

## A CLOSE BRUSH WITH PERFECTION

ELIMINATE THE NEED FOR COSTLY AND INCONSISTENT HAND DEBURRING APPLICATIONS.

Norton Blaze nylon abrasive brushes are precision-engineered with the highest quality ceramic grains for those markets with the strictest requirements – for easy integration into today's automated machinery, CNC machining centers, transfer lines, robotic cells, and other highly-specialized machinery, as well as hand tools.

### Markets

- Aerospace/aircraft
- Automotive
- Construction/utility products
- Medical
- Metal finishing
- Woodworking

### Brush Configurations

- Radial Wheel Brushes
- Narrow Face Wheel Brushes
- Disc Brushes
- End Brushes
- Twisted Brushes

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

# THE INDUSTRY'S NEW SURFACE REFINEMENT WORKHORSES:

Norton Blaze sharp, penetrating ceramic alumina nylon brushes are engineered specifically for jobs requiring controllable surface refinement and uniform finishing, for a consistent performance – brush after brush.



## NORTON BLAZE NYLON BRUSH PERFORMANCE BENEFITS

(vs. aluminum oxide, silicon carbide, and competitive ceramic grain products)

- 20% longer brush life with lighter work pressure
- 20-30% faster cut
- Reduced cycle time optimizes throughput
- Controlled surface abrasion
- Excellent balance for optimal performance
- Easily learned and safely used by end-users of various skill sets
- Customizable wheel designs

20%  
LONGER LIFE

20-30%  
FASTER CUT

## FEATURES & BENEFITS

### Self-Sharpening Ceramic Alumina Abrasive

Increased cutting:

- Norton Blaze elongated-shaped ceramic grain possesses extreme point endurance and improved micro-fracturing properties over alternative ceramic products
- Cutting points are increased as the grain is exposed and cut equally when pressure is applied to the side or tip of the filament

Consistent performance:

- Uniform distribution of grain throughout the filaments allows cutting and finishing performance levels to remain consistent throughout the life of the brush – making Norton Blaze abrasive brushes ideal for automated applications

### Strong, Conformable Filaments

Long life:

- Heat and stress-resistant filaments prolong brush life and allow for superior conformability to irregular surface shapes

Precision Shaping:

- The ceramic grain impregnated filaments act as a flexible file to deburr and radius edge profiles with precision, without gouging or affecting the overall geometry of a part

Improved finishing:

- The filaments bend at various angles to fit contours, creating a less prominent, more uniform surface finish in comparison to wire wheels or coated abrasive products

Versatility:

- Brush conformability allows usage on variety of complex part shapes without the need for ultra-precise programming and fixturing that is required with other deburring and finishing tools

## TECHNICAL INFO

### Filament Diameters

- All things being equal, a thicker filament is normally more aggressive

### Trim Length

- Short Trim: creates a stiffer brush with faster cut rate, shorter cycle times, increases performance consistency, and life; recommended for applications that do not require a high degree of brush conformability
- Long Trim: offers increased flexibility for maximum conformity on irregular surfaces



## WHY BUY NORTON BLAZE NYLON BRUSHES

Norton Blaze brushes meet the rigorous needs of both internal and external part finishing within such precise industries as aerospace and aircraft. Our brushes round sharp edges, remove metal flakes, and condition surfaces to eliminate any potential loose metal that can contaminate or compromise your finished part or operation.

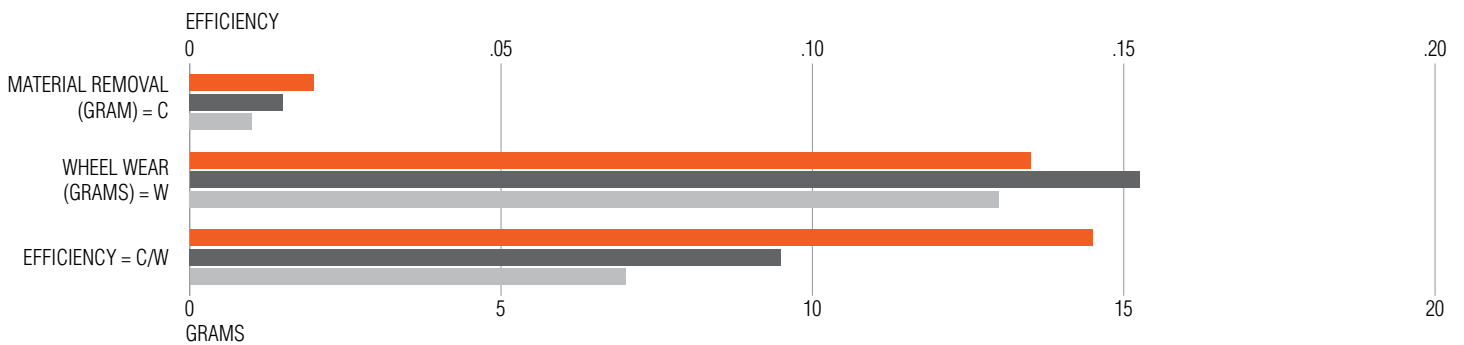
Your Norton representative will help meet your exact custom design specifications including filament type, density, diameter, and length.

