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## BS Power Brushing Machine

Deburring  
Edge Preparation  
Polishing

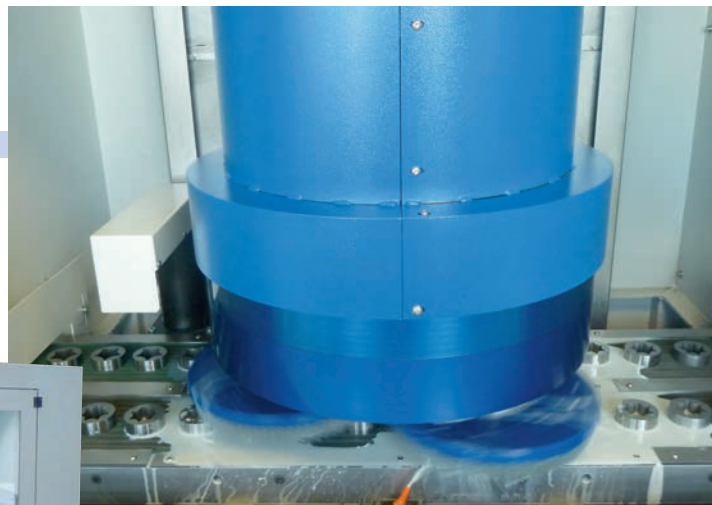


## BS Power Brushing Machine

The brushing-honing technique has been used by GERBER MASCHINENBAU for over 60 years. The machines were initially used for processing and polishing of ruby jewel bearings in watches, but later also for radiusing and polishing of indexable inserts produced in Tungsten carbide and CBN.

The BS Power brushing machine has been specially developed for de-burring and defined radiusing of edges on precision, mass produced components. Up to 7 million components can be processed annually in single-shift operation, depending on the workpiece material and diameter.

The machine is particularly suitable for precision components, such as valve plates, pump parts, rotors, indexable insert as well as for stamping and fine blanking parts for which there should be a requirement for high surface quality and parts free of all burrs.



### Other products:

Polishing machines for ultra-hard materials, as for example, tungsten carbide, CBN, PCD, sapphire, ruby and industrial ceramics

