



ATB[®]

Advanced Technology Brush

Osborn worldwide.



Osborn offers the best solutions for your mechanical surface treatment challenges. Our experts are highly trained to serve you with the best off-the-shelf or customized tools, when and where you need them. Unlike others, we help you optimize your process, meet the highest quality and safety requirements and reduce your costs.

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High-Tech Brushes for Automated Deburring.



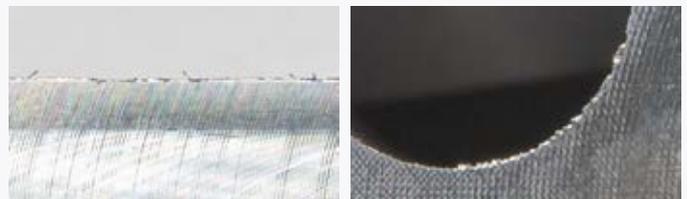
Edge rounding without changing the workpiece geometry.

Technical brushes are precision tools that take a major part of the responsibility for the quality of end products. They can be tailored to virtually any material processed in a component-oriented manner.

Our ATB® brushes are available to you with a large selection of abrasive bristles having silicone carbide or ceramic filament, with different grit sizes and filament diameters.

ATB® brushes are designed for direct adaption on tool holders with face mill arbors (DIN 6357) and shell mill mounts (DIN 6358). This means they can be used on machining centres, CNC millers & lathes and robot cells for example.

Brushes are deployed downstream of the machining process, and the use of cooling lubricants, emulsions and water poses no problems. This means the processed work pieces can be directly deburred and finished in a reliable and reproducible manner without reclamping on the machine.



Before processing - Distinct burrs on the edge. Milling grooves on the surface.



After processing - Burrs have been reliably removed and the edges rounded. The surface has a uniform, brushed appearance.

Deburring Directly After the Machining Process.



ATB® brushes are non-cutting tools.

ATB® brushes are non-cutting tools. They are used mainly for removing burrs and secondary burrs generated in the upstream machining process. The surface textures of components are positively influenced at the same time.

Deburring directly after the machining process

Shorter cycle times and very uniform edge rounding, and so particularly suited for the deburring of:

- Milled and turned parts
- Ground components
- Sinter parts
- Punched, moulded and pressed parts
- Pneumatic and hydraulic parts
- Engine components such as cylinder heads and cylinder blocks
- Die-cast parts
- Valve plates
- Parts ground flat
- Toothed parts
- Contact and sealing surfaces
- Finishes

Maximum filament density Minimum process costs

ATB® brushes have filament densities four times higher than disc brushes manufactured in the conventional way (punched). This means brush life is prolonged many times over - with at the same time quicker processing times and better and more efficient deburring results. Features:

- Bristles are securely casted
- Extremely dense filament surface
- Planar filament surface
- High abrasive grit content for effective deburring
- High levels of form stability and concentricity
- Aggressive brushing effect
- Can be tailored to any material processed
- Use with coolant possible/recommended
- Standardised face mill arbors and shell mill mounts
- Can be used on the same machining center/CNC machine directly after the upstream machining process

Features and Benefits at a Glance.



Many diameters and patterns

A wide range of diameters are available. In addition, both the fill length and the fill pattern can be individually adapted.

Benefit: With our individualized options, we can find you the best solution for your deburring application. An increase in the fill length can, for example, increase the service life and flexibility in order to deburr challenging components. Changing the fill pattern can increase the aggressiveness depending on the need.

Direct adaptation to tool holders

For example HSK-/SK, face mill arbors and shell mill mounts.

Benefit: No separate handling/clamping. The ATB® brush can be stored in the tool magazine of the BAZ / CNC, deburring can be started immediately after the machining process without removing the part.



1. Resin cast body

The fill material is firmly cast into the bodies of our ATB®.

Benefit: ATB® can be run faster while maintaining its fill integrity, highly precise design with a high level of tilting rigidity while remaining lightweight.

3. High tech filaments

Nylon threads interspersed with abrasive grit (e.g. silicon carbide or ceramic) are the ideal fill material for deburring. Other materials are also available on request (e.g. diamond grain).

Benefit: The use in combination with coolants, emulsions or water is possible and is recommended especially for higher speeds and very thin workpieces.

2. Maximum bristle density

A maximum filament density with up to 4 times more bristles.

Benefit: Longer service life, more aggressive brushing action. Even very complex components can be deburred quickly and effectively.