## BLAZE BRUSH PERFORMANCE

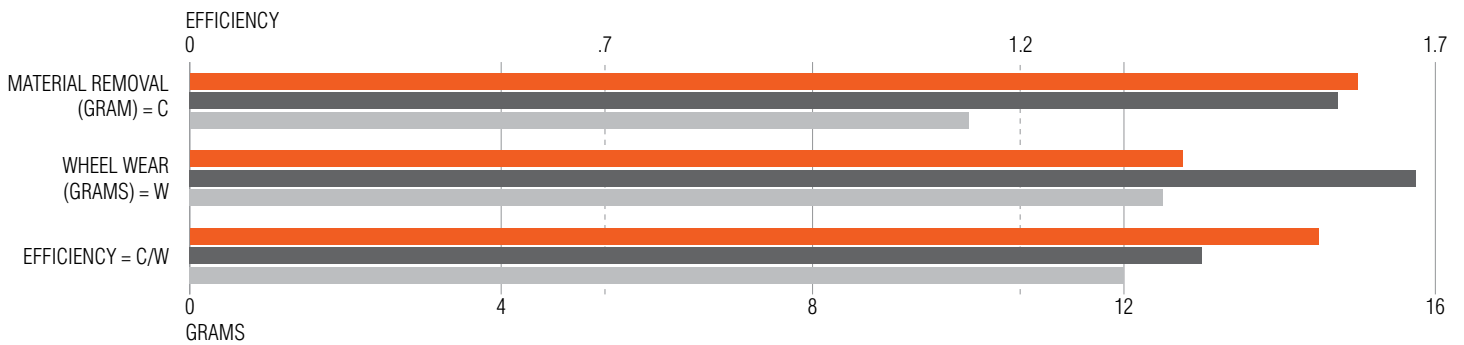
Tests were conducted using 8" diameter radial wheels over six, 15 minute cycles.

■ Norton Blaze   
 ■ Competitor 1   
 ■ Competitor 2

Performance on 718 Inconel



Performance on 7075 Aluminum



Norton brushes removed the most material, with the lowest wheel wear, for the greatest grinding efficiency.

# RADIAL WHEEL BRUSHES



## Applications

- Final finishing and sharpening precision parts during production
- Edge radiusing
- Cleaning, finishing, and polishing surfaces – including ferrous and nonferrous materials, and powdered and soft metals such as aluminum and brass

## Wheel Brush Operating Parameters

- Wheel brush life and performance is optimized when penetration rates are from .075" - .100".
- Running the wheel at lower RPMs and with lighter pressure generates less heat and requires less power thereby extending the life of the wheel. Operating speeds should be 50% - 70% of the maximum RPM.

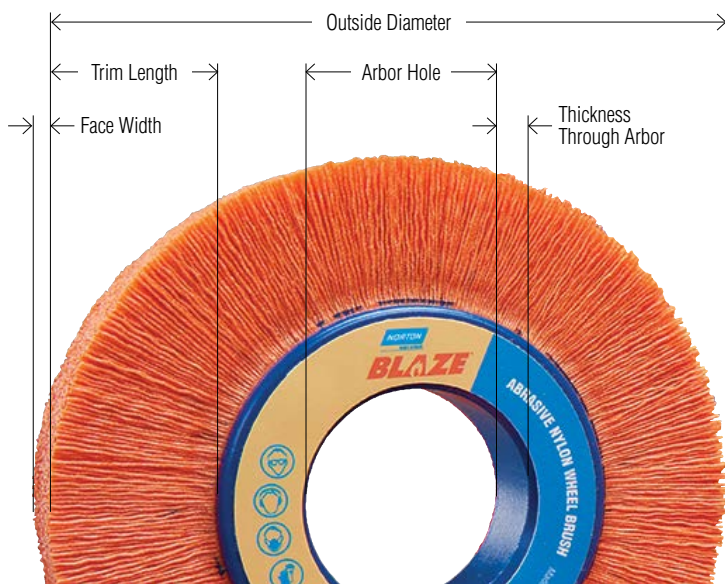
## Availability

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	FACE WIDTH	MAX. RPM	PART #
<b>Radial Wheel Brushes with Copper Center Arbor Hole</b>							
1-1/2"	120	0.028"	1/2"	1/4"	3/16"	10,000	77696090185
2"	80	0.040"	1/2"	3/8"	1/4"	10,000	77696090188
	120	0.028"	1/2"	3/8"	1/4"	10,000	77696090186
2-1/2"	80	0.040"	5/8"	5/8"	5/16"	10,000	77696090191
	120	0.028"	5/8"	3/8"	5/16"	10,000	77696090189
3"	80	0.040"	1/2"	7/8"	3/8"	10,000	77696090195
	120	0.028"	1/2"	5/8"	3/8"	10,000	77696090192
	120	0.040"	1/2"	7/8"	3/8"	10,000	77696090194

Std. Pkg. = 10 brushes/box.

