



NORTON

SAINT-GOBAIN

WIRE BRUSHES

INTRODUCTION









Norton offers a range of wire brushes suitable for a wide variety of surface processing applications. The range encompasses crimped and knotted wire power wheel brushes, bevelled brushes, cup brushes, end brushes and hand brushes.

A number different types of wire are available which have been specifically selected to give the best results in any specific application.

WIRE TYPES

TEMPERED QUALITY STEEL WIRE			STAINLESS STEEL WIRE			BRASS WIRE
CRIMPED	STRAIGHT		CRIMPED	STRAIGHT		CRIMPED
						
Removing dust and smoothing low-grade and non-alloy steels			Brushing and smoothing chrome-nickel steels, including stainless steel			Brushing, cleaning and smoothing brass, copper and bronze
NOSCW NOrmal Steel Crimped Wire	NOSKW NOrmal Steel Knotted Wire	NOSSW NOrmal Steel Straight Wire	STSCW STainless Steel Crimped Wire	STSKW STainless Steel Knotted Wire	STSSW STainless Steel Straight Wire	BRACW BRASS Crimped Wire

SHAPE KEY

CODE	PRODUCT TYPE	TOOL	APPLICATION
WHB	Crimped Wheel Brushes		Supplied as standard with arbour hole as indicated. The size of the arbour hole can be reduced with reduction rings. Wheel brushes with short wire are more aggressive. Larger widths require more horse power.
	Twist Knotted Wheel Brushes		Suitable for brushing out welded joints and brushing sharp corners.
BEB	Bevel Brushes		Specially designed for brushing hard-to-reach places such as edges and corners.
CPB	Crimped Cup Brushes		Use for cleaning jobs, especially on larger surfaces. Ideal for removing rust, corrosion, paint and primers. Removal of rust, corrosion, paint and primers.
	Twist Knotted Cup Brushes		An aggressive brush excellent for heavy-duty cleaning and finishing of large surfaces. Can be used for removing barnacles, scale, paint, rust and corrosion, as well as cleaning weld seams and spot-welds.
WHB/ENB	Shaft Mounted Brushes		Suitable for industrial use. Ideal for hard-to-reach areas. All shaft mounted brushes are equipped with a 6mm shank.
HCB/SPB	Hand Brushes		With wooden core. Available in different widths. For use on narrow work pieces. Ideal for light deburring and cleaning profiled surfaces.
TUB	Pipe Brushes		With handle or thread. For deburring and cleaning tubes.



WIRE BRUSHES FOR ANGLE GRINDERS

Wire brushes are excellent tools for deburring, removing rust, paint, corrosion and weld spatter from metal surfaces. They're almost spark free and with lower thermal impact, reduce the risk of workpiece burn. Norton offers a number of brush types and sizes for large flat areas to small, tight spaces. All provide a uniform finish and excellent price/performance ratio.

PRODUCT SELECTION GUIDE

FOR ANGLE GRINDERS

ANGLE GRINDER SIZE (mm)	115	125	150	180	230
BRUSH TYPES	BRUSH DIAMETER (mm)				
Wheel brush, knotted	100,115	125	150	178	-
Wheel brush, crimped	100,115	-	-	-	-
Cup brush, knotted	65	75	80	100	120
Cup brush, crimped	60	75	80,100	100	125,150

BY APPLICATION

Highly recommended ●

	WIRE DIAMETER (mm)				
APPLICATIONS	0,2	0,3	0,35	0,5	0,8
Roughening				●	●
Planing	●	●	●		
Deburring	●	●	●		
Edge honing	●	●	●		
Descaling/paint stripping	●	●	●	●	●
Weld seams	●	●	●	●	●

BY TYPE & MATERIAL

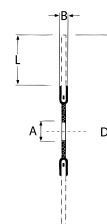
Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM
Normal steel	●	●			
Stainless steel			●	●	●

TWIST KNOTTED WHEEL BRUSHES



- Aggressive removal for heavy duty rust, paint, corrosion and weld spatter
- Work at high speed to finish parts faster
- Wheel shape makes it easy to access hard-to-reach areas
- Brush does not clog or load with surface material, for a cleaner finish

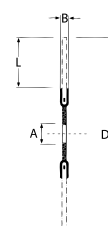


DxBxA L (mm)	NO. KNOTS	RECOMMENDED RPM	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,50 mm					
115x6x22,2 T22	36	6300 - 12500	1	63642581151	63642581639
125x6x22,2 T23	42	5500 - 11000	1	63642581157	63642581640
165x6x22,2 T35	76	4000 - 8000	1	63642581169	-

