Knot Wheel Brushes

Knot wheel brushes for grinders, angle grinders and stationary machines used in the preparation and reworking of bolt fillet and butt welds. They remove scale, rust, paint, slag, rubber residue and can be used for de-burring.

Knot Wheel Brushes with multiple Rows

Ready mounted brushes with multiple rows have a dense filling compared to single segment brushes, which are assembled together. In your order please state the width of the brush, bore size and type and thickness of wire.

The listed knot wheel brushes are for the use in stationary machines.

Stainless Steel Brushes

LESSMANN-brushes with stainless steel have green side plates. We use wire with material number 1.4310. Material number 1.4401 can be used on request.

Information on working on stainless steel you find at www.lessmann.com

All knots on our standard twisted wire wheel brushes are left hand twisted in order to minimize the undoing of the knots should the brush be used incorrectly. On request we can supply right hand twist brushes.

In addition to brushes with left or right knotted, we also offer left-right knotted brushes.

Left-right knotted wheel brushes usually are more aggressive, hence they are often used for heavy brushing operations. Besides the knots open less, therefore they are ideal for the treatment of edges.

User Tip:

We recommend to turn the brush during use in order to maintain sharpened wire ends.

On request other bores and wire diameter are available.

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<tr>
<th>Knot Wheel Brushes, Stainless Steel Wire</th>
</tr>
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<tbody>
<tr>
<td>D</td>
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<th>Knot Wheel Brushes, Stainless Steel Wire</th>
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</table>
Knot Wheel Brushes, multiple rows

Joint Cleaning Brushes

Joint cleaning brushes are used for the production of expansion joints in the construction of new linings as well as in restoration and repair. The application of this knot wheel brush is usually alike with all pavements.

Brussels with brass coated steel wire STM are very stable, hence they are often used for cleaning concrete joints.

<table>
<thead>
<tr>
<th>D</th>
<th>A</th>
<th>ZF</th>
<th>R</th>
<th>RPM</th>
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<th>STA 0.35</th>
<th>STA 0.50</th>
<th>ROH 0.35</th>
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<tr>
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<td>3/4</td>
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<tr>
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<td>7/8</td>
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<td>O</td>
<td>58 x 3</td>
</tr>
</tbody>
</table>

Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 152).

STA = steel wire, straight
STH = steel wire, high tensile, straight
STM = brass coated steel, straight
ROH = stainless steel wire, high tensile, straight
Pipeline Brushes / Stringer Bead Brushes

LESSMANN Pipeline brushes are specially developed for professional use on U- and V-welds in the pipeline industry.

The remarkable features of the high quality LESSMANN Pipeline Brushes are the long lifetime and the quietness of running. They are especially narrow and therefore they are the perfect tool for cleaning all welds at tube connections.

Pipeline Brushes / Stringer Bead Brushes, left-right knotted

Left-right knotted pipeline brushes usually are more aggressive, hence they are often used for heavy brushing operations. Besides the knots open less, therefore there are ideal for the treatment of edges.

Stainless Steel Brushes

LESSMANN Pipeline Brushes with stainless steel wire have green side plates. We use wire with material number 1.4310. Material number 1.4401 can be used on request. Information on working on stainless steel you find at www.lessmann.com

<table>
<thead>
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</tbody>
</table>

* Brushes with thread = packed 5 pieces per carton, brushes with bore = packed 10 pieces per carton

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**Item Nos. in bold** are available ex stock.

Consider our minimum order value for italic printed article numbers (see page 152).

STH = steel wire, high tensile, straight
Pipeline Brushes / Stringer Bead Brushes

Pipeline Brushes / Stringer Bead Brushes, Stainless Steel

Pipeline Brushes / Stringer Bead Brushes, rose bud

Pipeline Brushes / Stringer Bead Brushes, left-right knotted

Pipeline Brushes / Stringer Bead Brushes, encapsulated

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<td>32</td>
<td>D</td>
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<td>472.801.32</td>
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<td>6</td>
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<td>D</td>
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<td>5/10*</td>
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<td>1/4</td>
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<td>D</td>
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<td>5/10*</td>
<td>475.801.39</td>
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* Brushes with thread = packed 5 pieces per carton, brushes with bore = packed 10 pieces per carton

** Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 150).
Cutback Brushes

for the removal of pipe coatings.