SHANK DIAMETER	ARBOR HOLE	FOR ARBOR WIDTH UP TO	OVERALL LENGTH	PART #
<b>Air Motor Shanks for Copper Center Wheels</b>				
1/4"	1/2"	3/8	1-7/8"	77696090196
1/4"	5/8"	3/8	1-7/8"	77696090197

These shanks permit brushes to be mounted onto air motors and flexible shafts. Std Pkg = 1.



BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	TRIM	FACE WIDTH	MAX. RPM	PART #
<b>Radial Wheel Brushes with Standard Arbor Hole</b>								
4"	80	0.040"	5/8"	1"	Short	1/2"	10,000	77696085001
	120	0.028"	5/8"	1"	Short	1/2"	10,000	77696085003
	120	0.040"	5/8"	1"	Short	1/2"	10,000	77696085004
6"	80	0.040"	2"	1-1/4"	Short	1"	3,600	77696085007
	120	0.028"	2"	1-1/4"	Short	1"	3,600	77696085010
	120	0.040"	2"	1-1/4"	Short	1"	3,600	77696085011
8"	80	0.040"	2"	1-1/4"	Short	1"	3,600	77696085014
	120	0.028"	2"	1-1/4"	Short	1"	3,600	77696085017
	120	0.040"	2"	1-1/4"	Short	1"	3,600	77696085018
	80	0.040"	2"	2-1/4"	Long	1"	3,600	77696085021
	120	0.028"	2"	2-1/4"	Long	1"	3,600	77696090277
	120	0.040"	2"	2-1/4"	Long	1"	3,600	77696085024
10"	80	0.040"	2"	1-1/2"	Short	1"	3,600	77696085027
	120	0.028"	2"	1-1/2"	Short	1"	3,600	77696085030
	120	0.040"	2"	1-1/2"	Short	1"	3,600	77696085031
	80	0.040"	2"	3-1/4"	Long	1"	3,600	77696085034
	120	0.028"	2"	3-1/4"	Long	1"	3,600	77696090278
	120	0.040"	2"	3-1/4"	Long	1"	3,600	77696085037
12"	80	0.040"	4-1/4"	1-1/2"	Short	1"	1,800	77696085040
	120	0.028"	4-1/4"	1-1/2"	Short	1"	1,800	77696085043
	120	0.040"	4-1/4"	1-1/2"	Short	1"	1,800	77696085044
	80	0.040"	4-1/4"	3"	Long	1"	1,800	77696085047
	120	0.028"	4-1/4"	3"	Long	1"	1,800	77696090279
	120	0.040"	4-1/4"	3"	Long	1"	1,800	77696085050
14"	80	0.040"	5-1/4"	1-1/2"	Short	1"	1,800	77696085053
	120	0.028"	5-1/4"	1-1/2"	Short	1"	1,800	77696085056
	120	0.040"	5-1/4"	1-1/2"	Short	1"	1,800	77696085057
	80	0.040"	5-1/4"	3-1/2"	Long	1"	1,800	77696085060
	120	0.028"	5-1/4"	3-1/2"	Long	1"	1,800	77696085063
	120	0.040"	5-1/4"	3-1/2"	Long	1"	1,800	77696090280

Std. Pkg.: <= 4" diameter brushes = 5 brushes/box. >6" diameter brushes = 2 brushes/box.

ADAPTOR FITS ARBOR HOLE	ADAPTOR ID	KEYWAY SIZE	PART #
<b>Wheel Brush Adaptors</b>			
4.25"	2"	1/2" x 1/4"	77696090198
5.25"	2"	1/2" x 1/4"	77696090199
2"	.5"	-	77696090200
2"	.625"	-	77696090201
2"	.750"	-	77696090202
2"	.875"	-	77696090203
2"	1"	-	77696090204
2"	1.25"	-	77696090205
2"	1.5"	-	77696090206

Metal adapters are used for mounting wheel brushes into smaller shafts. Sold in pairs.