4. Dimensionally stable and flat

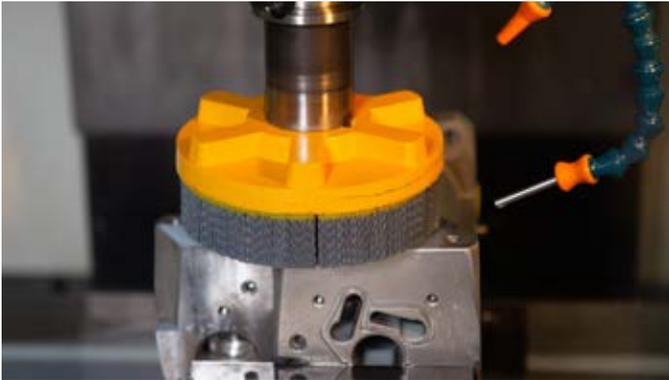
The surface of ATB® is flat.

Benefit: Even edge rounding can be achieved, wear characteristics are consistent and controllable. There is uniform contact and repeatability.

Sample and Parts Processing

If you are unsure whether you have already found the ideal tool for your industrial machining process, we recommend our parts and sample processing service. This is an excellent opportunity to put the quality of your tools currently in use to the test and, if necessary, replace them with a tool that is more suitable for the application.

We work with you to determine the ideal tools for processing your sample parts. Depending on the task, this may be a standard product or a customized product. We then define the most important parameters for processing the workpiece. Once we have received the sample parts from you and, if applicable, the current tools to be tested, we get to work in our test laboratory.



Deburring Contact Areas

We can process a wide variety of components. For this purpose, the workpiece is put in a clamping device or on a rotary table and can then be processed. Process-relevant parameters such as rotational speed, cutting speed, feeds, immersion depth, etc. can be set and the results are measured.

Documentation

After the parts have been processed, we create a detailed documentation of our inspection results for you. In our report we define the objectives, the test sequence and the conclusions. Based on this evaluation, you can compare the quality of the tools you are currently using with our solutions and make your decision.



Complex Parts

Even complex workpiece geometries are no obstacle. We also manufacture customised solutions for your components.

Put your deburring process to the Test

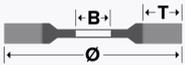
We will be happy to advise you

Our application engineers will be happy to look at your application and help you choose the right tool to ensure that cycle time, processing results and cost per-part are optimized.

Request our parts and sample processing service today: service@osborn.de



Appearance can vary from picture depending on variant.



EUIBWB001 | EVOLUTION ★★★★★

ATB® wheel brush with full trim, Cutter head holders/combined cutter arbor

ATB® wheel brush with longitudinal groove for direct clamping on tool holders (e.g. HSK, SK, BT) as cutter head holders and combi milling arbor holders. Feel free to ask our application engineers about general and specific application questions relating to the ATB® products.

- high density and concentricity
- process safety and high service life
- depending on the workpiece material to be processed, brushes are available with ceramic- (NH-C) and siliciumcarbide-trimming (NH-S)

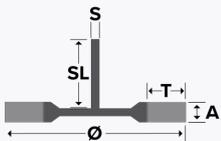
Application: On CNC machines, machining centres and on robot systems. Preferably to be used wet with cooling lubricant or oil. Suitable directly after machining for deburring and edge rounding on components with side and inner surfaces, as well as for fine machining of component contours.

Ø	T	B	B Type	Max. n/min		Silicon Carbide 120	Silicon Carbide 180
125	25	22	round	3500	1	● 2101401913	● 8401401913

Ø	T	B	B Type	Max. n/min		Ceramic 120	Ceramic 180
125	25	22	round	3500	1	● 2111401913	● 2121401913



Appearance can vary from picture depending on variant.



EUIBWB002 | EVOLUTION ★★★★★

ATB® wheel brush with full trim, shank adaption

ATB® wheel brush with shank for direct adaption on several tool holders. Please ask our application technicians for open requests and general questions about the ATB® products.

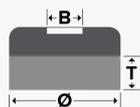
- high density and concentricity
- process safety and high service life
- depending on the workpiece material to be processed, brushes are available with ceramic- (NH-C) and siliciumcarbide-trimming (NH-S)
- high machine compatibility because of the shank adaption
- high flexibility in processing allows several customer specific variations

Application: On CNC machines, machining centres and on robot systems. Preferably to be used wet with cooling lubricant or oil. Suitable directly after machining for deburring and edge rounding on component

Ø	T	A	S	SL	Max. n/min		Silicon Carbide 120
70	12.5	10	6	30	3500	1	● 3601507910
80	17.5	10	6	30	3500	1	● 3601508910
100	27.5	10	6	30	3500	1	● 3601600910



Appearance can vary from picture depending on variant.