The removal of pipe-ends with brushes is a common process in the pipe industry. To prevent corrosion, steel pipes are usually covered in epoxy resin and several layers of polyethylene (PE) or polypropylene (PE). To ensure a strong and safe welded joint during the installation of the pipes, the coating has to be removed completely on the ends of the pipes. For this process, usually several rings of knotted wire brushes are mounted together to get one large block of wheel brushes.

The LESSMANN Cutback Brushes are proven to have a long lifetime and are used by many international companies producing pipe for the oil and gas industry.

Cutback Brushes are supplied already mounted to one another. This ensures a perfect balancing, an even surface and a tighter fitting.

All Cutback Brushes can be purchased with left-right knotting (WZ), too. The LESSMANN Cutback rings are supplied already mounted to one another. This ensures a perfect balancing, an even surface and a tighter fitting.

Cutback Brushes, left-right knotted

Left-right knotted cutback brushes usually are more aggressive, hence they are often used for heavy brushing operations. The knots of this type of brush open less, therefore there are ideal for the treatment of edges.

Knot types ZF

- B: Rose Bud
- G: Open Knot (wire ends are cut)
- D: Fully knotted (wire ends are cut completely)

Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 152). STH = steel wire, high tensile, straight

<table>
<thead>
<tr>
<th>Item</th>
<th>Description</th>
<th>D</th>
<th>A</th>
<th>H</th>
<th>d</th>
<th>Keyways</th>
<th>Z</th>
<th>ZF</th>
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<tr>
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<td>13</td>
<td>45</td>
<td>102</td>
<td>115,8 x 13</td>
<td>56</td>
<td>O</td>
<td>0,63</td>
<td>0,50 / 0,80</td>
<td></td>
</tr>
<tr>
<td>300</td>
<td></td>
<td>13</td>
<td>60</td>
<td>102</td>
<td>115,8 x 13</td>
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<td>O</td>
<td>0,80</td>
<td>0,50 / 0,80</td>
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<td>45</td>
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<td>233 x 24</td>
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<td>O</td>
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<tr>
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<td>233 x 24</td>
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<td>O</td>
<td>0,58 / 0,80</td>
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</tr>
</tbody>
</table>

The table above gives you an insight into the range of brushes LESSMANN can produce. Due to modern technologies in production we can respond to individual requests and wishes of our customers (diameter, working width, bore).

If requested, scribe markings are possible.

Please follow the QR-Code or fill in the form below:

Enquiry for Cutback Brushes

sender: company, contact person

Inquiries and Infos:
Phone: +49 9082 707-0
Fax: +49 9082 707-76
info@lessmann.com
www.lessmann.com

Cutback Brushes

Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 152).
Single Segment Brushes

These brushes are mainly used for deburring purposes in stationary machines or processing centres.

The construction of these brushes allows it to assemble them to roller brushes of any desired width. Many different filling materials like steel, stainless steel or abrasive nylon with various grit are at your disposal.

Outstanding Processing
The flexible bristles align to the different shapes of working pieces. An important advantage of the single segment brushes compared to other grinding tools, such as pads or grinding discs, is their gentle treatment.

Furthermore the brushes do not become encrusted. They are suitable for deburring work and fine polishing of stainless steel, light metal or plastic material. Besides the executions listed on this page other diameters and grit sizes are available.

Stainless Steel Brushes
LESMANN-brushes with stainless steel wire have a laser imprint.

Information on working on stainless steel you find at www.lessmann.com

Stainless Steel Brushes

LESMANN-brushes with stainless steel wire have a laser imprint.

For further information on abrasive filaments please see page 13.

Item Nos. in bold are available ex stock.
Consider our minimum order value for italic printed article numbers (see page 152).

SIC = silicon carbide bristles

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</table>

1 Single Segment Wheel Brushes, Silicon Carbide Bristles, 2 rows

| D | R | BD | H | d Stand. | d | RPM | Pack. | SIC 120/0.6 | Art. No. | SIC 180/1.0 | Art. No. | SIC 320/0.6 | Art. No. |
|---|---|---|---|---------|---|-----|------|-----------|---------|---------|---------|---------|
| 200 | 8 | 80 | 27 | 43 | 5/8 | 16-60 | 6,000 | 5 | available on demand | 362.852 | available on demand | 370.852 | available on demand |
| 250 | 10 | 100 | 27 | 58 | 5/8 | 16-60 | 6,000 | 5 | available on demand | 370.852 | available on demand | 370.852 | available on demand |
Single Segment Wheel Brushes

Single Segment Wheel Brushes, Steel Wire

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Single Segment Wheel Brushes, Stainless Steel Wire

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Note: A* can be up to 4 mm larger than BD. EB 3.0 mm with R > 60
EB 2.4 mm with R ≤ 60

For further information on abrasive filaments please see page 13.