# NARROW FACE WHEEL BRUSHES



## Applications

- Their small profile makes these brushes ideal for cleaning, polishing, and deburring recessed areas such as small openings, slots, and machined grooves

## Narrow Face Wheel Brush Operating Parameters

- Wheel brush life and performance are optimized when penetration rates are from .075" - .100".
- Running the wheel at lower RPMs and with lighter pressure generates less heat and requires less power thereby extending the life of the wheel. Operating speeds should be 50% - 70% of the maximum RPM.

## Availability

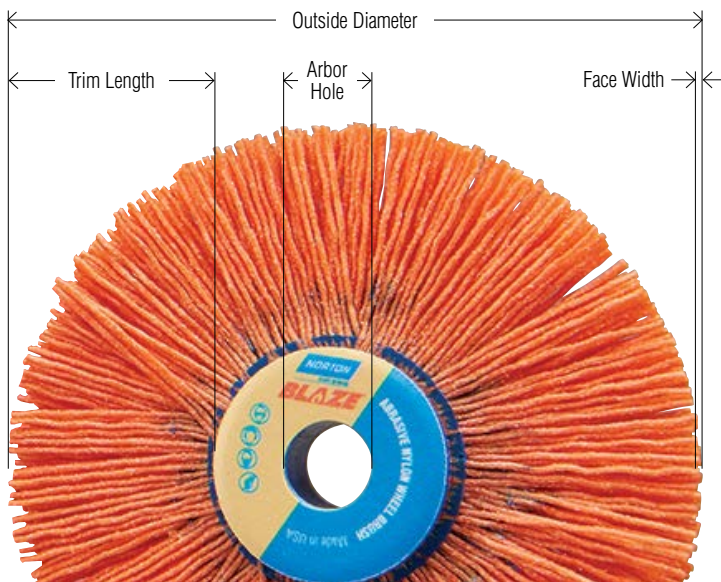
BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	FACE WIDTH	MAX. RPM	PART #
<b>Narrow Face Wheel Brushes with Arbor Hole</b>							
3"	80	0.040"	3/8"	1"	1/8"	10,000	77696085069
	120	0.028"	3/8"	1"	1/8"	10,000	77696085070
	120	0.040"	3/8"	1"	1/8"	10,000	77696085071
	80	0.040"	3/8"	1"	1/4"	10,000	77696085066
	120	0.028"	3/8"	1"	1/4"	10,000	77696085067
4"	120	0.040"	3/8"	1"	1/4"	10,000	77696085068
	80	0.040"	5/8"	1"	1/4"	10,000	77696085075
	120	0.028"	5/8"	1"	1/4"	10,000	77696085076
	120	0.040"	5/8"	1"	1/4"	10,000	77696085077
	80	0.040"	5/8"	1"	1/2"	10,000	77696085072
120	0.028"	5/8"	1"	1/2"	10,000	77696085073	
	0.040"	5/8"	1"	1/2"	10,000	77696085074	

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	FACE WIDTH	MAX. RPM	PART #
<b>Narrow Face Wheel Brushes with Arbor Hole (continued)</b>							
5"	80	0.040"	5/8"	1-1/2"	1/4"	6,000	77696085081
	120	0.028"	5/8"	1-1/2"	1/4"	6,000	77696085082
	120	0.040"	5/8"	1-1/2"	1/4"	6,000	77696085083
	80	0.040"	5/8"	1-1/2"	1/2"	6,000	77696085078
	120	0.028"	5/8"	1-1/2"	1/2"	6,000	77696085079
	120	0.040"	5/8"	1-1/2"	1/2"	6,000	77696085080
6"	80	0.040"	5/8"	2"	1/4"	6,000	77696085087
	120	0.028"	5/8"	2"	1/4"	6,000	77696085088
	120	0.040"	5/8"	2"	1/4"	6,000	77696085089
	80	0.040"	5/8"	2"	1/2"	6,000	77696085084
	120	0.028"	5/8"	2"	1/2"	6,000	77696085085
	120	0.040"	5/8"	2"	1/2"	6,000	77696085086

Std. Pkg. = 5 brushes/box.

