

Flexible Hone-Brushes



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Lessmann Hone-Brushes are used to improve the inner surface of tubes, bores and cylinder walls. They are equally suitable for burr removal, cleaning and surface finishing.

Thanks to the elasticity and flexibility of the filling, they can also deburr cross bores, openings and channels in the same operation.

At the same time, the use of honing brushes produces a so-called cross cut, which is created by the simultaneous rotation during back and forth movements of the brush while processing. This structure ensures less friction and more even distribution of oil on the surface.



Example of the cross cut produced during honing.

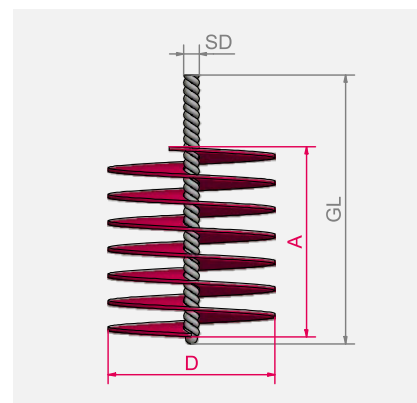
Mechanical Application

Only use the brush with the indicated maximal peripheral speed (RPM max.). The max. RPM only is allowed when the brush is clamped min. for 10 mm into the tool. When the brush is inserted into the suitable work piece, higher RPMs are possible. **Only use the brush right rotating.**



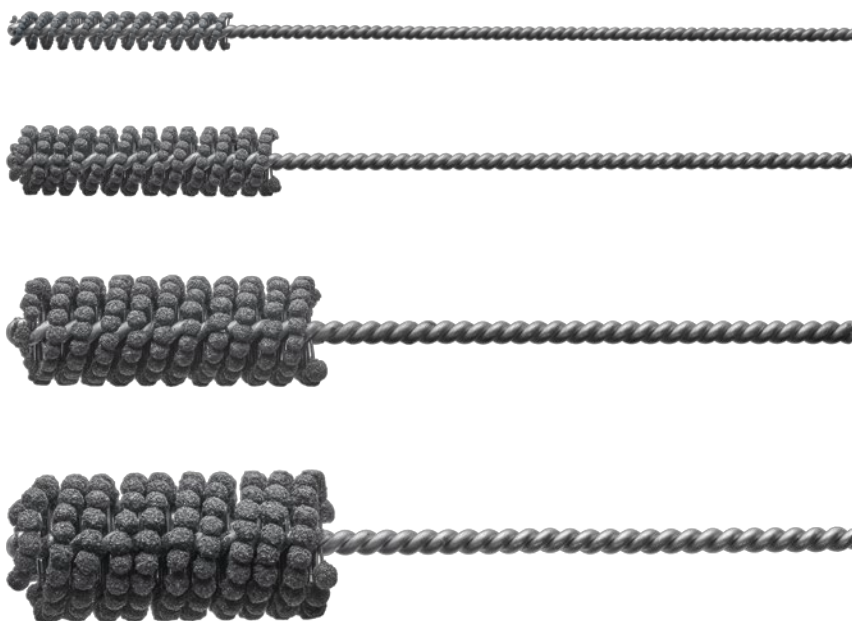
Attention!

When using hone-brushes, we recommend to always use a suitable lubricant (oil or drilling emulsion).



Item Nos. in bold are available ex stock. Consider our minimum order value for *italic printed* article numbers (see page 184).

