Reduce number of passes! Process without lap marks!

Suitable for deburring and polishing workpieces with a **width of 100mm or greater**, such as cylinder heads, cylinder blocks and machinery beds.

<table>
<thead>
<tr>
<th>Brush Color</th>
<th>Ø125mm</th>
<th>Ø165mm</th>
<th>Ø200mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Red</td>
<td>A11-CB125M EDP 30025</td>
<td>A11-CB165M EDP 30028</td>
<td>A11-CB200M EDP 30031</td>
</tr>
<tr>
<td>White</td>
<td>A21-CB125M EDP 30026</td>
<td>A21-CB165M EDP 30029</td>
<td>A21-CB200M EDP 30032</td>
</tr>
<tr>
<td>Blue</td>
<td>A31-CB125M EDP 30027</td>
<td>A31-CB165M EDP 30030</td>
<td>A31-CB200M EDP 30033</td>
</tr>
<tr>
<td>Slide Ring</td>
<td>SR125M EDP 40010</td>
<td>SR165M EDP 40011</td>
<td>SR200M EDP 40012</td>
</tr>
</tbody>
</table>

*Slide ring sold separately*
**Xebec Brush™ Surface Extra-Large Product Structure & Dimensions**

- **shank**
- **base holder**
- **slide ring**
- **brush**
- **ring**

**Xebec Brush™ Surface Extra-Large Parameters**

<table>
<thead>
<tr>
<th>Brush Diameter (mm)</th>
<th>Vertical Burr</th>
<th>Horizontal Burr</th>
<th>Depth of Cut (mm)</th>
<th>Polishing</th>
<th>Maximum</th>
<th>Rotation Speed (mm-1)</th>
<th>Recommended</th>
<th>Maximum</th>
<th>Feed Rate (mm/min)</th>
<th>Burr Root Thickness (mm)</th>
<th>Cutter mark removal</th>
<th>Recommended Brush Projection (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>125</td>
<td>0.5</td>
<td>1.0</td>
<td>0.5~1.0</td>
<td>0.3~0.5</td>
<td>1.5</td>
<td>800</td>
<td>1000</td>
<td>4000</td>
<td>2500</td>
<td>300</td>
<td>15</td>
<td></td>
</tr>
<tr>
<td>165</td>
<td>0.5</td>
<td>1.0</td>
<td>0.5~1.0</td>
<td>0.3~0.5</td>
<td>1.5</td>
<td>600</td>
<td>750</td>
<td>4000</td>
<td>2500</td>
<td>300</td>
<td>15</td>
<td></td>
</tr>
<tr>
<td>200</td>
<td>0.5</td>
<td>1.0</td>
<td>0.5~1.0</td>
<td>0.3~0.5</td>
<td>1.5</td>
<td>480</td>
<td>600</td>
<td>4000</td>
<td>2500</td>
<td>300</td>
<td>15</td>
<td></td>
</tr>
</tbody>
</table>

**Adjusting Parameters - Deburring**

- If burrs are not completely removed
  - Increase the rotation speed in 25% increments; be aware of the maximum rotation speed
  - Decrease the feed rate in 10 - 20% increments

- Edge is too rounded or you want to extend tool life
  - Decrease the rotation speed in 25% increments
  - Increase the feed rate in 10 - 20% increments

- Uneven wear occurs on the brush
  - Double the feed rate and process the workpiece using the round pass
  - Rotate the brush in a counterclockwise direction for the return pass

**Adjusting Parameters - Cutter Marks & Polishing**

- If cutter marks are not completely removed
  - Increase the number of passes
  - Increase the rotation speed in 25% increments; be aware of the maximum rotation speed

- Cutter marks are removed but edge is too rounded or you want to extend tool life
  - Decrease the rotation speed in 25% increments
  - Increase the feed rate in 20 - 40% increments

- Uneven wear occurs on the brush
  - Double the feed rate and process the workpiece using the round pass
  - Rotate the brush in a counterclockwise direction for the return pass