TWIST KNOTTED WHEEL BRUSHES



- Powerful performance for de-burring, edge honing and removing rust, paint, corrosion and weld spatter
- Wheel shape makes it easy to access hard-to-reach areas
- Work at high speed to finish parts faster
- Brush does not clog or load with surface material, for a cleaner finish



DxBxA L (mm)	RECOMMENDED RPM	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,35 mm				
100x11x22,2 T22	7500 - 12500	1	66254406185	-
115x11xM14 T23	6300 - 12500	1	66254406173	-
125x13x22,2 T28	5500 - 11000	1	66254406178	-
125x13xM14 T28	5500 - 11000	1	66254406172	-
0,50 mm				
115x11x22,2 T23	6300 - 12500	1	66254406167	66254406153
115x11xM14 T23	6300 - 12500	1	66254406160	-
125x13x22,2 T28	5500 - 11000	1	66254406166	-
125x13xM14 T28	5500 - 11000	1	66254406158	66254410928*
178x15x22,2 T35	4500 - 8500	1	66254406163	-

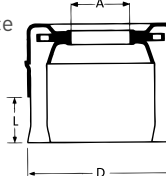
DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length

* Made-to-order

TWIST KNOTTED CUP BRUSHES **+++++**

- Aggressive brush for high speed roughing, rust, paint, corrosion and weld spatter removal
- Cup shape is ideal for use on large surface areas, removing matter quickly

- Brush guard offers protection, acting as a shield against surface material, whilst retaining visibility of the workpiece
- Brush guard is flexible enough for use on flat contoured, and hard-to-reach areas



DxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,50 mm				
65xM14 T20	115 & 125	1	66261103046	66261103171



TWIST KNOTTED CUP BRUSHES **+++**

- For tough cleaning and de-burring on heavy rust, weld scale and paint
- Cup shape with rigid wire construction provides extra cleaning power on large surface areas

- Stiff, long lasting knots make light work of heavy material build-up for applications such as preparing joints for filing and scaling
- Long life thanks to anti-clog nature



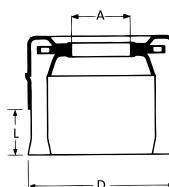
DxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,35 mm				
65xM14 T20	115	1	66254406104	-
100xM14 T25	150	1	66254406099	-
0,50 mm				
65xM14 T20	115	1	66254406095	66254406068
80xM14 T25	125	1	66254406094	-
100xM14 T25	150	1	66254406088	-

* Made-to-order

WIRE BRUSHES FOR ANGLE GRINDERS

CRIMPED CUP BRUSHES **+++++**

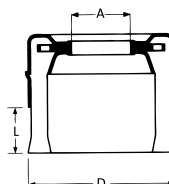
- A multi-purpose brush for the most common cleaning jobs
- Use on large surfaces for removing rust, paint and primer fast
- Offers excellent protection against flying debris thanks to the brush guard
- Brush guard allows visibility on the workpiece



DxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,30 mm				
75xM14 T22	115 & 125	1	66261103049	66261103176

CRIMPED WIRE CUP BRUSHES **+++**

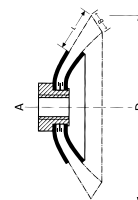
- Cup brush shape with crimped wire construction for cleaning light surface oxidation, paint and primers
- Cover large areas fast thanks to the cup shape
- Select a smaller diameter wire for lighter cleaning, thicker wire for more aggressive applications
- Long product life, thanks to anti-clog nature of the brush



DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,30 mm				
60xM14 T16	115	1	66254406058	66254406037
75xM14 T20	125	1	66254406055	-
80xM14 T25	125	1	66254406054	66254404868
100xM14 T30	150	1	66254406053	-
125xM14 T35	230	1	66254406050	-
150xM14 T55	230	1	66254406049	-

TWIST KNOTTED BEVEL BRUSHES **+++++**

- Bevel shape is specially designed for hard-to-reach areas including edges and corners
- Brush guard offers protection against flying debris, whilst still providing visibility of the workpiece
- Brush guard is flexible, allowing brush to be used on flat, open surfaces as well as hard to reach areas.
- Long product life, thanks to anti-clog nature of the brush

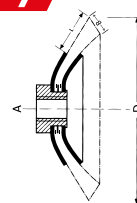


DxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,50 mm				
100xM14 T22	115	1	66261103055	66261103179

