



21002



21014

Crosshole Deburring Brushes

are designed for automated applications in CNC machining centers and dedicated machines. They are ideal for removing burrs from internal edges. Since they eliminate off-hand deburring, they improve part-to-part consistency and reduce direct labor content. Crosshole Deburring brushes are available in sizes ranging from 3/4" to 4" and can be readily adapted into a machining center's tool changer.

Diam.	Steel Wire Size*	Face Width	Stem Diam.	Max. RPM	Standard Pack	Item Number	List Price Ea.
3/4	.005	3/8 3/4	3/8	8,000	1	21000 21001	\$89.66 137.53
7/8	.006	3/4	3/8	8,000	1	21002	82.81
1	.006	3/4	3/8	8,000	1	21004	84.84
1-1/4	.006	3/4	3/8	8,000	1	21006	87.64
1-1/2	.006	1	3/8	8,000	1	21008	93.41
2	.006	1	3/8	6,000	1	21010	98.17
2-1/2	.008	1	3/8	6,000	1	21012	109.42
3	.008	1	3/8	6,000	1	21014	116.35
4	.0118	1	3/8	6,000	1	21015	121.72

* Stainless Steel fill is available by special order.

Note: All brush stems have a 2" long flat for use in end mill holders. Alternatively, they can be mounted in 3/8" collets. Crosshole Deburring Brush extension holder is available. Contact Application Engineering at 800-553-2371.



Replacement Head



Reusable Arbor

Replacement Brush Heads and Reusable 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 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 800-553-2371 for more information.

Operating Parameters

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