

CROSSFLEX

HONING BRUSHES

CROSSFLEX™

Cross hole deburring and honing solutions for off-hand and automated applications.

800.835.9999 / weilerabrasives.com



CROSSFLEX HONING BRUSHES

CrossFlex offers machinists the right combination of performance and value for professional honing applications. Flexible filaments provide the correct pressure to create an ideal hone; one bore after another. It's the ideal tool to create cross-hatch patterns for improved oil retention and increased part efficiency. The strong self-centering system leaves a smooth, even surface finish free of metal burrs whether used in a manual or automated application.



Deburring cross holes in a firearms component.

No matter what type or size cylinder, Weiler's CrossFlex brushes deliver the options you need to solve your toughest deburring and honing challenges.

FEATURES & BENEFITS:

- **Desired Finish** – CrossFlex offers a wide range of grits and sizes allowing machinists to achieve the desired finish.
- **Heavy Burr Removal** – Increased brush to part contact ensures that the heaviest burrs will be removed, outperforming standard nylon tube brushes.
- **Long Life** – CrossFlex brushes have a long operational life, lowering total cost of use compared to other brush options.
- **Flexible Nylon Stems** – Distribute pressure evenly and self centers within the part to create an ideal hone.
- **Consistent Cross Hatch Pattern** – Helps to seat piston rings and retains oil for lubrication in a combustion cylinder.
- **Collet Ready Brushes** – Deliver a true center rotation and exceptional brush balance for automated applications or hand held use.

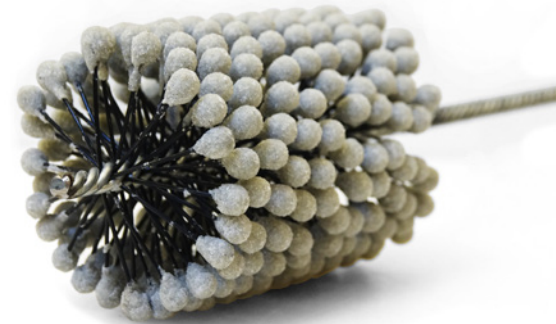
SPECIALTY BRUSHES

Weiler understands that not all your finishing or deburring applications have a standard solution. For instances where applications require unique sizes, lengths or abrasives; Weiler Process Solutions (WPS) specialists work with you to provide custom CrossFlex brushes for your specific application.

- Custom sized for your specific bore diameters
- Brushes with shorter or longer stems for your particular application
- Collet ready or other connection methods
- Options in a variety of abrasives including **silicon carbide, aluminum oxide, zirconia alumina** and **ceramic** grains

WPS An application engineering program designed to provide Weiler customers with engineering support to identify value added opportunities in their processes.

To learn more about Weiler's specialty solutions go to: weilerabrasives.com/weilerprocesssolutions



Custom large diameter ceramic CrossFlex brush.



Deburring mounting holes on a machined component.

CROSSFLEX ABRASIVE GRITS: Every individual brush end tip is colored to indicate the grit of that brush.



SMALL DIAMETER CROSSFLEX HONING BRUSHES

Silicon carbide cross-honing brushes for standard use. Ideal for deburring small diameter cross hole intersections.



For Hole Sizes in Inches	For Hole Sizes in mm	Length of Brush Part	Overall Length	Shank Diameter	Max RPM	120 Grit Item No.	180 Grit Item No.	240 Grit Item No.	320 Grit Item No.
0.177"	4.5 mm	0.787"	6"	0.083"	1,000	—	34105	34106	34107
0.1857"	4.7625 mm					—	34108	34109	34110
0.197"	5 mm	1.575"	7.875"	0.098"	900	34111	34112	34113	34114
0.217"	5.5 mm					34115	34116	34117	34118
0.236"	6 mm					34119	34120	34121	34122
0.25"	6.35 mm					34123	34124	34125	34126
0.276"	7 mm					34127	34128	34129	34130
0.315"	8 mm	1.969"		0.13"		34131	34133	34134	34135
0.354"	9 mm					34136	34137	34138	34139
0.375"	9.5 mm					34141	34142	34143	34144
0.394"	10 mm					34145	34146	34147	34148
0.433"	11 mm					34149	34150	34151	34152
0.472"	12 mm					34153	34154	34155	34156
0.5"	12.7 mm					34158	34159	34160	34161
0.552"	14 mm					34162	34163	34164	34165
0.625"	16 mm					34166	34167	34168	34169
0.709"	18 mm					34170	34171	34172	34173
0.75"	19mm	2.48"		0.157"		34174	34175	34176	34177
0.787"	20 mm					34178	34179	34180	34181
0.875"	22 mm					34182	34183	34184	34185
0.9375"	23.8 mm					34186	34187	34188	34189
						3"		0.213"	



COLLET READY – SMALL DIAMETER CROSSFLEX HONING BRUSHES

Silicon carbide cross-honing brushes for standard use within automated applications and to reduced brush run-out.