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	SHANK DIAMETER	TRIM LENGTH	FACE WIDTH	MAX. RPM	PART #
<b>Narrow Face Wheel Brushes with Stem-Mount</b>							
3"	80	0.040"	1/4"	1"	1/8"	10,000	77696085093
	120	0.028"	1/4"	1"	1/8"	10,000	77696085094
	120	0.040"	1/4"	1"	1/8"	10,000	77696085095
	80	0.040"	1/4"	1"	1/4"	10,000	77696085090
	120	0.028"	1/4"	1"	1/4"	10,000	77696085091
4"	120	0.040"	1/4"	1"	1/4"	10,000	77696085092
	80	0.040"	1/4"	1"	1/4"	10,000	77696085099
	120	0.028"	1/4"	1"	1/4"	10,000	77696085100
	120	0.040"	1/4"	1"	1/4"	10,000	77696085101
	80	0.040"	1/4"	1"	1/2"	10,000	77696085096
120	0.028"	1/4"	1"	1/2"	10,000	77696085097	
	0.040"	1/4"	1"	1/2"	10,000	77696085098	
	80	0.040"	1/4"	1-1/2"	1/4"	4,500	77696085105
	120	0.028"	1/4"	1-1/2"	1/4"	4,500	77696085106
	120	0.040"	1/4"	1-1/2"	1/4"	4,500	77696085107
5"	80	0.040"	1/4"	1-1/2"	1/2"	4,500	77696085102
	120	0.028"	1/4"	1-1/2"	1/2"	4,500	77696085103
	120	0.040"	1/4"	1-1/2"	1/2"	4,500	77696085104
	80	0.040"	1/4"	2"	1/4"	4,500	77696085111
	120	0.028"	1/4"	2"	1/4"	4,500	77696085112
6"	120	0.040"	1/4"	2"	1/4"	4,500	77696085113
	80	0.040"	1/4"	2"	1/2"	4,500	77696085108
	120	0.028"	1/4"	2"	1/2"	4,500	77696085109
	120	0.040"	1/4"	2"	1/2"	4,500	77696085110

Std. Pkg. = 2 brushes/box.



# DISC BRUSHES



## Applications

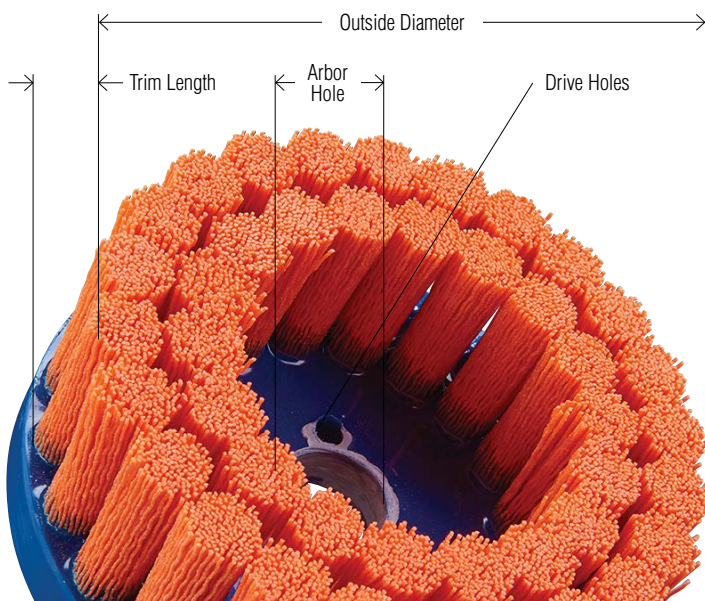
- Deburring and removing burrs and sharp edges
- Edge radiusing
- Removing rust, scale, and other surface contaminants, scrubbing and cleaning
- Surface prepping before painting, plating, and coating
- Blending tool marks
- Applying decorative finishes/texturing surfaces
- Finishing and polishing

## Key Workpieces:

- Tubing
- Machined flat surfaces
- Metal and wood sheets
- Steel and cast aluminum parts
- Concrete molds
- Aerospace/automotive: gears, engine heads/blocks, blades, manifolds, wheel rims

## Disc Brush Operating Parameters

- To optimize the performance of a disc brush, depth of penetration between the brush face and the work surface is recommended to be .075" - .100". Adjustments should be made to achieve the most efficient operational conditions.



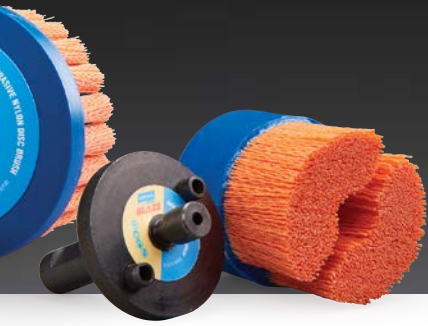
## Disc Brush Filament Patterns

- Tufted: provides flexibility in the filament, allowing the brush to conform to the part surface
- Tear Drop: allows brush to run cooler in dry applications, coolant to flow in wet applications, and increased brush aggression