EUIBDB001 | EVOLUTION ★★★★★

ATB® disc brushes with maximum fill density, compatible with clamping fixture

Can be used for deburring components made of the most diverse of materials, such as steel, aluminium and cast iron.

Application: For use on machining centers, CNC turning and milling machines and robot cells. For deburring milled, turned and ground components, sintered parts, punched, nipped and pressed parts, pneumatic and hydraulic parts, engine components, toothed parts, etc. Can be used on a wide variety of materials such as steel, aluminium, cast iron, etc.

∅ Body	T	B Type	B	Max. n/min	∅		Silicon Carbide 80	Silicon Carbide 120	Silicon Carbide 180	Silicon Carbide 320
50	35	hexagonal	16	3500	46	1	● 6701604912	● 5411604912	● 5431604912	● 5441604912
76	35	hexagonal	16	3500	70	1	● 3111604913	● 9841604913	● 3311604913	● 3151604913
85	35	hexagonal	16	3500	80	1	● 6201604914	● 1601604914	● 2211604914	● 6231604914
106	35	hexagonal	16	3500	100	1	● 3101604914	● 3221604914	● 3321604914	● 3401604914

∅ Body	T	B Type	B	Max. n/min	∅		Ceramic 80	Ceramic 120	Ceramic 180	Ceramic 320
50	35	hexagonal	16	3500	46	1	● 2201604912	● 1301604912	● 1311604912	
76	35	hexagonal	16	3500	70	1	● 1321604913	● 1331604913		
85	35	hexagonal	16	3500	80	1	● 1341604914	● 1351604914	● 1361604914	
106	35	hexagonal	16	3500	100	1	● 5891604914	● 9901604914	● 4411604914	● 1381604914



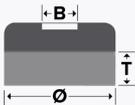
EUIBDB002 | EVOLUTION ★★★★★

ATB® disc brushes with maximum fill density, for tool holders

For deburring sealing and contact surfaces. The application should take place on stationary machines. Use with cooling lubricant, water, oil is recommended.

Application: For deburring sealing and contact surfaces. The application should take place on stationary machines. Use with cooling lubricant, water, oil is recommended.

Appearance can vary from picture depending on variant.

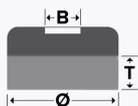


Ø Body	T	B Type	B	Max. n/min		Silicon Carbide 80	Silicon Carbide 120	Silicon Carbide 180	Silicon Carbide 320
125	40	round	18.2	3500	1	● 3101604916	● 3201604916	● 3311604916	● 3401604916
150	40	round	18.2	3500	1	● 3111604916	● 3211604916	● 4341604916	● 3411604916
175	40	round	18.2	3500	1	● 3131604916	● 3231604916		● 3431604916
200	40	round	18.2	3500	1	● 8411604918	● 4021604918	● 5901604918	
250	38	round	18.2	3500	1	● 6511604919	● 6171604916	● 2401604919	

Ø Body	T	B Type	B	Max. n/min		Ceramic 80	Ceramic 120	Ceramic 180	
125	40	round	18.2	3500	1	● 0101604916	● 0201604916	● 0311604916	
150	40	round	18.2	3500	1		● 0211604916	● 0341604916	
200	40	round	18.2	3500	1	● 1611604918	● 0021604918		
250	38	round	18.2	3500	1		● 8771604919		



Appearance can vary from picture depending on variant.



EUIBDB003 | EVOLUTION ★★★★★

ATB® disc brushes with maximum fill density, for shell mill mount

For direct mounting on shell mill holders without need of further clamping set / system.

- For usage on stationary machines
- Usage with cooling lubricant, water or oil is recommended

Application: For the deburring of contact and sealing surfaces, and the functional areas of the most diverse of components.

Ø Body	T	B Type	B	Max. n/min		Silicon Carbide 80	Silicon Carbide 120	Silicon Carbide 180
50	35	round	16	3500	1	● 6601604912	● 6501604912	● 6401604912
76	35	round	16	3500	1	● 6301604913	● 6311604913	● 6321604913
76	35	round	22	3500	1	● 5521604913	● 5511604913	● 5501604913
106	35	round	16	3500	1	● 5431604914	● 5511604914	● 5441604914
106	35	round	22	3500	1	● 5501604914	● 5791604914	● 5521604914
125	35	round	16	3500	1	● 6751604916	● 6801604916	● 6631604916
125	35	round	22	3500	1	● 6721604916	● 6821604916	● 6621604916
125	35	round	27	3500	1	● 6761604916	● 6811604916	● 6641604916
150	35	round	22	3500	1	● 6771604916	● 6841604916	● 6651604916
150	35	round	27	3500	1	● 6781604916	● 6831604916	● 6661604916