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length

TWIST KNOTTED BEVEL BRUSH +++

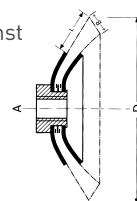
- Bevel shape is specially designed for hard-to-reach areas including edges and corners
- For aggressive removal of rust, corrosion, paint and primer
- Stiff, long lasting knots make light work of heavy material build-up for applications such as preparing joints for filing and scaling
- Long product life, thanks to anti-clog nature of the brush



DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,50 mm				
100x13xM14 T20	115	1	66254406149	66254406146
115x15xM14 T27,5	125	1	66254406147	66254406144

CRIMPED WIRE BEVEL BRUSHES +++++

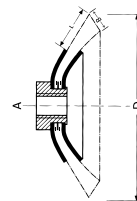
- Bevel shape is specially designed for hard-to-reach areas including edges and corners
- For removal of light rust, corrosion, paint and primer
- Brush guard offers protection against flying debris, whilst still providing visibility of the workpiece
- Long product life, thanks to anti-clog nature of the brush



DxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,30 mm				
100xM14 T24	115	1	66261103056	66261103180

CRIMPED WIRE BEVEL BRUSHES +++

- Bevel shape is specially designed for hard-to-reach areas including edges and corners
- For removal of light rust, corrosion, paint and primer
- Thick wire diameter provides more aggressive cleaning
- Long product life, thanks to anti-clog nature of the brush



DxBxA L (mm)	GRINDER SIZE (mm)	PK QTY	NORMAL STEEL
0,50 mm			
100x13xM14 T20	115	1	66254406142
115x15xM14 T27,5	125	1	66254406109*

* Made-to-order





WIRE BRUSHES FOR HAND DRILLS

Norton wire brushes for hand drills are ideal for small and hard-to-reach areas like inner diameters of holes and tubes. Used with medium pressure, the brushes are almost spark free, reducing thermal damage on the workpiece. A number of brush types are available for different application needs.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	WIRE DIAMETER (mm)			
	0,2	0,3	0,35	0,5
Roughing			●	●
Planing	●	●	●	
Deburring	●	●	●	●
Edge honing	●	●	●	
Descaling/paint stripping		●	●	●
Weld seams	●	●	●	

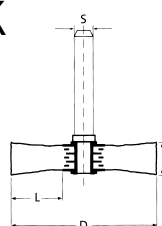
BY TYPE & MATERIAL

Highly recommended ●

PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFT WOOD	HARD WOOD
Normal steel	●	●				●	●
Stainless steel			●	●	●		
Brass wire				●		●	

TWIST KNOTTED WIRE WITH SHANK

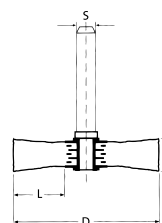
- Circular shape for hard-to-reach areas including edges and corners
- For aggressive removal of rust, corrosion, paint and primer
- Stiff, long lasting knots make light work of heavy material build-up for preparing joints for filing and scaling
- 6mm shank fits most brands of hand drills



DxB L (mm)	SHANK	PK QTY	NORMAL STEEL
0,35 mm			
70x15 T15	6	12	66254405406
0,50 mm			
70x15 T15	6	12	66254405407

CRIMPED WIRE WITH SHANK

- Circular shape for hard-to-reach areas including edges and corners
- For removal of light rust, corrosion, paint and primer
- Thicker wire diameter provides more aggressive cleaning, for less aggressive applications, choose a thinner wire
- 6mm shank fits most brands of hand drills



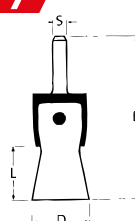
DxB L (mm)	SHANK	PK QTY	NORMAL STEEL	STAINLESS STEEL	BRASS
0,20 mm					
20x4 T3	6	10	66254404872	-	-
30x6 T6,5	6	10	66254404875	-	-
30x9 T6,5	6	10	66254404876	66254404909	-
40x9 T9	6	10	66254404879	66254404910	-
50x10 T12,5	6	10	66254404880	-	-
50x15 T12,5	6	10	66254404881	66254405238	66254405397
60x10 17,5	6	10	-	66254405269	-
60x15 17,5	6	10	66254404885	66254405270	-
70x10 T19	6	10	66254404886	66254405271	-
80x20 T19	6	10	-	66254405392*	66254405405
0,30 mm					
50x10 T12,5	6	10	66254404891	-	-
60x15 17,5	6	10	66254404897	66254405394*	-
70x10 T19	6	10	66254404899	66254405395	-
70x15 T19	6	10	-	66254405396	-
80x20 T19	6	10	66254404907*	66254405398	-

