/4"			17203
7/8"	.006	3/4"	4-3/4"	8,000	1	17205
1"	.006	3/4"	5"	8,000	1	17207
1-1/4"	.006	3/4"	4-3/4"	8,000	1	17209
1-1/2"	.006	1"	5"	8,000	1	17211
2"	.006	1"	4-1/4"	6,000	1	17214
2-1/2"	.008	1"	4-3/4"	6,000	1	17216
3"	.008	1"	5-1/4"	6,000	1	17218
4"	.0118	1"	6-1/4"	6,000	1	17219

\* Stainless Steel fill is available by special order.

Note: All Bore-Rx brush stems have a 2" long flat for use in end mill holders. Alternatively, they can be mounted in 3/8" collets. Bore-Rx extension holder is available. Contact Application Engineering at 888-299-APPS (2777).

## CUSTOMIZABLE CROSSHOLE DEBURRING SOLUTIONS

### Replacement Bore-Rx Brush Heads and Reusable Bore-Rx Arbors

In high production applications, reusable arbors reduce manufacturing costs by allowing the use of inexpensive brush head replacements. Brush heads are made-to-order in diameters ranging from 3/4" to 1-1/2" with face widths of 1/4" to 1". They are available on 3/16" and 1/4" pins. The pin diameter is based on the application and determines brush density. Contact Application Engineering at 888-299-APPS (2777) for more information.



Replacement Head



Reusable Extension 03991



Reusable Arbor