Ø Body	T	B Type	B	Max. n/min		Ceramic 80	Ceramic 120	Ceramic 180
50	35	round	16	3500	1		● 1431604912	
76	35	round	22	3500	1	● 1451604913	● 5991604914	● 1461604913
106	35	round	22	3500	1		● 1431604914	
125	35	round	22	3500	1	● 2431604916	● 2441604916	● 2451604916
125	35	round	27	3500	1	● 6991604916	● 2461604916	
150	35	round	22	3500	1	● 1061604916	● 1071604916	



EUIBDB004 | EVOLUTION ★★★★★

ATB® disc brushes with segmented trimming, Turbo-line

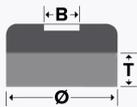
Brushes for use on continuous deburring systems with planetary heads.

- The trim position of ATB® Turbo-Line brushes can optionally be angled to the left or right at a defined angle. Depending on the direction of rotation, this can bring about more aggressive and effective deburring, or can limit the brush to a surface finish only.

Appearance can vary from picture depending on variant.



Application: For use on continuous deburring systems with planetary heads. Used for flat parts that have to be produced and deburred by punching, laser, fine blanking and forming processes.

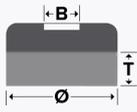


∅ Body	T	B Type	B	Fill Angle	Max. n/min		Silicon Carbide 80	Silicon Carbide 120	Silicon Carbide 180	Silicon Carbide 320
150	25	step	25	left	3500	1	● 3161604916	● 3261604916	● 3371604916	● 3461604916
150	25	step	25	neutral	3500	1	● 3141604916	● 3241604916	● 3351604916	● 3441604916
150	25	step	25	right	3500	1	● 3181604916	● 3281604916	● 3391604916	● 3481604916

∅ Body	T	B Type	B	Fill Angle	Max. n/min		Ceramic 80	Ceramic 120	Ceramic 180	Ceramic 320
150	25	step	25	left	3500	1	● 0161604916	● 2191604916		
150	25	step	25	neutral	3500	1	● 0141604916	● 0241604916	● 0351604916	● 0441604916
150	25	step	25	right	3500	1	● 0181604916	● 0281604916	● 0391604916	



Appearance can vary from picture depending on variant.



Fill Arr.: Fill Material Arrangement

EUIBDB005 | XTREME ★★★★★★

ATB® disc brushes for planetary heads

Precise disc brushes for planetary head machines and deburring systems.

- The highly accurate and stable brush body ensures high concentricity
- It can be directly adapted to planetary heads or existing exchangeable shanks for toolholders in machining centres
- The manufacturing process with tight tolerances generates high balance and low vibration
- Available with several trimming styles, fill materials and grit sizes to offer the best solution for your application
- Special trimming styles and angles possible on request

Application: Deburring of sintered, fine blanked or lasered parts in planetary head machines with high tolerance requirements. Suits for the nearly every common materials, such as (stainless) steel, aluminium or cast iron.

Please note: We offer all versions in a maximal precise version to make sure to meet the highest industrial requirements. Due to a optimised flatness and surface condition of the contact surface facing the machine we reach a perfect tool adaption.

Ø Body	T	B Type	B	Fill Arr.	Fill Angle	Ø Fill Bundle	Max. n/min		Silicon Carbide 80	Silicon Carbide 120	Silicon Carbide 180	Silicon Carbide 320
150	25	step	25	bundle	left	8	3500	1	● 2101624916	● 2111624916	● 2121624916	● 2131624916
150	25	step	25	bundle	left	12	3500	1	● 3101624916	● 3111624916	● 3121624916	● 3131624916
150	25	step	25	bundle	neutral	8	3500	1	● 2001624916	● 2011624916	● 2021624916	● 2031624916
150	25	step	25	bundle	neutral	12	3500	1	● 3001624916	● 3011624916	● 3021624916	● 3031624916
150	25	step	25	bundle	right	8	3500	1	● 2201624916	● 2211624916	● 2221624916	● 2231624916
150	25	step	25	bundle	right	12	3500	1	● 3201624916	● 3211624916	● 3221624916	● 3231624916
150	25	step	25	full	neutral		3500	1	● 1001624916	● 1011624916	● 1021624916	● 1031624916
150	25	step	25	turbo	left		3500	1	● 4101624916	● 4111624916	● 4121624916	● 4131624916
150	25	step	25	turbo	neutral		3500	1	● 4001624916	● 4011624916	● 4021624916	● 4031624916
150	25	step	25	turbo	right		3500	1	● 4201624916	● 4211624916	● 4221624916	● 4231624916