SIC = silicon carbide bristles



Flexible Hone-Brushes IBFH, abrasive silicon carbide bristles

D	max. pipe Ø	GL	A	SD	RPM	Pack.	SIC K120	SIC K180
mm inch	mm inch	mm inch	mm inch	mm	max.		Art.-Nr.	Art.-Nr.
5,5 $\frac{3}{16}$	5 $\frac{3}{16}$	200 8	40 $1 \frac{9}{16}$	2,1	1.200	1		591.310.55
6,5 $\frac{1}{4}$	5,5 $\frac{3}{16}$	200 8	40 $1 \frac{9}{16}$	2,5	1.200	1	591.210.65	591.310.65
7 $\frac{1}{4}$	6 $\frac{1}{4}$	200 8	40 $1 \frac{9}{16}$	2,5	1.200	1	591.210.70	591.310.70
8 $\frac{5}{16}$	7 $\frac{1}{4}$	200 8	50 2	3,6	1.200	1	591.210.80	591.310.80
9 $\frac{3}{8}$	8 $\frac{5}{16}$	200 8	50 2	3,6	1.200	1	591.210.90	591.310.90
10 $\frac{3}{8}$	9 $\frac{3}{8}$	200 8	50 2	3,6	1.200	1	591.211.00	591.311.00
11 $\frac{7}{16}$	10 $\frac{3}{8}$	200 8	60 $2 \frac{3}{8}$	3,6	1.200	1	591.211.10	591.311.10
12 $\frac{1}{2}$	11 $\frac{7}{16}$	200 8	60 $2 \frac{3}{8}$	3,6	1.200	1	591.211.20	591.311.20
13 $\frac{1}{2}$	12 $\frac{1}{2}$	200 8	60 $2 \frac{3}{8}$	3,6	1.200	1	591.211.30	591.311.30
15,5 $\frac{5}{8}$	13 $\frac{1}{2}$	200 8	60 $2 \frac{3}{8}$	3,6	1.200	1	591.211.55	591.311.55
18 $\frac{11}{16}$	16 $\frac{5}{8}$	200 8	60 $2 \frac{3}{8}$	4,6	1.200	1	591.211.80	591.311.80
20 $\frac{13}{16}$	18 $\frac{11}{16}$	200 8	60 $2 \frac{3}{8}$	4,6	1.200	1	591.212.00	591.312.00
22 $\frac{7}{8}$	20 $\frac{13}{16}$	200 8	70 $2 \frac{3}{4}$	4,6	1.200	1	591.212.20	591.312.20
25 1	22 $\frac{7}{8}$	200 8	70 $2 \frac{3}{4}$	4,6	1.200	1	591.212.50	591.312.50
27 $1 \frac{1}{16}$	24 $\frac{15}{16}$	200 8	70 $2 \frac{3}{4}$	5,1	1.200	1	591.212.70	591.312.70
28 $1 \frac{1}{8}$	25 1	200 8	70 $2 \frac{3}{4}$	5,1	1.200	1	591.212.80	591.312.80
30 $1 \frac{3}{16}$	27 $1 \frac{1}{16}$	200 8	70 $2 \frac{3}{4}$	5,1	1.200	1	591.213.00	591.313.00
32 $1 \frac{1}{4}$	29 $1 \frac{1}{8}$	200 8	70 $2 \frac{3}{4}$	5,1	1.200	1	591.213.20	591.313.20
35 $1 \frac{3}{8}$	32 $1 \frac{1}{4}$	200 8	70 $2 \frac{3}{4}$	5,7	1.200	1	591.213.50	591.313.50
38 $1 \frac{1}{2}$	35 $1 \frac{3}{8}$	200 8	70 $2 \frac{3}{4}$	5,7	1.200	1	591.213.80	591.313.80
41 $1 \frac{5}{8}$	38 $1 \frac{1}{2}$	200 8	70 $2 \frac{3}{4}$	5,7	800	1	591.214.10	591.314.10
45 $1 \frac{3}{4}$	41 $1 \frac{5}{8}$	200 8	70 $2 \frac{3}{4}$	5,7	800	1	591.214.50	591.314.50
48 $1 \frac{7}{8}$	45 $1 \frac{3}{4}$	200 8	70 $2 \frac{3}{4}$	5,7	800	1	591.214.80	591.314.80
51 2	48 $1 \frac{7}{8}$	200 8	70 $2 \frac{3}{4}$	6,5	800	1	591.215.10	591.315.10
54 $2 \frac{1}{8}$	51 2	200 8	70 $2 \frac{3}{4}$	6,5	800	1	591.215.40	591.315.40
57 $2 \frac{1}{4}$	54 $2 \frac{1}{8}$	200 8	70 $2 \frac{3}{4}$	7,3	800	1	591.215.70	591.315.70
60 $2 \frac{3}{8}$	57 $2 \frac{1}{4}$	200 8	70 $2 \frac{3}{4}$	7,3	800	1	591.216.00	591.316.00
64 $2 \frac{1}{2}$	60 $2 \frac{3}{8}$	200 8	70 $2 \frac{3}{4}$	7,3	800	1	591.216.40	591.316.40