UNEEDA

640 CHESTNUT RIDGE RD
SPRING VALLEY, NY 10977
**P** 800-431-2494
**F** 845-426-2810
**E** SALES@UNEEDA.COM
WWW.UNEEDA.COM

# Brush Strip Sanding Guidelines

## Brush Information:

F30: Very aggressive – Good for sanding UV-lacquer – Good for metal – Good on even surfaces.
F40: Aggressive - Used for items with wide and not so deep profiles.
F45: Universal – Good for both even & profiled surfaces. Works well together with support brushes.
F55: Universal – Works well together with support brushes and on items with deeper profiles.
F70: Used for very deep moldings – Used if item require a light sanding.
F85: Used for extremely deep moldings.

Horsehair brushes: Very soft and therefore gives a light sanding.
Pig hair brushes: Used for polishing and as a cleaning brush for dust etc.

## Correct brush / depth of profile

F30 & F40: Used if profile depth is between 0 – 4 mm.
F45: Used if profile depth is between 4 – 6 mm.
F55: Used if profile depth is between 6 – 9 mm.
F70: Used if profile depth is between 9 – 12 mm.
F85: Used if profile depth is bigger than 12 mm.

## Correct slit choice (Always mix slits to avoid sanding lines)

3mm slit: Hard to reach areas – Small profiles. The smaller the slit = the less aggressive sanding on edges sanding on edges
4mm slit & 5mm slit: Smaller profiles.
7mm slit: Medium size profiles. Is standard choice of slit – if not mentioned in the order!
14mm slit: Used for bigger profiles.
20mm slit: Used for big profiles. Good on 100% flat surfaces together with 0mm (no cut) slits.

Special slits like 25mm, 50mm, 100mm or bigger can be made. Ask Pro-Flex.

Remember – Slits should always be smaller than the width of the profile they shall sand.

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## Grit Size:

Grit 60, 80: VERY aggressive. Good for metal sanding. Use with care on wood!
Grit 100, 120: Aggressive. Used for badly prepared wood pieces.
Grit 150, 180: Used in general for white wood sanding – Used on MDF.
Grit 220: MR. Universal grit – Can be used for white wood sanding & lacquer sanding.
Grit 240: Universal grit. Used for lacquer sanding – Used for intermediate sanding.
Grit 280 & 320: Good for lacquer sanding – Good for intermediate sanding
Grit 400+: Used for fine sanding and polishing.

Remember: Brushes are a surface finishing tool. The better the work before sanding is made = better result!

## Type of Abrasives:

Aluminium Oxide (AO): Used for sanding wood. Color is typical "green" or "red".
Silicon Carbide (SC): Used for sanding lacquer. Color is typical "black".
Ceramic: Used for sanding Metal, Composite etc. Color is typical "Blue".

## Support Brushes:

Used to add more/harder pressure when sanding with the sanding brush. Pro-Flex has many different kinds & sizes of support brushes. Contact us if you need to know more about this product.

- Single row: Good pressure without losing the flexibility. Used for deep profiles.
- Single row with foam: Presses the sanding brush into the profiles without being to aggressive on the edges.
- Twin row: Strong pressure. Used for sanding in profiled items. Last for a very long time!
- Triple row: Extreme pressure. Perfect for sanding flat surfaces. Good on MDF! Last for a very long time!

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## Pressure of sanding brush onto item you wish to sand.

Too much pressure on brushes onto the item, you wish to sand, gives bad life time of abrasive and not a better sanding result!

- General rule: Pressure of brush shall be between 6-10mm of brush hair onto item.
- Depending on the sanding brush you are using. Higher Brush height = more pressure!
- When new brushes is being installed. Always adjust pressure!
- When you change items being sand in the sanding machine. Always adjust the pressure!

## Correct RPM of POM core

**The correct RPM always depend on the total diameter. Therefore it is always hard to say exactly, because there so many variations. But as a general rule here are the correct RPM for each POM core size:**

- **Ø280mm = 50 – 300 RPM**
- **Ø180mm = 250 – 500 RPM**
- **Ø120mm = 400 – 700 RPM**
- **Ø100mm = 600 – 950 RPM**
- **Ø80mm = 700 – 1000 RPM**

- Higher RPM = Less life of abrasive.
- Always keep RPM as low as possible when new brushes have been installed. Slowly go up in
- RPM when the brushes have been sanding for some time.

## General good advices:

1. Use as big a POM core as possible. This gives better sanding result.
2. Always mix slit sizes. This make sure no sanding stripes are made.
3. Normally only fill up every second keyway in the POM core with sanding brushes.
4. Fill up other hubs with support brushes if more aggressive sanding is wanted.
5. Only change 50% of sanding brushes when sanding brushes shall be changed. Then the other 50% after some time and then the first 50% after some time and so on. This gives a more uniform sanding result on all sanded items.