



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



AHB

TOOLING & MACHINERY, INC.

COMPLETE METALWORKING SOLUTIONS

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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.

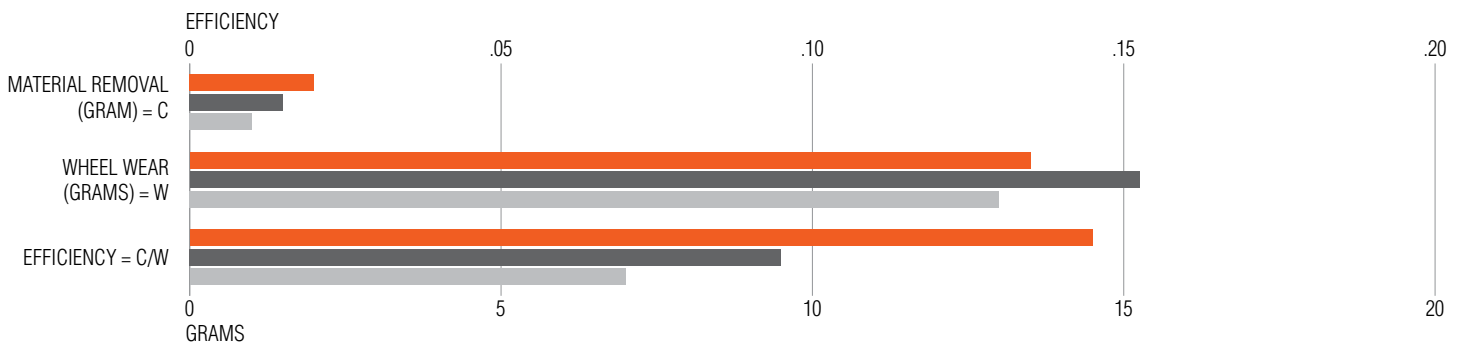
Your Norton representative will help meet your exact custom design specifications including filament type, density, diameter, and length.

BLAZE BRUSH PERFORMANCE

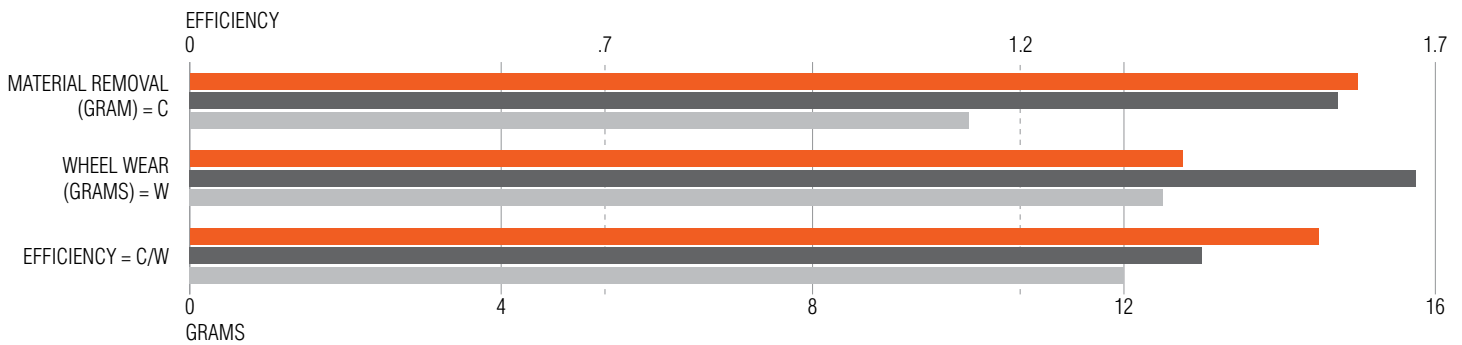
Tests were conducted using 8" diameter radial wheels over six, 15 minute cycles.

■ 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.