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length * Made-to-order

TWIST KNOTTED END BRUSHES



- End brush shape is perfect for heavy-duty cleaning and deburring hard-to-reach areas such as tubes and internal diameters
- Twist knotted wires are aggressive and remove material faster
- For use on steel, choose a larger wire diameter for more aggressive applications, for lighter work, select a smaller wire diameter
- 6mm shank fits most brands of hand drills



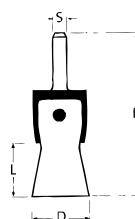
DxB L (mm)	SHANK	PK QTY	NORMAL STEEL
0,35 mm			
19x68 T28	6	12	66254405421
22x68 T28	6	12	66254405422*
0,50 mm			
28x68 T28	6	12	66254405423

* Made-to-order

CRIMPED WIRE END BRUSHES ON SHANK (ENB)



- End brush shape is perfect for cleaning and deburring hard-to-reach areas such as tubes and internal diameters
- Crimped wires are perfect for lighter cleaning and material removal
- For use on steel, choose a larger wire diameter for more aggressive applications, for lighter work, select a smaller wire diameter
- 6mm shank fits most brands of hand drills



DxBxL (mm)	SHANK	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,20 mm				
12x60 T20	6	12	66254405408	-
17x65 T22	6	12	66254405409	-
0,30 mm				
12x60 T20	6	12	66254405410	66254405414
17x65 T22	6	12	66254405411	66254405415
24x68 T25	6	12	66254405412	66254405418*
30x68 T26	6	12	66254405413	66254405419

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length

* Made-to-order





WIRE BRUSHES FOR BENCH GRINDERS

Wire wheel brushes for bench grinders are commonly used to remove rust, corrosion, hardened paint and adhesive residues, providing a good surface finish on large or small work pieces at a good price/performance ratio.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	WIRE DIAMETER (mm)		
	0,2	0,3	0,5
Roughing			●
Surface preparation	●	●	
De-burring	●	●	
Edge honing	●	●	
Descaling/paint stripping	●	●	●
Weld seams	●	●	●

BY TYPE & MATERIAL

Highly recommended ●

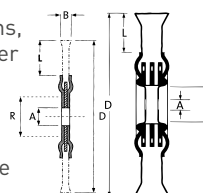
PRODUCT AVAILABILITY ON:	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFT WOOD	HARD WOOD
Normal steel	●	●				●	●
Stainless steel			●	●	●		

CRIMPED WHEEL BRUSHES (WHB)



- Wheel brushes are ideal for removing corrosion, rust, hardened paints and hard adhesive residues
- Crimped wire removes light rust, corrosion, paint and primer

- Choose a larger wire diameter for more aggressive applications, for lighter work, select a smaller wire diameter
- For working on large surface areas, several wheel brushes can be mounted on the machine simultaneously



DxBxAR L (mm)	PK QTY	NORMAL STEEL	STAINLESS STEEL
0,20 mm			
100x20x20x30 T24	1	66254406450	-
125x24x20x30 T36	1	66254406409	-
150x29x32x50,8 T27	1	66254406407	-
200x26x32x80 T40	1	66254406401	-
0,30 mm			
80x15x20x20 T20	1	66254406399	-
100x11x12x20 T22	1	66254406455*	-
125x11x12x20 T34	1	66254406454	-
125x24x20x30 T36	1	66254406282	-
150x18x32x50,8 T27	1	66254406265	66254406206
180x22x32x50,8 T42	1	66254406263	-
180x28x32x50,8 T42	1	66254406259	66254406196
200x26x32x80 T40	1	66254406255	66254406187
200x36x32x80 T40	1	66254406243	-
250x32x50,8x100 T50	1	66254406241	-
0,50 mm			
200x20x32x80 T40	1	66254406216	-
250x38x50,8x100 T50	1	66254406214	-

DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length

* Made-to-order



WIRE BRUSHES FOR MANUAL APPLICATION

Simple brushing operations can be carried out by hand using Norton manual brushes. A number of brush types are available for different applications including cleaning and removing rust, scale and paint.

