## Twisted Brush Stem Construction

**Single Stem/Single Spiral (SS/SS)**
Filament is twisted between two stem wires with a single layer of filament.

**Double Stem/Single Spiral (DS/SS)**
Filament is twisted between four stem wires, with two stem wires on each side for additional strength and higher density fill.

**Double Stem/Double Spiral (DS/DS)**
Filament is twisted between four stem wires with two layers of bristles. Each layer is perpendicular to the other with a single stem wire in each quadrant. The highest brush density and highest strength twisted wire brush available.

## Brush Tip Styles

**Continuous End**

**Cut off End**

## Operating Recommendations

When mounting a twisted brush in a collet or chuck, it is recommended to minimize the overhang of the stem to under an inch. This is particularly true with power tube brushes, and it is important to avoid any load conditions and operating speeds that can cause stem deflections and destructive bending. A safe operating speed from 100-500 RPM is recommended for most twisted brushes.

To reach into deeper holes we recommend the use of collet-ready shank mounted brushes or drill extension rods rather than increasing stem overhang.

## Before Starting the Twist Brush Rotation

- Secure the brush in the chuck.
- Ensure clockwise brush rotation—counter clockwise rotation can cause the brush to come apart and release the filament.
- Securely clamp the workpiece. Make sure all machine guards are in position.
- Align the brush with the workpiece to ensure the brush rotates on its true center line and avoid stem deflection.
- Guide the brush into the hole before starting the brush rotation.
- Always wear eye protection and protective clothing!

## Other Considerations:

**Wire Options**
- Coated
- Galvanized
- Stainless Steel

**Filament Options**
- Abrasive Nylon
- CeramiX®
- Brass
- Carbon Steel
- Horse Hair
- Nylon
- Stainless Steel
- Crimped, Level or Color Options

**Gauge**
- Stem Diameter

**Other**
- Shank Type
- Tubing
- Coupling
- Loop
- No Loop

## Twist Brush Terminology