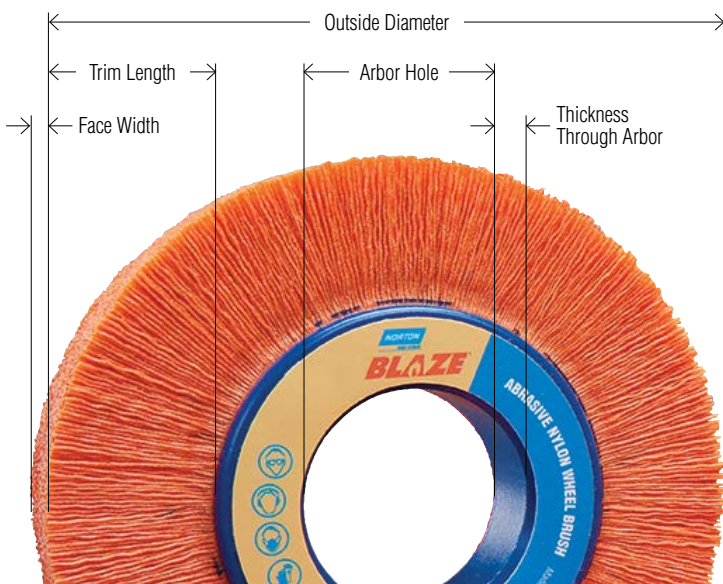
Availability

| BRUSH DIAMETER | GRIT | FILAMENT DIAMETER | ARBOR HOLE | TRIM LENGTH | FACE WIDTH | MAX. RPM | PART # |
|---|------|-------------------|------------|-------------|------------|----------|-------------|
| Radial Wheel Brushes with Copper Center Arbor Hole | | | | | | | |
| 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 # |
|--|------------|-----------------------|----------------|-------------|
| Air Motor Shanks for Copper Center Wheels | | | | |
| 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 # |
|--|------|-------------------|------------|-------------|-------|------------|----------|-------------|
| Radial Wheel Brushes with Standard Arbor Hole | | | | | | | | |
| 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 # |
|-----------------------------|------------|-------------|-------------|
| Wheel Brush Adaptors | | | |
| 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

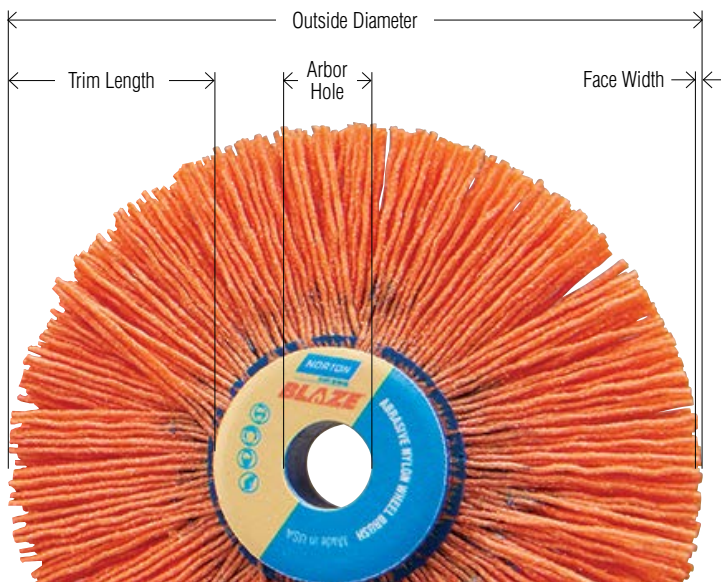
| BRUSH DIAMETER | GRIT | FILAMENT DIAMETER | ARBOR HOLE | TRIM LENGTH | FACE WIDTH | MAX. RPM | PART # |
|--|--------|-------------------|------------|-------------|------------|-------------|-------------|
| Narrow Face Wheel Brushes with Arbor Hole | | | | | | | |
| 3" | 80 | 0.040" | 3/8" | 1" | 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 # | |
|--|--------|-------------------|------------|-------------|------------|-------------|-------------|-------------|
| Narrow Face Wheel Brushes with Arbor Hole (continued) | | | | | | | | |
| 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 # | |
|--|--------|-------------------|----------------|-------------|------------|-------------|-------------|-------------|
| Narrow Face Wheel Brushes with Stem-Mount | | | | | | | | |
| 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 | |
| 120 | 0.040" | 1/4" | 1" | 1/4" | 10,000 | 77696085092 | | |
| | 4" | 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 | | |
| | 5" | 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 |
| 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 | | |
| | 6" | 80 | 0.040" | 1/4" | 2" | 1/4" | 4,500 | 77696085111 |
| | | 120 | 0.028" | 1/4" | 2" | 1/4" | 4,500 | 77696085112 |
| | | 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