PRODUCT SELECTION GUIDE

BY APPLICATION

Highly recommended ●

APPLICATIONS	TYPE OF WIRE			
	BRASS	CRIMPED	STRAIGHT	NYLON/PVC
Descaling/paint stripping		●		
Weld seams		●		
Brushing/dust removal			●	●
Light cleaning	●			●

BY TYPE & MATERIAL

Highly recommended ●

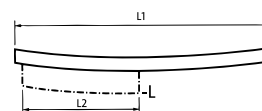
PRODUCT AVAILABILITY ON:							
	STEEL	CARBON STEEL	STAINLESS STEEL	NON-FERROUS METAL	ALUMINIUM	SOFT WOOD	HARD WOOD
Normal steel	●	●				●	●
Stainless steel			●	●	●		
Brass wire				●		●	

WIRE BRUSHES FOR MANUAL APPLICATION

BRUSHES WITH HANDLE

- Basic hand brush for simple cleaning jobs in hard-to-reach or small areas
- Plastic handle for better grip and comfort in use
- Choose a larger wire diameter for more aggressive applications, for lighter work, select a smaller wire diameter

L1xL2xL (mm)	NUMBER OF ROWS	PK QTY	ART NO.
WOOD HANDLE NORMAL STEEL STRAIGHT WIRE 0,30 mm			
290x140x25	1R	12	66254405431
290x140x25	2R	12	66254405432
290x140x25	3R	12	66254405434
290x140x25	4R	12	66254405435
290x140x25	5R	12	66254405437
WOOD HANDLE STAINLESS STEEL STRAIGHT WIRE 0,30 mm			
290x140x25	2R	12	66254405443*
290x140x25	4R	12	66254405447
WOOD HANDLE STAINLESS STEEL CRIMPED WIRE 0,30 mm			
290x140x25	2R	12	66254405457
290x140x25	4R	12	66254405461
WOOD HANDLE BRASS CRIMPED WIRE 0,30 mm			
290x140x25	4R	12	66254405466
290x140x25	6R	12	66254405468
PLASTIC HAND NORMAL STEEL STRAIGHT WIRE 0,30 mm			
265x140x25	1R	12	66254405470
PLASTIC HAND STAINLESS STEEL STRAIGHT WIRE 0,30 mm			
265x140x25	1R	12	66254405471
PLASTIC HAND BRASS CRIMPED WIRE 0,30 mm			
265x140x25	1R	12	66254405473



DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length

* Made-to-order

SPECIAL HAND BRUSHES

SPARK PLUG BRUSHES

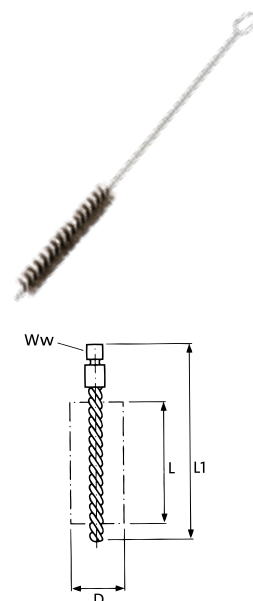
L1xL2xL (mm)	WIRE	ROWS	PK QTY	ART NO.
SPB				
200x18x45	0,20	3x6R	24	66254405474



PIPE BRUSHES WITH HANDLE

- Pipe brush cleans and descales internal diameter of pipes
- Flexible metal shaft allows cleaning around bends and corners
- Choose a larger wire diameter for more aggressive applications, for lighter work, select a smaller wire diameter

DxLxL1 (mm)	PK QTY	ART NO.
NORMAL STEEL CRIMPED WIRE 0,10 mm		
10x100x300	20	66254405706
12x100x300	20	66254405704
NORMAL STEEL CRIMPED WIRE 0,20 mm		
20x100x300	20	66254405715
BRASS CRIMPED WIRE 0,10 mm		
10x100x300	20	66254405725
18x100x300	20	66254405728*
BRASS CRIMPED WIRE 0,15 mm		
20x100x300	20	66254405730*
NYLON WIRE 0,10 mm		
10x100x300	20	66254405734*
15x100x300	20	66254405737



* Made-to-order

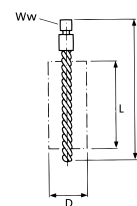
PIPE BRUSHES WITH SHANK

DxLxL1 (mm)	W/w	PK QTY	ART NO.
NORMAL STEEL CRIMPED WIRE 0,20 mm			
18x80x115	6	10	66254405502
25x80x115	6	10	66254405503
NORMAL STEEL CRIMPED WIRE 0,30 mm			
32x100x160	1/2"BSW	5	66254405634



LONG SHAFT FOR PIPE BRUSHES WITH SHANK

D (mm)	SHANK / W/w	WIRE Ø	PK QTY	ART NO.
DOU				
1000	6	-	1	66254405629
1000	1/2"BSW	-	1	66254405692



DIMENSION KEY: D = Diameter B = Width A = Bore min L = Wire Length



OPERATING SPEED






Peripheral speed is a decisive factor in achieving optimum performance from a brush, the table below enables you to determine the relevant peripheral speed by simply reading down and across the appropriate diameter and drive shaft operating speed columns.

