IMEXSU'S GUIDELINES FOR SELECTING RIGHT TYPE OF DISC BRUSH

- **Basically we have 3 types of Densities** :-
    1. **Low** – Dot type
    2. **Medium** – Dot Heavy ; Dot Combination ; Turbine ; High Performance ; Interleaved ; Vertical and Circular sector ; Dot vertical Combi
    3. **High** – Heavy sector ; High Density ; Coated
- **Selecting Right Raw Material as per application demands which is based on various factors:-**
    1. **Material: -** types, cross-section, openings, wall thickness
    2. **Machines: -** Model, clamping fixtures, through / side coolant, last operation done, path followed by cutter
    3. **Other Needs: -** R_A value required, Radius required, cutter mark to be reduced or removed, CYCLE – TIME (this is important as some time you pay less for brush, but Life is less, As a result, per piece cost. We recommend such that cycle time is reduced with better brush life thereby, reducing per piece cost. ***We recommend don't compare brush price but, check out Quality, Brush life and per piece cost reduction***).
- ***Right filament material in right shape and height*** can help one achieve desired output in LESS time ***bringing down per piece cost drastically.***
- To determine the output of brushing operation… ***proper selection of brush density and trim length is very important.***
- Low density / long trim brushes are best suited for operations requiring a high degree on conformability
- High density / short trim wheel brushes are ideal for one who need minimum cycle times and maximum brush life
- Shorter filaments are more aggressive while longer filaments have the ability to conform to irregular surfaces better
- Instead of increasing the pressure and speed to attain more aggression – switch to brushes with lower grit – more coarse filament and shorter trim length.
- Slower brush RPM are found to be more aggressive than faster speed.
- Use of coolant facilitates higher RPM, faster speed rates and produces a better surface finish.
- Always start with lower grit and slowly increase the grit till desirable finish is attained.
- 80 grit flat filaments mostly give desired finish with more aggression.
- Larger the brush diameter, the more efficient is the brush
- Increasing brush speed does not always result in more aggressive action , to achieve more aggression with same brush try following parameters –
    - Reduce RPM and increase the depth of penetration
    - Reduce the feed rate
    - Use flat filaments
    - Increase filament diameter and reduce the grit size
    - Use brush with shorter trim length

DISC BRUSHES

IMEXSU®