## Availability

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	FILAMENT PATTERN	MAX. RPM	PART #
<b>Disc Brushes with Arbor Holes</b>							
3"	80	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085114
	120	0.028"	7/8"	1-1/2"	Tear Drop	2,500	77696085117
	120	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085118
4"	80	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085121
	120	0.028"	7/8"	1-1/2"	Tear Drop	2,500	77696085124
	120	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085125
5"	80	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085128
	120	0.028"	7/8"	1-1/2"	Tear Drop	2,500	77696085131
	120	0.040"	7/8"	1-1/2"	Tear Drop	2,500	77696085132
6"	80	0.040"	7/8"	1-1/2"	Tear Drop	2,000	77696085135
	120	0.028"	7/8"	1-1/2"	Tear Drop	2,000	77696085138
	120	0.040"	7/8"	1-1/2"	Tear Drop	2,000	77696085139
8"	80	0.040"	7/8"	1-1/2"	Tear Drop	2,000	77696085142
	120	0.028"	7/8"	1-1/2"	Tear Drop	2,000	77696085145
	120	0.040"	7/8"	1-1/2"	Tear Drop	2,000	77696085146
10"	80	0.040"	7/8"	1-1/2"	Tear Drop	1,750	77696085149
	120	0.028"	7/8"	1-1/2"	Tear Drop	1,750	77696085152
	120	0.040"	7/8"	1-1/2"	Tear Drop	1,750	77696085153
12"	80	0.040"	7/8"	1-1/2"	Tear Drop	1,750	77696085156
	120	0.028"	7/8"	1-1/2"	Tear Drop	1,750	77696085159
	120	0.040"	7/8"	1-1/2"	Tear Drop	1,750	77696085160
3"	80	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085163
	120	0.028"	7/8"	1-1/2"	Tufted	2,500	77696085166
	120	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085170
4"	80	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085173
	120	0.028"	7/8"	1-1/2"	Tufted	2,500	77696085174
	120	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085177
5"	80	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085177
	120	0.028"	7/8"	1-1/2"	Tufted	2,500	77696085180
	120	0.040"	7/8"	1-1/2"	Tufted	2,500	77696085181
6"	80	0.040"	7/8"	1-1/2"	Tufted	2,000	77696085184
	120	0.028"	7/8"	1-1/2"	Tufted	2,000	77696085187
	120	0.040"	7/8"	1-1/2"	Tufted	2,000	77696085188
8"	80	0.040"	7/8"	1-1/2"	Tufted	2,000	77696085191
	120	0.028"	7/8"	1-1/2"	Tufted	2,000	77696085194
	120	0.040"	7/8"	1-1/2"	Tufted	2,000	77696085195
10"	80	0.040"	7/8"	1-1/2"	Tufted	1,750	77696085198
	120	0.028"	7/8"	1-1/2"	Tufted	1,750	77696085201
	120	0.040"	7/8"	1-1/2"	Tufted	1,750	77696085202
12"	80	0.040"	7/8"	1-1/2"	Tufted	1,750	77696085205
	120	0.028"	7/8"	1-1/2"	Tufted	1,750	77696085208
	120	0.040"	7/8"	1-1/2"	Tufted	1,750	77696085209

Std. Pkg. = 1 brush/box.



# STEM-MOUNTED END BRUSHES



BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	MAX. RPM	PART #
<b>Mini Disc Brushes with Arbor Hole</b>						
2"	80	0.040"	3/8"	1-1/4"	4,500	77696085229
	120	0.028"	3/8"	1-1/4"	4,500	77696085228
	120	0.040"	3/8"	1-1/4"	4,500	77696085230
3"	80	0.040"	3/8"	1-1/4"	4,500	77696085234
	120	0.028"	3/8"	1-1/4"	4,500	77696085233
	120	0.040"	3/8"	1-1/4"	4,500	77696085235

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	ARBOR HOLE	TRIM LENGTH	FILAMENT PATTERN	MAX. RPM	PART #
<b>Disc Brush for Shell Mill Holder Keyway</b>							
2"	80	0.040"	3/4"	1-1/4"	Tear Drop	2,500	77696090227
	120	0.028"	3/4"	1-1/4"	Tear Drop	2,500	77696090225
	120	0.040"	3/4"	1-1/4"	Tear Drop	2,500	77696090226
3"	80	0.040"	3/4"	1-1/4"	Tear Drop	2,500	77696090232
	120	0.028"	3/4"	1-1/4"	Tear Drop	2,500	77696090230
	120	0.040"	3/4"	1-1/4"	Tear Drop	2,500	77696090231
4"	80	0.040"	1-1/4"	1-1/4"	Tear Drop	2,500	77696090237
6"	80	0.040"	1-1/4"	1-1/4"	Tear Drop	2,500	77696090242
8"	80	0.040"	1-1/4"	1-1/4"	Tear Drop	2,000	77696090247
10"	80	0.040"	1-1/4"	1-1/4"	Tear Drop	2,000	77696090252
4"	120	0.028"	1-1/4"	1-1/4"	Tufted	2,500	77696090235
	120	0.040"	1-1/4"	1-1/4"	Tufted	2,500	77696090236
6"	120	0.028"	1-1/4"	1-1/4"	Tufted	2,500	77696090240
	120	0.040"	1-1/4"	1-1/4"	Tufted	2,500	77696090241
8"	120	0.028"	1-1/4"	1-1/4"	Tufted	2,500	77696090245
	120	0.040"	1-1/4"	1-1/4"	Tufted	2,000	77696090246
10"	120	0.028"	1-1/4"	1-1/4"	Tufted	2,000	77696090250
	120	0.040"	1-1/4"	1-1/4"	Tufted	2,000	77696090251

Std. Pkg. = 1 disc brush/box.