Item Nos. in bold are available ex stock.
Consider our minimum order value for italic printed article numbers (see page 152).

STA = steel wire, crimped
STH = steel wire, high tensile, crimped
STL = cord wire, crimped
ROF = stainless steel wire, crimped

For further information on abrasive filaments please see page 13.
Wheel Brushes

Wheel brushes filled with crimped wire are used for the purpose of obtaining different surface finishing:

- the removal of rust, paint and dirt
- for roughening, deburring, stripping or polishing.

**Big or Small?**
A decisive factor for choosing the most suitable brush is the wire and tube diameter. Brushes with a larger tube diameter (measure R) are filled with more wire, are more aggressive and have a longer life.

In our catalogue are the usual tube diameters – other diameters can also be supplied. More technical instruction such as peripheral speed etc. see pages 8 - 10.

**Stainless Steel Brushes**
Information on working on stainless steel you find at www.lessmann.com

Other filling materials, filling diameters and special executions
Take advantage of the LESSMANN range of products, of the experience in developing and producing brushes! We are able to produce special executions on demand.

**Adapter Set**
All brushes are supplied with adapter sets for easy mounting on all popular grinding machines. The adapters have the following dimensions:

- **Set 1 / tube 30:**
  - 30 / 1” / 22.2 / 20 / 16 / 1/2” / 12
- **Set 2 / tube 40:**
  - 40 / 1” / 22.2 / 20 / 16 / 1/2”
- **Set 3 / tube 50:**
  - 50 / 1” / 22.2 / 20 / 16 / 1/2”
- **Set 4 / tube 80 + 100:**
  - brushes with metal discs, bore 50.8 and double keyway 7x13; plus adapter to bore 32.
- **Set 5 / tube 80 + 100:**
  - brushes with metal discs, bore 50.8 and double keyway 7x13; plus adapter to bore 32.

By usage without adapter set the actual size might be up to 0.2 mm below nominal size.

**Item Nos. in bold** are available ex stock. Consider our minimum order value for each printed article numbers (see page 152).

**STA** = steel wire, crimped

**STM** = brass coated steel, crimped
## Wheel Brushes, Stainless Steel

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*Note: Bore must be indicated in the order. Standard bore delivery ex stock, short termed. Other bores are available with extra charge: 1 - 10 pcs. EUR 5,50 / 11 - 25 pcs. EUR 3,50*

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*Note: Bore must be indicated in the order. Standard bore delivery ex stock, short termed. Other bores are available with extra charge: 1 - 10 pcs. EUR 5,50 / 11 - 25 pcs. EUR 3,50*

---

Wheel Brushes

![Wheel Brushes](image)

Plate with tube 80 and 100 (Set 4 / 5)
Satin Brushes
Satin brushes are the perfect tool for satining, polishing, abrading/smoothing, matting and structuring.

Staple Set Wheel and Disc Brushes
Wheel and Disc Brushes with abrasive nylon filament are used for the wood machining industry. Used on angle grinders, the disc brushes are ideal for maintaining, cleaning, structuring or polishing wood. Besides, the brushes are used for giving wood a rustic effect or for roughening it before treating with colour or lacquer. The brushes are very effective when working on large surfaces.

| Item Nos. in bold | are available ex stock.

Consider our minimum order value for basic printed article numbers (see page 152).

STM = brass coated steel, crimped
STL = cord wire, crimped
ROF = stainless steel wire, crimped
SIC = silicon carbide bristles
FIB = fibre
PA = polyamide, crimped

Bore must be indicated in the order. Standard ones with double keyway 0.5 x 23 mm delivery ex stock, short termed. Other bores are available with extra charge: 1 - 10 pcs. EUR 5.50 / 11 - 25 pcs. EUR 3.50

**Satin Brushes**

<table>
<thead>
<tr>
<th>Item</th>
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<th>RPM</th>
<th>Pack.</th>
</tr>
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<tr>
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**Staple Set Disc Brushes**

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Special Models

Band Saw Brushes
Wheel Brushes in circular saws or band saws are used for cleaning the chipping space. A wheel brush with diameter 80-100 mm is pressed against the saw blade (circular or band saw). By moving the saw blade or band the brush is rolling and it taking the chipping out of the shipping space. Hence a built-up edge is prevented and the durability of the saw blade is extended. The used wheel brushes usually are with steel wire, corded wire or nylon filament. The brushes are suitable for all common machines.

