



## Novoflex-B®, Honing and Deburring Tool



- Flexible, self-centering honing and deburring tool
- Creates plateau finish
- Good carrier for oil film adhesion due to cross sanding
- Is always used with an oversize in relation to the bore and is therefore very effective for deburring and rounding at workpiece edges at the inlet and outlet of cylindrical bores, for internal intersections and grooves, as well as in bearing tunnels
- Produces a clean and controllable surface finish on edges and surfaces independent of the material quality of the component
- Can be used both on hand-held machines and honing machines
- Use in CNC and NC machines, machining centers and automatic machines; can be placed in tool spindles

### Application:

Motor cylinders, piston rods, boreholes on shafts and cranks, pneumatic and hydraulic cylinders, valve guides, compressed air equipment, wheel cylinders, brake control cylinders, pipes and tubes,

and many other applications in the automotive and aerospace industries, as well as hydraulic systems and heat exchangers.

### Recommendations:

For choosing the correct Novoflex-B diameter the bore diameter of the workpiece is decisive. First determine the bore diameter. On the back of this flyer you find the bore diameter in the first column of the table specified with "W" (workpiece). You find the corresponding brush diameter in the second column.

The use of lubricants is always required. We recommend lubricating the Novoflex-B with honing oil before using it. Mineral oil, motor oil, water-soluble oil (viscosity 10W30) and cooling lubricants can be used as alternatives. On hydraulic brake cylinders please use brake fluid instead.

Honing time 20 to 40 seconds. Recommended speed for Novoflex-B brushes up to Ø 40 mm: 600–1000 RPM / 60–120 stroke/min. From Ø 41 mm: 350–600 RPM / 60–120 stroke/min. The process time can be reduced to deburr cross and longitudinal holes.

Clean the bore using Osborn nylon tube brushes with hot water and cleaning agent.



W = Ø-bore workpiece

W	Ø	A	L	S	PU	■ Abr. Bristle/grit SIC 120 ■		■ Abr. Bristle/grit SIC 180 ■		■ Abr. Bristle/grit SIC 240 ■	
						Order no.	€ per pcs	Order no.	€ per pcs	Order no.	€ per pcs
7	8	50	200	3.6	1			<b>9828-036 308</b>			
8	9	50	200	3.6	1	<b>9818-036 309</b>		<b>9828-036 309</b>			
9	10	50	200	3.6	1	<b>9818-036 310</b>		<b>9828-036 310</b>			
10	11	60	200	3.6	1	<b>9818-036 311</b>		<b>9828-036 311</b>			
11	12	60	200	3.6	1	<b>9818-036 312</b>		<b>9828-036 312</b>			
12	13	60	200	3.6	1	<b>9818-036 313</b>		<b>9828-036 313</b>		9838-036 313	
14	15.5	60	200	3.6	1	<b>9818-036 316</b>		<b>9828-036 316</b>			
16	18	60	200	4.6	1	<b>9818-036 318</b>		<b>9828-036 318</b>		9838-036 318	
18	20	60	200	4.6	1	<b>9818-036 320</b>		<b>9828-036 320</b>		9838-036 320	
20	22	70	200	4.6	1	<b>9818-036 322</b>		<b>9828-036 322</b>		9838-036 322	
22	25	70	200	4.6	1	<b>9818-036 325</b>		<b>9828-036 325</b>		9838-036 325	
24	27	70	200	5.1	1	<b>9818-036 327</b>		<b>9828-036 327</b>			
25	28	70	200	5.1	1	<b>9818-036 328</b>		<b>9828-036 328</b>		<b>9838-036 328</b>	
27	30	70	200	5.1	1	<b>9818-036 330</b>		<b>9828-036 330</b>		9838-036 330	
29	32	70	200	5.1	1	<b>9818-036 332</b>		<b>9828-036 332</b>		<b>9838-036 332</b>	
32	35	70	200	5.7	1	<b>9818-036 335</b>		<b>9828-036 335</b>		9838-036 335	
35	38	70	200	5.7	1	<b>9818-036 338</b>		<b>9828-036 338</b>			
38	41	70	200	5.7	1	<b>9818-036 341</b>		<b>9828-036 341</b>			
41	45	70	200	5.7	1	<b>9818-036 345</b>		<b>9828-036 345</b>			
45	48	70	200	5.7	1	<b>9818-036 348</b>		<b>9828-036 348</b>			
48	51	70	200	6.5	1	<b>9818-036 351</b>		<b>9828-036 351</b>			
51	54	70	200	6.5	1	<b>9818-036 354</b>		<b>9828-036 354</b>			
54	57	70	200	6.5	1	<b>9818-036 357</b>		<b>9828-036 357</b>			
57	60	70	200	7.3	1	<b>9818-036 360</b>		<b>9828-036 360</b>		9838-036 360	
60	64	70	200	7.3	1	<b>9818-036 364</b>		<b>9828-036 364</b>			

**Item numbers in bold:** available from stock. Other dimensions, grit sizes and filament types on request.