FOR BRUSH DIAMETER	SHAFT DIAMETER	NUMBER OF LOCATOR PINS	PART #
<b>Disc Brush Drive Arbors</b>			
2"	1/2"	2	66261128252
3", 4", 5"	3/4"	2	77696085212
6"	3/4"	2	77696085213
6"	3/4"	3	77696085214
8"	3/4"	4	77696085215
10", 12", 14"	3/4"	4	77696085216

Used to securely mount disc brushes for use in any type of milling machine or CNC machine. Drive arbor shaft is 3/4" diameter for use in any live tool holder. Std Pkg = 1.

FOR BRUSH DIAMETER	BAND ID	BAND OD	BAND WIDTH	PART #
<b>Disc and End Brush Bands</b>				
1-1/2"	1-1/8"	1-1/2"	.210"	77696085217
2"	1-1/2"	1-7/8"	.210"	77696085218
2-1/2"	2"	2-3/8"	.210"	77696085219
3"	2-1/2"	2-7/8"	.210"	77696085220
4"	3-1/4"	3-5/8"	.210"	77696085221
5"	4-3/8"	4-3/4"	.210"	77696085222
6"	5-1/8"	5-5/8"	.275"	77696085223
8"	7"	7-1/2"	.275"	77696085224
10"	9"	9-1/2"	.275"	77696085225
12"	11"	11-1/2"	.275"	77696085226
14"	13"	13-1/2"	.275"	77696085227

Apply to disc or end brush to prevent flare and enhance aggression. To use, insert bands on disc and end brushes where filament meets composite material. Std Pkg - 3 bands.

## Applications

- End brushes include a stem that allows for mounting in a collet or tool holder for CNC machine or robotic use
- May be used with portable or electric tools for deburring slots, small recessed areas, and internal part features

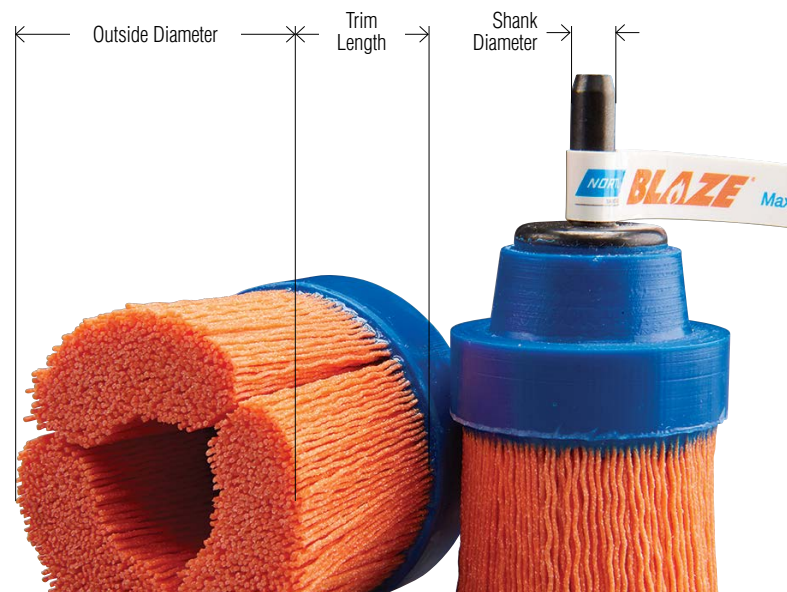
## End Brush Operating Parameters

- To optimize the performance of an end brush, depth of penetration between the brush face and the work surface is recommended to be .075" - .100". Adjustments should be made to achieve the most efficient operational conditions.
- Feed rate is determined by the material being processed as well as the amount of deburring or surface finishing required. On soft material with small burrs, higher feed rates may be used.