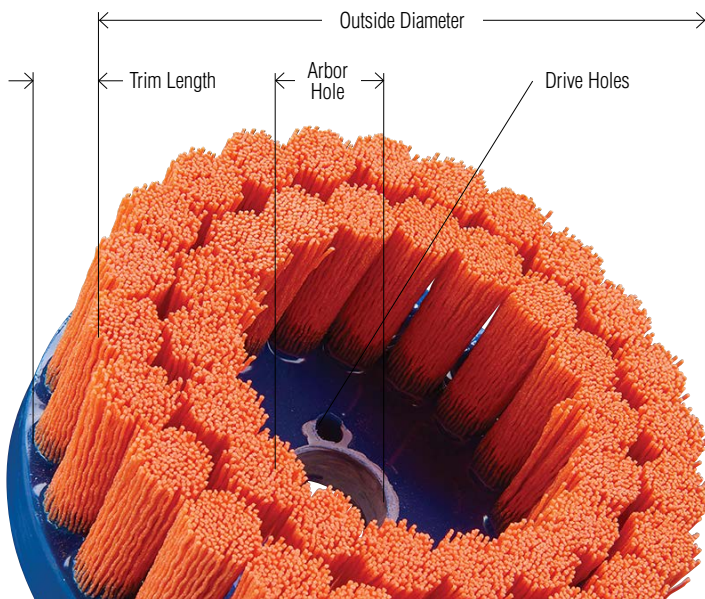
- Deburring and removing burrs and sharp edges
- Edge radiusing
- Removing rust, scale, and other surface contaminants, scrubbing and cleaning
- Surface prepping before painting, plating, and coating
- Blending tool marks
- Applying decorative finishes/texturing surfaces
- Finishing and polishing

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.



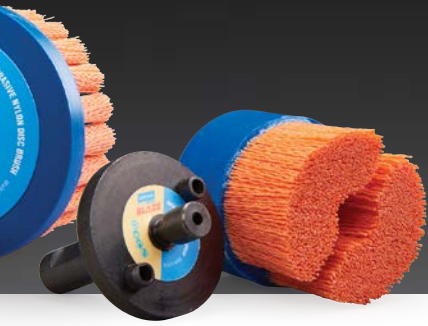
Disc Brush Filament Patterns

- 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 # |
|--------------------------------------|------|-------------------|------------|-------------|------------------|----------|-------------|
| Disc Brushes with Arbor Holes | | | | | | | |
| 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 | 1,750 | 77696085128 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tear Drop | 1,750 | 77696085131 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 1,750 | 77696085132 |
| 6" | 80 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085135 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085138 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085139 |
| 8" | 80 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085142 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085145 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 1,200 | 77696085146 |
| 10" | 80 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 800 | 77696085149 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tear Drop | 800 | 77696085152 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 800 | 77696085153 |
| 12" | 80 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 800 | 77696085156 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tear Drop | 800 | 77696085159 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tear Drop | 800 | 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 | 1,750 | 77696085180 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tufted | 1,750 | 77696085181 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tufted | 1,750 | 77696085188 |
| 6" | 80 | 0.040" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085184 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085187 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085188 |
| 8" | 80 | 0.040" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085191 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085194 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tufted | 1,200 | 77696085195 |
| 10" | 80 | 0.040" | 7/8" | 1-1/2" | Tufted | 800 | 77696085198 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tufted | 800 | 77696085201 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tufted | 800 | 77696085202 |
| 12" | 80 | 0.040" | 7/8" | 1-1/2" | Tufted | 800 | 77696085205 |
| | 120 | 0.028" | 7/8" | 1-1/2" | Tufted | 800 | 77696085208 |
| | 120 | 0.040" | 7/8" | 1-1/2" | Tufted | 800 | 77696085209 |

Std. Pkg. = 1 brush/box.