Stripping Brushes
For the removal of laquer and other insulations from cables and electric equipment. The polished surface and the concentric running enable soft removal of laquer from the wires.

<table>
<thead>
<tr>
<th>Item Nos.</th>
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<td>STL</td>
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</tr>
<tr>
<td>PA</td>
<td>Polyamide, crimped</td>
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</tbody>
</table>

| Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 152). |

Band Saw Brushes, polyamide

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Band Saw Brushes, steel wire

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<td>8,000</td>
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<tbody>
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<td>80</td>
<td>300.091</td>
<td>320.001</td>
<td>320.009</td>
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Stripping Brushes

<table>
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<tr>
<th>D</th>
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</table>

* bore with plastic sleeve

EB 3,0 mm with R > 60
EB 2,4 mm with R ≤ 60
Special Models

Small diameter crimped wheels SDW

LESSMANN small diameter crimped wheels have a manifold use, e.g. for deburring, cleaning, derusting or paint stripping on various work pieces and surfaces. A typical application e.g. is the cleaning of interior and exterior threads or the treatment of areas which are hard to reach.

The brushes are inserted directly into the machine or are mounted into a drilling machine or fast-moving item with a suitable drive arbor. Depending on the application and requirements several brushes can be mounted in a row. Suitable adapters are available on request.

The typical filling material LESSMANN offers is steel wire, stainless steel wire or abrasive nylon. On request other wire diameters and filling materials are available. All brushes are manufactured with a copper shell.

Item Nos. in bold are available ex stock. Consider our minimum order value for italic printed article numbers (see page 152).

Wheel Brushes for the treatment of hard metal

Wheel brushes with diamond filling are often used for the rounding of edges of carbide or diamond tools. Cutting edges on carbide tools extend the lifetime and allow a higher cutting speed. The treatment on major cutting edges of drills are mainly operated manually. LESSMANN wheel brushes with diamond support to decrease abrasion and to improve the surface quality of the work piece. Due to the consistent and narrow filling a clean and steady dipping of the edges is possible.

Surfaces of chip flutes of carbide drills are finished with brushes with aluminum oxide filling material. Finished chip flutes have a better process stability when drilling.

Stainless Steel Brushes

Information on working on stainless steel you find at www.lessmann.com

Wheel Brushes for the treatment of hard metal

Diamant K400

Stainless Steel Brushes

Information on working on stainless steel you find at www.lessmann.com

* Filling with angular cut
Accessories

Adapters
With these adapters the bore can be reduced to the required size. The wheel brushes are supplied with adapter sets which make it possible to mount the brushes on all popular grinding machines. The adapters have the following dimensions:

Set 1 / tube 30:
30 / 1” / 22.2 / 20 / 16 / 1/2” / 12
Set 2 / tube 40:
40 / 3/4” / 22.2 / 20 / 16 / 1/2”
Set 3 / tube 50:
50 / 3/4” / 22.2 / 20 / 16 / 1/2”
Set 4 / tube 80 + 100:
brushes with metal discs, bore 50.8 and double keyway 7x13; plus adapter to bore 30. Further reduction possible with set 1.
Set 5 / tube 80 + 100:
brushes with metal discs, bore 50.8 and double keyway 7x13; plus adapter to bore 32. Further reduction possible with set 1.

A technical advice and safety information leaflet is included.

The practical adapter sets can also be ordered separately.

Single plastic reducing rings in many different dimensions can be supplied ex stock.

Drive Arbors
For use on drilling machines.

Metal Discs
Brushes with tube diameter 80 and 100 mm are supplied with our standard metal plates made of steel. Occasionally these metal plates are also required for brushes with smaller tubes. The metal plates on this page are therefore also suitable for the brushes on page 31 - 33. Please indicate the required bore size on your order and note that normally two metal plates are required for one brush.

Adapter Sets

<table>
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Metal Discs

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</table>

Bore must be indicated!

* On request with double keyset 12 x 7 (50.8 / 52.9 / 54.5)