RPM	BRUSH DIAMETER (mm)											
	20	40	50	80	100	125	150	180	200	250	300	350
min ⁻¹	-	-	-	-	-	-	-	-	-	-	-	-
800	-	-	-	3,35	4,19	5,23	6,28	7,53	8,37	10,47	12,56	14,75
900	-	-	2,35	3,77	4,71	5,88	7,06	8,48	9,41	11,77	14,12	16,47
1150	-	-	3,01	4,81	6,01	7,52	9,02	10,83	12,03	15,04	18,04	21,04
1200	1,26	2,51	3,14	5,02	6,28	7,85	9,41	11,3	12,55	15,69	18,83	21,97
1400	1,46	2,93	3,66	5,86	7,32	9,15	10,98	13,18	14,64	18,31	21,97	25,63
1500	1,57	3,14	3,92	6,28	7,85	9,81	11,77	14,13	15,69	19,61	23,54	27,46
1800	1,88	3,77	4,71	7,54	9,41	11,77	14,12	16,95	18,83	23,54	28,24	32,95
2000	2,09	4,19	5,23	8,37	10,26	13,08	15,69	18,84	20,92	26,15	31,38	36,61
2500	2,62	5,23	6,54	10,47	13,08	16,35	19,61	23,55	26,15	32,67	39,23	45,76
2800	2,93	5,86	7,32	11,72	14,64	18,31	21,97	26,37	29,29	36,61	43,93	51,25
3000	3,14	6,28	7,85	12,56	15,69	19,62	23,54	28,26	31,38	39,23	47,07	54,92
3200	3,35	6,7	8,37	13,4	16,74	20,92	25,1	30,14	33,47	41,84	50,21	58,58
3500	3,66	7,33	9,15	14,65	18,31	22,89	27,46	32,97	36,61	45,76	54,92	64,07
4000	4,19	8,37	10,46	16,75	20,92	26,16	31,38	37,68	41,84	52,33	62,76	73,22
4500	4,7	9,42	11,77	18,84	23,54	29,43	35,3	42,4	47,07	58,84	70,61	82,43
5000	5,23	10,47	13,08	20,93	26,15	32,7	39,23	47,1	52,33	65,38	78,5	-
5400	5,65	11,3	14,12	22,94	28,24	35,31	42,36	50,67	56,48	70,61	84,78	-
6000	6,28	12,56	15,69	25,12	31,38	39,24	47,07	56,52	62,76	78,5	-	-
7000	7,33	14,66	18,31	29,31	36,61	45,78	54,92	65,94	73,22	91,58	-	-
8000	8,37	16,75	20,92	33,94	41,48	52,32	62,76	75,36	83,73	-	-	-
9000	9,42	18,84	23,54	37,68	47,07	58,86	70,61	84,78	94,2	-	-	-
10000	10,47	20,93	26,17	41,86	52,33	65,4	78,5	94,2	-	-	-	-
12500	13,08	26,17	32,71	52,33	65,42	81,75	98,13	-	-	-	-	-
15000	15,7	31,4	39,25	62,8	-	-	-	-	-	-	-	-
17500	18,32	36,63	45,79	73,26	-	-	-	-	-	-	-	-
20000	20,93	41,87	52,33	83,73	-	-	-	-	-	-	-	-
22500	23,55	47,1	58,88	94,2	-	-	-	-	-	-	-	-
25000	26,17	52,33	65,42	104,66	-	-	-	-	-	-	-	-

HOW TO READ THIS TABLE

Select your brush diameter, then move down until you reach desirable peripheral speed in m/s, after check on the left side of the table the value for the RPM. Check on page 377 the maximum operating speed per type of brush.