STEM-MOUNTED END BRUSHES



| BRUSH DIAMETER | GRIT | FILAMENT DIAMETER | ARBOR HOLE | TRIM LENGTH | MAX. RPM | PART # |
|--|------|-------------------|------------|-------------|----------|-------------|
| Mini Disc Brushes with Arbor Hole | | | | | | |
| 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 # |
|--|------|-------------------|------------|-------------|------------------|----------|-------------|
| Disc Brush for Shell Mill Holder Keyway | | | | | | | |
| 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 # |
|--------------------------------|----------------|------------------------|-------------|
| Disc Brush Drive Arbors | | | |
| 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 # |
|---------------------------------|---------|---------|------------|-------------|
| Disc and End Brush Bands | | | | |
| 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

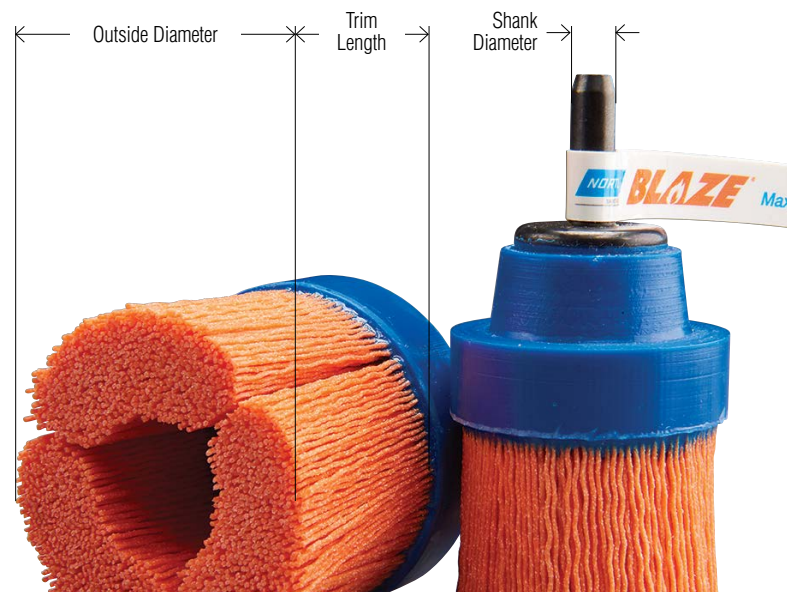
End Brush Operating Parameters

- To optimize the performance of 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.
- 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 # |
|-------------------------------|------|-------------------|----------------|-------------|----------|-------------|
| Stem-Mounted End Brush | | | | | | |
| 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 collect-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

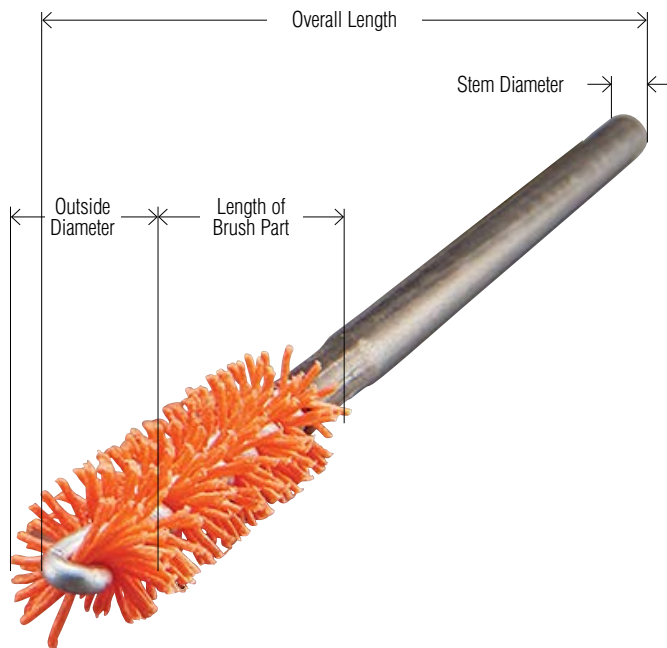
Twisted Brush Operating Parameters

- 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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