

Brushware Operating Techniques

Rotation Speed:

Under working conditions, the centrifugal force built up by a revolving brush is quite high. The wires or materials used in the brush become considerably stiffer at the working face, and then the cutting or abrasive action of the brush is greatly increased. It follows that, as the speed increases, so the cutting action is faster.

Pressure needed when applying work to brush:

For cleaning, roughening and deburring at high speeds, use a light pressure. For finishing, polishing and brushing at low speeds with wire, sufficient pressure may be needed to bring the sides of the wire in contact with the work.

Brush Wear:

To achieve the longest life out of the brush, it is recommended that the rotation should be reversed from time to time (not all brushes able to be reversed - check with Josco if unsure). When rotating in one direction only, the cutting edge of the wires become dulled, and by reversing the brush, better cutting action is noticed.

Brushing Recommendations

If you have any brushing problems, you may write to us for advice on the best brush for your application:

To enable us to solve your problem efficiently, please give us the following details:

- A description of the article you wish to brush: the size, shape and material, with (if possible), a sample of the part to be brushed.
- A description of the work to be done and the surface of the finish required.
- The horsepower available.
- Maximum speed of your equipment.
- Arbor hole or shaft size of your equipment.
- The maximum diameter of the brush which can be mounted to your machine.

Testing:

A brush should always be tested on a small part of your work piece to ensure the best results. The chart on the below will help you to select the right brush for your purpose.

Desired Effect/Problem	Course of Action Advised/Solution
To cut faster	<ul style="list-style-type: none">• Use a large diameter brush• Increase RPM• Use a brush with a heavier wire gauge• Use a shorter trim <p><i>The trim of the brush is the free length wire protruding from the sideplates.</i></p>
To produce a finer finish	<ul style="list-style-type: none">• Use a brush with a lighter wire gauge• Follow up with Josco polishing mops and compounds
To reach all parts of an irregular surface	<ul style="list-style-type: none">• Use a brush with a longer trim
To remove burrs	<ul style="list-style-type: none">• Use a short trim wire brush
To produce a more even finish	<ul style="list-style-type: none">• Use a holding fixture, hand operated or automatic