MAXIMUM OPERATING SPEED

TYPE	DIAMETER (mm)	MAX RPM	TYPE	DIAMETER (mm)	MAX RPM
 WHEEL BRUSHES	80	10000	 BEVEL BRUSHES	100	11000
	100	8000		100/115	11000
	125	6000		115	10000
	150	6000	 TWIST KNOTTED WHEEL BRUSHES	100	11000
	180	6000		115	11000
	200	4500		125	10000
	250	3600		150/180	8500
	250 - 1 row	3500		200	6500
	300	3000		20	20000
 CUP BRUSHES	60/65/75	11000	 SHAFT MOUNTED WIRE BRUSHES	30	20000
	60/65/75	11000		40	18000
	60/65/75	10000		50	15000
	75	9300		60	15000
	80/100	8500		70	15000
	125/150	6500		80	12000

The maximum RPM ratings are safety ratings not recommended operating speeds. The optimum operating speed is determined by the application and in most cases lower operating speeds will prove more efficient and achieve the best result. As a general guide we recommend the following peripheral speeds when working on the materials listed with:

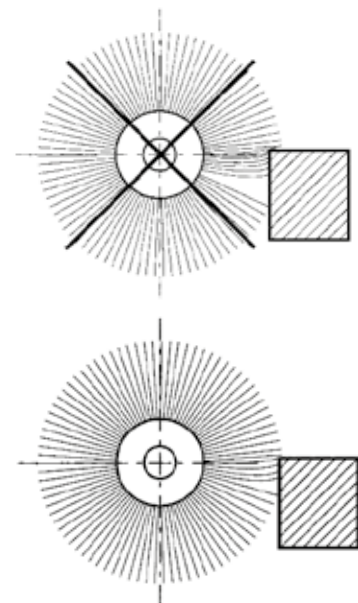
APPLICATION	CRIMPED WIRE	TWIST KNOTTED
STEEL	30m/s	35-40m/s
NON-FERROUS	18-20m/s	-
PLASTIC	15m/s	-

BRUSHING PRESSURE

- Let the tip of the wire brush do the work. Operate the brush with the lightest pressure so only the tips of the wire come in contact with the work
- If heavy pressure is used, wires will be over stressed, resulting in a wiping action, and if this is continued, the life of the brush will be shortened due to wire fatigue
- Apply the work to the face of the brush ensuring as much of the brush face as possible is in full contact. Applying the work to the side or edge of the brushing tool will result in wire breakage and shortened brush life
- Reversing the wheel brush rotation periodically will tend to increase the life of the brush. This results in the sharpening of the wire tips or ends, ensuring faster cutting action

SIZE OF WIRE

- Use the finest size of wire suitable for the application
- Finer wire size will perform better and last longer than heavier



TROUBLESHOOTING

Several factors can influence a brush application. If the selected brush does not achieve the expected result, the following table may provide solutions for the most common problems faced by a user.

For further information, please contact our technical department.

PROBLEM	RECOMMENDED ACTIONS
Brush is too aggressive	Increase trim length
	Reduce wire diameter
	Reduce operating speed
Brush is not aggressive enough	Reduce trim length
	Increase wire diameter
	Increase operating speed
Action of brush does not totally remove scale	Reduce trim length
	Increase wire diameter
Finish is too coarse	Increase trim length
	Reduce wire diameter
	Increase operating speed
	Choose a nylon abrasive brush
Finish is too smooth	Reduce trim length
	Increase wire diameter
Action of brush is not uniform	Reduce brushing pressure
	Automate operations to avoid human inaccuracy
Wire breaks more than usual	Reduce brushing pressure
	Reduce wire diameter
	Reduce operating speed
Life of the brush is too short	Reduce wire diameter
	Increase brush diameter
	Reduce brushing pressure

SAFETY & STORAGE

Safety goggles or full face protection with side shields must be worn by all operators and others in the immediate area of power brush operations.

- Keep all machine guards in place
- Observe all speed restrictions indicated on brushes
- Appropriate protective clothing and equipment must be used
- Brushes should be carefully checked when removed from the original carton. Do not use if rusted or damaged
- Store brushes in the original carton. Wire brushes should not be exposed to heat, high humidity, acids, fumes or liquids that can result in deterioration of the wire filaments, and subsequently, premature failure of the wires. Also, check for distortion of brush fill that can cause imbalance and excessive vibration when the brush is running
- Check maximum spindle speed. Do not mount and operate the brush if spindle RPM exceeds the maximum safe free speed for which the brush is rated. Spindle length should be sufficient to permit a full nut mounting
- Before starting the machine, rotate the wire brush with a gloved hand to determine that the brush has been correctly mounted and turns freely



NORTON NORBEVEL

Norton provides cutting heads for bevelling and rounding metal, designed to be used with electric and pneumatic machines to make light work of heavy duty bevelling and radius work, up to a depth of 12mm.