## Availability

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	SHANK DIAMETER	TRIM LENGTH	MAX. RPM	PART #
<b>Stem-Mounted End Brush</b>						
1/2"	120	0.040"	1/4"	1"	10,000	77696090207
3/4"	120	0.040"	1/4"	1"	10,000	77696090210
1"	120	0.040"	1/4"	1"	10,000	77696090213
	80	0.040"	1/4"	1-3/8"	4,500	77696085247
1-1/2"	120	0.028"	1/4"	1-3/8"	4,500	77696085251
	120	0.040"	1/4"	1-3/8"	4,500	77696085250
	80	0.040"	1/4"	1-3/8"	4,500	77696085253
2"	120	0.028"	1/4"	1-3/8"	4,500	77696085257
	120	0.040"	1/4"	1-3/8"	4,500	77696085256
	80	0.040"	1/4"	1-3/8"	4,500	77696085259
2-1/2"	120	0.028"	1/4"	1-3/8"	4,500	77696085263
	120	0.040"	1/4"	1-3/8"	4,500	77696085262

Std. Pkg.: 1/2" - 3/4" diameter brushes = 10 brushes/box. => 1" diameter brushes = 1 brush/box.



# TWISTED BRUSHES



## Applications

- Norton collet-ready brushes have a solid steel shank for use in CNC machine tools, drill presses and manual machine tools
- Deburring, cleaning, finishing and polishing inside any small diameter holes: bores, narrow cavities, and inner walls of tubing and pipes

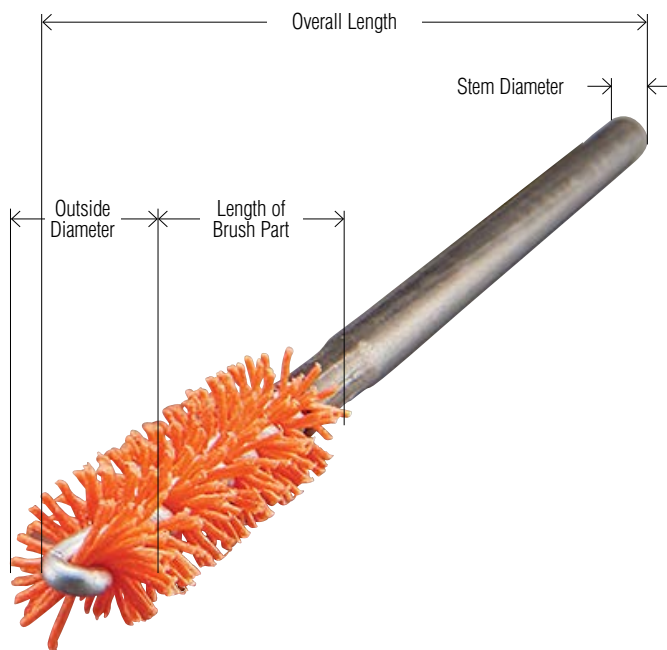
## Twisted Brush Operating Parameters

- Twist brushes should be securely clamped and run in clockwise motion
- Insert the brush into the workpiece before starting the brush's motion - aligning the brush with the workpiece's centerline

## Availability

BRUSH DIAMETER	GRIT	FILAMENT DIAMETER	SHANK DIAMETER	BRUSH LENGTH	OVERALL LENGTH	PART #
1/4"	120	0.028"	3/16"	2"	8"	77696085281
5/16"	120	0.028"	1/4"	2"	8"	77696085283
3/8"	120	0.028"	1/4"	2"	8"	77696085285
1/2"	120	0.040"	1/4"	2"	8"	77696085287
5/8"	120	0.040"	1/4"	2"	8"	77696085289
3/4"	120	0.040"	1/4"	2"	8"	77696085291
7/8"	120	0.040"	1/4"	2"	8"	77696085293
1"	80	0.040"	1/4"	2"	8"	77696085295
	120	0.040"	1/4"	2"	8"	77696085294
1-1/4"	80	0.040"	1/4"	2"	8"	77696085297
	120	0.040"	1/4"	2"	8"	77696085296
1-3/8"	80	0.040"	1/4"	2"	8"	77696085299
	120	0.040"	1/4"	2"	8"	77696085298
1-1/2"	80	0.040"	1/4"	2"	8"	77696085301
	120	0.040"	1/4"	2"	8"	77696085300
1-3/4"	80	0.040"	1/4"	2"	8"	77696085303
	120	0.040"	1/4"	2"	8"	77696085302
2"	80	0.040"	1/4"	2"	8"	77696085305
	120	0.040"	1/4"	2"	8"	77696085304

Std. Pkg. = 36 brushes/box.



## TECHtip

- The maximum operating speed on the brush is used for safety purposes. The optimal operating speed is typically 50% - 70% less than the max operating speed. Finding a balance between the part penetration, line speed, and RPM allow for optimal brush life and cut rates.
- Lower speeds and lighter pressure generate less heat and require less power. When higher brush speeds and pressures are required, it is recommended to use a more aggressive brush which can be done by increasing abrasive grit size, changing filament configuration, decreasing trim length, increasing the brush diameter, and/or slowing line speed.



Always wear personal protective equipment when using abrasive brushes, including goggles and gloves.

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