For Hole Sizes in Inches	For Hole Sizes in mm	Length of Brush Part	Overall Length	Shaft Diameter	Max RPM	120 Grit Item No.	180 Grit Item No.	240 Grit Item No.	320 Grit Item No.
0.177"	4.5 mm	0.75"	6"	5/32"	1,000	—	34298	34299	34359
0.188"	4.763 mm					—	34300	34301	34302
0.197"	5 mm	1.5"	7.875"	1/4"	900	34303	34304	34305	34306
0.217"	5.5 mm					34307	34308	34309	34310
0.236"	6 mm					34311	34312	34313	34314
0.25"	6.35 mm					34315	34316	34317	34318
0.276"	7 mm					34319	34320	34321	34322
0.315"	8 mm	2"		8 mm		34323	34324	34325	34326
0.354"	9 mm					34327	34328	34329	34330
0.375"	9.5 mm					34331	34332	34333	34334
0.394"	10 mm					34335	34336	34337	34338
0.433"	11 mm					34339	34340	34341	34342
0.472"	12 mm					34343	34344	34345	34346
0.5"	12.7 mm					34347	34348	34349	34350
0.552"	14 mm					34351	34352	34353	34354
0.625"	16 mm					34355	34356	34357	34358



COLLET READY BENEFITS FOR SMALL DIAMETER BRUSHES:

- Reduces brush run-out
- Strengthens and sturdies brush shaft for better stability and overall reach
- Strong positive engagement with tool holder



Collet ready CrossFlex brush in a CNC machine.

MEDIUM DIAMETER CROSSFLEX HONING BRUSHES

Silicon carbide cross-honing brushes for standard use. Ideal for changing the surface finish in machined bores and deburring the ID of castings.



For Hole Sizes in Inches	For Hole Sizes in mm	Length of Brush Part	Overall Length	Shank Diameter	Max RPM	120 Grit Item No.	180 Grit Item No.	240 Grit Item No.	320 Grit Item No.
1"	25.4 mm	3"	7.875"	0.213"	900	34190	34191	34192	34193
1.125"	29 mm			0.224"	800	34194	34195	34196	34197
1.25"	31.8 mm			0.252"	341989	34199	34200	34201	
1.375"	35 mm			34202	34203	34204	34205		
1.5"	38 mm			34206	34207	34208	34209		
1.625"	41 mm			34210	34211	34212	34213		
1.75"	45 mm			34214	34215	34216	34217		
1.875"	47.6 mm			34218	34219	34220	34221		
2"	51 mm			34222	34223	34224	34225		
2.125"	54 mm			0.283"	700	34226	34227	34228	34229
2.25"	57 mm					34230	34231	34232	34233
2.375"	60 mm					34234	34235	34236	34237
2.5"	64 mm					34238	34239	34240	34241
2.625"	67 mm					34242	34243	34244	34245
2.75"	70 mm	34246	34247			34248	34249		
2.875"	73 mm	34250	34251			34252	34253		
3"	76 mm	34254	34255			34256	34257		

HEAVY-DUTY MEDIUM DIAMETER CROSSFLEX HONING BRUSHES

Silicon carbide cross-honing brushes for heavy-duty use. Ideal for changing the surface finish in machined bores and deburring the ID of castings.

For Hole Sizes in Inches	For Hole Sizes in mm	Length of Brush Part	Overall Length	Shank Diameter	Max RPM	120 Grit Item No.	180 Grit Item No.	240 Grit Item No.	320 Grit Item No.
3"	76 mm	5.5"	13.5"	0.311"	700	34258	34259	34260	34261
3.25"	83 mm					34262	34263	34264	34265
3.5"	89 mm					34266	34267	34268	34269

HEAVY-DUTY LARGE DIAMETER CROSSFLEX HONING BRUSHES

Silicon carbide cross-honing brushes for heavy-duty use. Ideal for cross hatching in combustion cylinders.

For Hole Sizes in Inches	For Hole Sizes in mm	Length of Brush Part	Overall Length	Shank Diameter	Max RPM	120 Grit Item No.	180 Grit Item No.	240 Grit Item No.	320 Grit Item No.
3.75"	95 mm	5.5"	13.5"	0.311"	700	34270	34271	34272	34273
4"	101 mm	6.5"		0.346	600	34274	34275	34276	34277
4.25"	108 mm	18"	18"	0.402"		34278	34279	34280	34281
4.5"	114 mm					34282	34283	34284	34285
5"	127 mm					34286	34287	34288	34289
5.5"	140 mm					34290	34291	34292	34293
6"	152 mm					34294	34295	34296	34297



34208



34257



34274



34294



Cleaning burrs out of an automotive head port.

