

FLAT SURFACE DEBURRING PRODUCTS

**MADE IN
USA**

DISC BRUSHES

Manufactured using a tufted filament configuration and longer trim length for increased aggression, greater conformability and longer product life in comparison to monofilament disc brushes, which feature a distribution of short individual bristles.

Burr-Rx® disc brushes feature Weiler's advanced black ceramic grain filament, which delivers up to a 400% greater edge cutting action in comparison to traditional silicon carbide and aluminum oxide filaments for the fastest, most aggressive deburring action for minimum cycle times and maximum life.

All Burr-Rx disc brushes are manufactured using a new process that results in a very consistent, flat brush face in comparison to traditional construction, which utilizes a molded backing. The high dimensional precision of these tools means that the brushes are suitable for the most critical applications and perform more consistently from first part to last. In addition, the machined polymer backings are designed to mount directly onto a standard shell mill holder for convenient use in CNC machining centers.

APPLICATIONS

- Deburring flat surfaces on machined components
- Deburring face-milled castings or forgings
- Improving texture characteristics on machined or ground surfaces
- Blending tool marks after machining or grinding

DISC BRUSHES

0.075" - 0.100" DEPTH OF INTERFERENCE

OPERATING SPEEDS - DISC BRUSHES



Diameter	RPM
1-3/4" & 2"	1,750 - 2,000
3"-4"	1,500 - 1,750
5" - 6"	1,250 - 1,500
8"	800 - 1,000
10"	700 - 800
12"	600 - 700
14"	500 - 600

FEED RATE RECOMMENDATIONS

Feed rate is determined by the amount of deburring, edge radiusing or surface finishing required, and the type of material that is being processed. It is generally application specific. Slower feeds result in a more aggressive brushing action. Based on the brushing action desired for a specific application, the feed rate can be increased or decreased.

Material	SiC and AO Grain Feed Rate	Burr-Rx Grain Feed Rate
Non-Ferrous	50 in./min.	80 in./min.
Cast Iron	30 in./min.	60 in./min.
Mild Steel and Ductile Iron	25 in./min.	50 in./min.
Stainless and Alloy Steels	15 in./min.	30 in./min.
Titanium and High Nickel Alloys	10 in./min.	30 in./min.

BURR-RX SHELL MILL HOLDER DISC BRUSHES - Crimped Black Ceramic Filament

Compatible with 3" shell mill holders.

Diameter	Filament Dia./Grit	Arbor Hole	Trim Length	Max. RPM	Standard Pack	Item Number
Round Filament						
4"	.026/120	1-1/4"	1-1/2"	2,500	1	86112
	.043/120					86113
	.043/120					86204*
	.055/80					86114*
6"	.026/120	1-1/4"	1-1/2"	2,500	1	86115
	.043/120					86116
	.055/80					86117*
8"	.026/120	1-1/4"	1-1/2"	2,000	1	86141
	.043/120					86142
	.055/80					86143*
10"	.026/120	1-1/4"	1-1/2"	2,000	1	86125
	.043/120					86121
	.055/80					86122*
Rectangular Filament						
4"	80	1-1/4"	1-1/2"	2,500	1	86167*
6"	80	1-1/4"	1-1/2"	2,500	1	86198*
8"	80	1-1/4"	1-1/2"	2,500	1	86199*

* Maximum Density



Deburring a bearing cage in a CNC machining center.



Disc brush shown with shell mill holder



86112



86143