Ø Body	T	B Type	B	Fill Arr.	Fill Angle	Ø Fill Bundle	Max. n/min		Ceramic 80	Ceramic 120	Ceramic 180	Ceramic 320
150	25	step	25	bundle	left	12	3500	1	● 3141624916	● 3151624916	● 3161624916	● 3171624916
150	25	step	25	bundle	neutral	8	3500	1	● 2041624916	● 2051624916	● 2061624916	● 2071624916
150	25	step	25	bundle	neutral	12	3500	1	● 3041624916	● 3051624916	● 3061624916	● 3071624916
150	25	step	25	bundle	right	8	3500	1	● 2241624916	● 2251624916	● 2261624916	● 2271624916
150	25	step	25	bundle	right	12	3500	1	● 3241624916	● 3251624916	● 3261624916	● 3271624916
150	25	step	25	full	neutral		3500	1	● 1041624916	● 1051624916	● 1061624916	● 1071624916
150	25	step	25	turbo	left		3500	1	● 4141624916	● 4151624916	● 4161624916	● 4171624916
150	25	step	25	turbo	neutral		3500	1	● 4041624916	● 4051624916	● 4061624916	● 4071624916
150	25	step	25	turbo	right		3500	1	● 4241624916	● 4251624916	● 4261624916	● 4271624916



Appearance can vary from picture depending on variant.



EUIBEB001 | EVOLUTION ★★★★★

ATB® end brush, shank adaption

ATB® end brush with shank for direct adaption on several tool holders. Please ask our application technicians for open requests and general questions about the ATB® products.

- high density and concentricity
- process safety and high service life
- depending on the workpiece material to be processed, brushes are available with ceramic- (NH-C) and siliciumcarbide-trimming (NH-S)
- high machine compatibility because of the shank adaption
- high flexibility in processing allows several customer specific variations
- useful for precisely manufacturing (for example for processing groove bottoms)
- flexibility in shank length allows high processing depths

Application: On CNC machines, machining centres and on robot systems. Preferably to be used wet with cooling lubricant or oil. Suitable directly after machining for deburring and edge rounding on components with side and inner surfaces, as well as for fine machining of component contours.

Ø	Ø Body	T	S	SL	L	Max. n/min		Silicon Carbide 120	Ceramic 80
16	14	25	6	50	100	4500	1	● 7921509911	
18	18	25	6	50	100	4500	1	● 7931509911	
20	20	23	6	30	82	4500	1	● 1701509911	
20	20	25	6	40	90	4500	1		● 3301509911
25	25	30	6	30	85	4500	1	● 7911509911	● 7971509911
31	30	25	6	40	89	4500	1	● 3601509914	



EUIBAC001 | EVOLUTION ★★★★★

Clamping fixtures for ATB® disc brushes

Clamping fixtures with shank-Ø 12 mm and clamping surface DIN 6535-HB. Compatible with ATB® disc brushes including a hexagonal mounting bore.

Appearance can vary from picture depending on variant.

Ø	adapt. to	Adapt.		Item Number
50	12 DIN 6535-HB	K	1	● 5002075000
76	12 DIN 6535-HB	L	1	● 3642075000
85	12 DIN 6535-HB	J	1	● 9602075000
106	12 DIN 6535-HB	H	1	● 3652075000
125	HSK - 63 / SK - 40	C	1	● 3602075000
150	HSK - 63 / SK - 40	D	1	● 3612075000
175	HSK - 63 / SK - 40	E	1	● 3622075000
200	HSK - 63 / SK - 40	F	1	● 3692075000
250	HSK - 63 / SK - 40	G	1	● 1922075000



EUIBAC002 | EVOLUTION ★★★★★

Tool holders for ATB® disc brushes

Compatible with ATB® disc brushes including a Ø18 mm central bore with driving bores.

Appearance can vary from picture depending on variant.

adapt. to	Adapt.		Item Number
WELDON S. Ø 12, HSK - A63, DIN 69893	H, J, K, L	1	● 4933604000
WELDON S. Ø 12, HSK - A100, DIN 69893	H, J, K, L	1	● 6303604000
SK - 40, DIN 69871	C, D, E, F, G	1	● 3613604000
HSK - A63, DIN 69893	C, D, E, F, G	1	● 3603604000
HSK - A100, DIN 69893	C, D, E, F, G	1	● 3633604000

Terms & Conditions and Contact Addresses.

Refer to our website for our general terms of payment and delivery and further information on ordering and dispatch.

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