FINISH STRONG

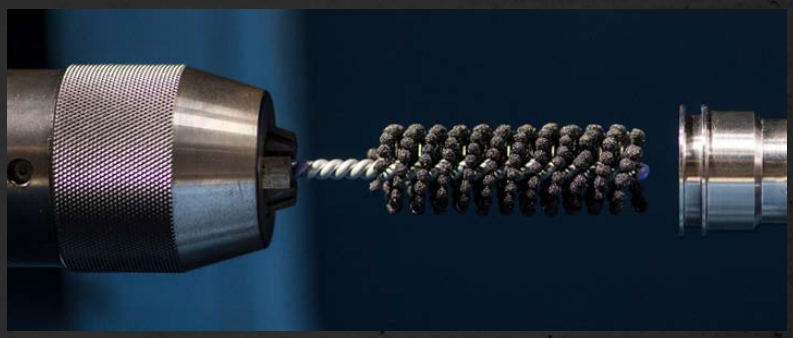
BRM
BRUSH RESEARCH MANUFACTURING

FLEX-HONE® NEW 10-PIECE FINISHING STARTER KIT

The Flex-Hone® Tool is a resilient, flexible, honing tool with a soft cutting action. Ideal for cross hole deburring, this low RPM tool can be mounted in any rotating spindle to improve your finishing process. Additional sizes, grits and abrasive types are available upon request to suit your application needs.

INCLUDED IN THE KIT :

+ For bore diameters: 1/4", 3/8",1/2", 5/8", 3/4",7/8", 1", 1-1/4", 1-1/2", 2" + Flex-Hone Oil, BRM hat, flash drive with instructional information and BRM sticker.



PRICE: $183.06

FLEX-HONE® 10-PIECE FINISHING KIT FOR MILD STEEL, STAINLESS STEEL AND CAST IRON

Mfg Part #: BCKFIN24 (10PC 240 GRIT SILICON CARBIDE)

240 grit generally provides an Ra Finish range of 24-32 (.6 – .8 Micrometer)

PRICE: $233.93

FLEX-HONE® 10-PIECE FINISHING KIT FOR ALUMINUM, BRASS, BRONZE AND SOFTER METALS

Mfg Part #: BCKFIN240AO (10PC 240 GRIT ALUMINUM OXIDE)

240 grit generally provides an Ra Finish range of 24-32 (.6 – .8 Micrometer)

PRICE: $326.94

FLEX-HONE® 10-PIECE FINISHING KIT FOR MILD STEEL, STAINLESS STEEL AND CAST IRON

Mfg Part #: BCKFIN600 (10PC 600 GRIT SILICON CARBIDE)

600 grit generally provides an Ra Finish range of 8-12 (.2 – .3 Micrometer)

PRICE: $326.94

FLEX-HONE® 10-PIECE FINISHING KIT FOR ALUMINUM, BRASS, BRONZE AND SOFTER METALS

Mfg Part #: BCKFIN600AO (10PC 600 GRIT ALUMINUM OXIDE)

600 grit generally provides an Ra Finish range of 8-12 (.2 – .3 Micrometer)

MADE IN USA

AT LEAST 10% SAVINGS OVER BUYING INDIVDUALLY

FLEX-HONE FINISHING KIT

4642 FLORAL DRIVE, LOS ANGELES, CA 90022 P: 323-261-2193 F: 323-268-6587 EMAIL: SALES@BRUSHRESEARCH.COM

GRIT SELECTION

FLEX-HONE®

The amount of work to be performed and the degree of surface finish improvement required govern grit selection. Coarse finishes may require progressively finer Flex-Hones to meet final surface finish requirements. In very general terms, final finish will be in the following ranges. This chart is intended to offer a starting point in selecting a grit but the final selection must be verified by actual trial.

GRIT	FINISH RANGE
800-LA (2500 MESH)	Ra 3-10 (.05 – .2 Micrometer)
600	Ra 8-12 (.2 – .3 Micrometer)
400 (800 MESH)	Ra 10-20 (.3 – .6 Micrometer)
320	Ra 18-30 (.5 – .7 Micrometer)
240	Ra 24-32 (.6 – .8 Micrometer)
180 (170/200 MESH)	Ra 30-40 (.7 – 1.0 Micrometer)
120	Ra 35-50 (.9 –1.4 Micrometer)
80	Ra 45-64 (1.2 – 1.6 Micrometer)
60	Ra 60-80 (1.5 – 2 Micrometer)
40	Ra 70-125 (1.7 – 3.2 Micrometer)
20	Ra 125-250 (3.2 – 6.3 Micrometer)

Grit Type

Color Marked on Tip of Hone

ABRASIVE/GRIT OPTIONS

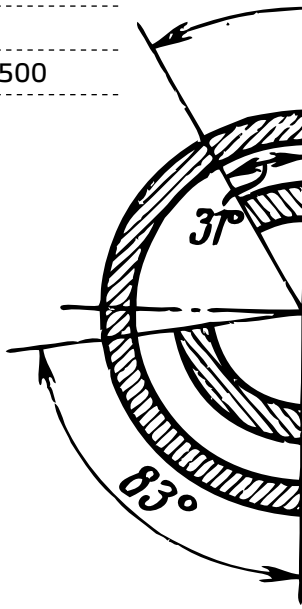
ABRASIVE TYPES	GRIT SIZES 20	40	60	80	120	180	240	320	400	600	800
SC = Silicon Carbide	X	X	X	X	STANDARD				X	X	X
AO = Aluminum Oxide	X	X	X	X	X	X	X	X	X	X	X
BC = Boron Carbide	X	X	X	X	X	X	X	X	X	X	X
Z Grain - Alumina Zirconia No. 1525 (25% Zirconia/75% Alumina)			X	X	X	X	X				
Z Grain - Alumina Zirconia No. 1549 (40% Zirconia/60% Alumina)					X	X	X				
Diamond	Diamond is available in mesh 170/200, 800 and 2500										
Levigated Alumina	Available in extra fine grit only										
CBN	Available in mesh 170/200, 800, 2500										
Ceramic	Available on special order										

SUGGESTED RPM

The Flex-Hone Tool is a low RPM tool. Specific RPM is dependent on the diameter of the tool and the application. General speed ranges are given but, again, machine trials are required to verify the parameters.

The smaller the hone, the faster the speed. The larger the hone, the slower the speed.

HONE DIA.	RPM
Hone Dia.	RPM
19" to 36"	60 –120 RPM
12" to 18"	125 – 200 RPM
8" to 11"	225 – 300 RPM
4" to 7 ½"	350 – 600 RPM
2" to 3 ¾"	600 – 900 RPM
½" to 2"	900 – 1,000 RPM
4mm to ½"	1,000 –1,200 RPM



***Additional sizes (4mm-36"), abrasives and grits sold individually upon request.**

The Flex-Hone Tool should be securely held in a collet, chuck, or similar holding device. It is best to use the shortest shank possible for your application. The tool should be well coated with lubricant and rotating prior to entry and should continue rotating until fully removed from the part. When deburring cross drilled holes using the Flex-Hone, it is helpful to first stroke and rotate the tool in a clockwise direction and then remove the tool from the bore, reverse the spindle and then stroke and rotate in a counterclockwise direction. This promotes a symmetrical deburring pattern.