FOR **BEVELLING**, NORBEVEL PROVIDES:

BETTER WORKING CONDITIONS

Lightweight and almost vibration-free. The chips are large enough to immediately drop to the ground. No hazardous dust particles and/or combustion gases are released.

A MORE CONSISTENT AND ACCURATE ANGLE

NorBevel-6 and NorBevel-12 machines provide a more consistent and accurate angle to the metal for a stronger welded joint.

A MACHINE QUALITY FINISH WITHOUT CONTAMINATION

A better quality weld joint is created through reduced encapsulation of impurities in the weld, as NorBevel does not contaminate the metal.

SPEED AND FLEXIBILITY

Approximately 1,2m of bevelling can be done in one minute. In a matter of seconds, the machine can be adjusted and the bevel heads replaced.

NO FINISHING AND NO DISCOLORATION

A perfect end result straight away, without finishing. Discoloration is prevented through reduced-sparking that adds hardly any heat to the material.

FOR **ROUNDING**, NORBEVEL PROVIDES:

UNIFORM QUALITY

A larger bonding surface is created for paint and coatings due to the uniform radius. Cable feed glands are no longer required to prevent chafing when feeding through cables, wiring and/or piping.

A QUALITY FINISH

Only with NorBevel you can quickly achieve high levels of constant quality when rounding metal.

SPEED AND FLEXIBILITY

Rounding small openings from a diameter of 18 mm is easy due to the compact and lightweight machine design. Rounding metal now has an unprecedented degree of flexibility.




For NorBevel machines, please get in touch with your Norton sales representative to find the latest solution for your application.



NORTON NORBEVEL-12 RANGE

The NorBevel 12 cutting heads have been designed for heavy duty bevelling and radius work up to a depth of 12mm. All heads can be used on the Norton NorBevel EBA-12 and ABA-12 machines which are adjustable for adapting bevelling depth.

HEADS FOR NORBEVEL-12 FOR ELECTRIC AND PNEUMATIC MACHINES

MAX DEPTH (mm)	RADIUS / ANGLE	PK QTY	LASER-CUT STEEL & STAINLESS STEEL	STEEL	ALUMINIUM, PLASTIC, BRASS & SOFT METALS
 8mm	R2	1	66261136479	66261107707	66261113318
	R3	1	66261136480	66261107799	66261113319
	R4	1	-	66261107801	66261113320
	R5	1	66261152485*	-	-
	R8	1	66261152489*	-	66261152484
 8mm	30°	1	66261146205	66261107805	66261113321
	45°	1	66261136503	66261107809	66261113323
 12mm	30°	1	66261146212	66261107841	66261146169
	45°	1	66261146216	66261107844	66261146171
	60°	1	-	66261107845	-

* Made-to-order



Recommended maximum cut depth
is 4mm per pass







NORTON NORBEVEL- 6 RANGE

For lighter bevelling and rounding to a depth of 6mm the cutting heads have been designed for heavy duty bevelling and radius work up to a depth of 12mm. All heads can be used on the Norton NorBevel EBA-12 and ABA-12 machines which are adjustable for adapting bevelling depth.

HEADS FOR NORBEVEL-06 FOR ELECTRIC AND PNEUMATIC MACHINES

MAX DEPTH (mm)	RADIUS / ANGLE	PK QTY	LASER-CUT STEEL & STAINLESS STEEL	STEEL	ALUMINIUM, PLASTIC, BRASS & SOFT METALS
	R2	1	66261136486	66261107851	66261113306
	R3	1	66261136502	66261107852	66261113309
	R4	1	66261146174	66261107853	66261113310
	30°	1	66261146179	66261107856	66261113311
	45°	1	66261136504	66261107858	66261113312
	60°	1	-	66261107859	-



Recommended maximum cut depth
is 4mm per pass



STEEL WOOL

For cleaning a variety of materials and highlighting and rubbing wood. Washable and reusable. Won't rust, shred or splinter. Compatible with water based finishes.

STANDARD

- Made from strands of ultra-fine steel filaments
- Can be used with a chemical stripper
- For use on wood, paint, metal, stone, marble and glass
- Ideal for cleaning and fine finishing



WEIGHT	GRADE	PK QTY	ART NO.
1kg	0000	12	63642593149
1kg	000	12	63642593151
1kg	00	12	63642593153
1kg	0	12	63642593154