Expanding mandrels TORAXOR

Thickness grading machines for small parts

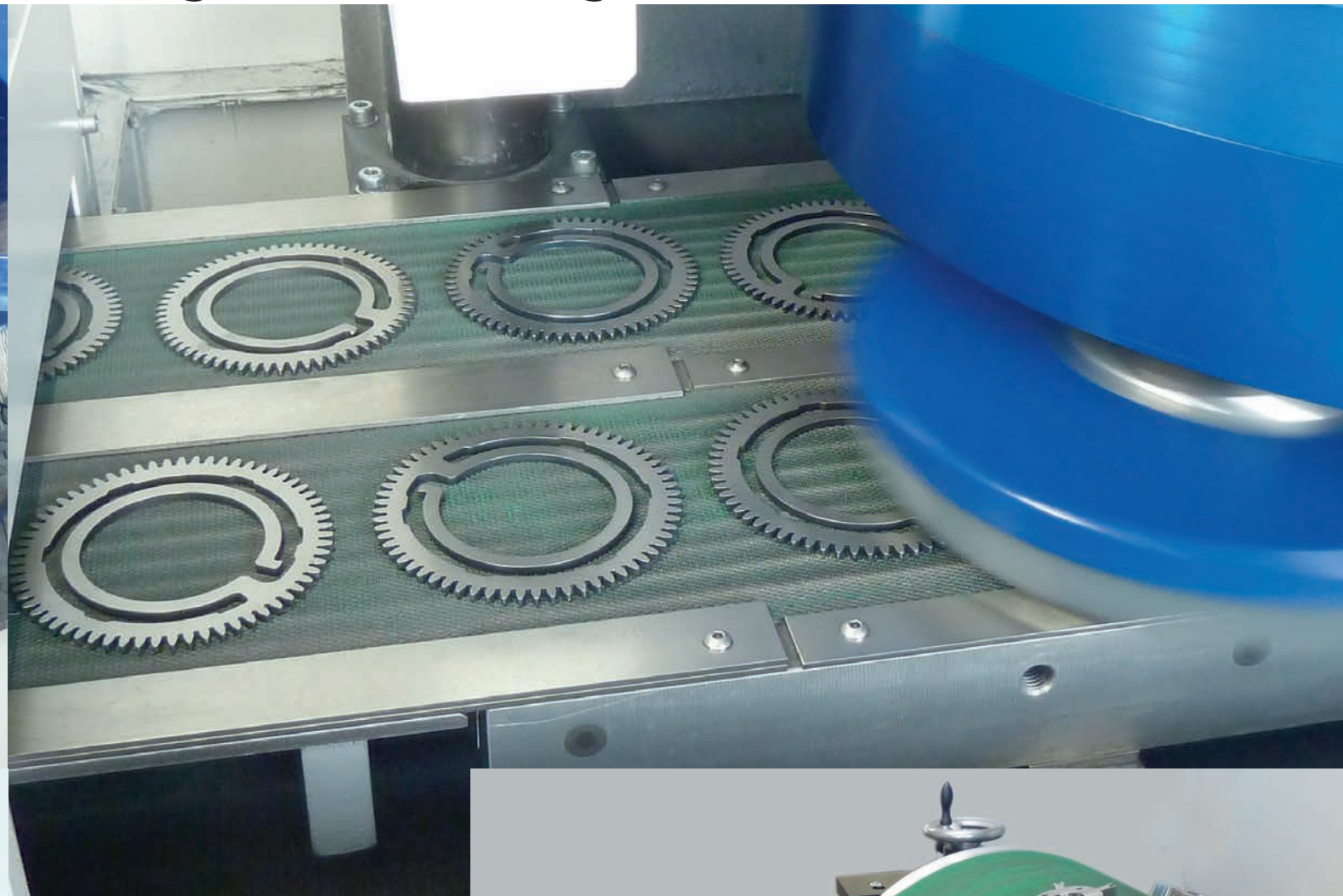
Sub-contract in the precision mechanics sector

Your representative:



# Consistent

even de-burring and radiusing of contours in a continuous process



## MAIN FEATURES

- Solid modern construction poured with polymer concrete, guarantees high accuracy
- The powerful planetary brushing head produces evenly radiused edges all around
- Turn over station for processing both sides of components
- Magnet turn over wheel allows unit times <1 second
- 1- or 2-head machine available
- user-friendly, easy programming
- Fully automatic processing
- Continuous compensation for brush wear
- Processing can take place dry or with coolant, depending on application



## TECHNICAL CHARACTERISTICS

Component size, single-side processing, nominal	400 mm dia.
Component size, processing both sides, nominal	175 mm dia.
Component thickness	0.2...200 mm
Brush diameter	3 x 260 mm
Brush speed	400-2000 rpm
Brush drive power	7.5 kW
Brush types	SiC, ceramic or diamond impregnated plastic bristles, straight or obliquely fitted
Speed of planetary brushing head	8-40 rpm
Control of brush head feed	Automatic
Application range of brushes	570 mm dia.
Z-axis stroke	250 mm
Power supply	3 x 400 VAC, 10 A, 4 kVA
Air supply	min. 6 bar
Width / depth / height	3780 / 1800 / 2287 mm
Total weight (with magnetic turn over wheel)	3500 kg

## Options (specific to workpiece)

Feeding device	with conveyor belts and pull-down magnet or link conveyor with workpiece carriers/cages/nests
Delivery speed	2-70 mm/s
Component handling	manual work place, stacking magazine, vibrating conveyor, conveyor belt with individual feed, robot, aso.
Demagnetizing device	for residual magnetism <2A/cm
Coolant device	specific to component and customer requirement
Interfaces	Profibus/Ethernet



## PRODUCTION EXAMPLE

Component description	Outer rotor
Material	Sintered steel
Dimensions	dia. 40 x 15 mm
Operation	De-burr/radiusing 0.05 mm, both sides
Hourly production	1500 pieces
Annual production	6 Mil



The conveyor feeding device is adapted to suit the range of components of the user and offers very quick changeover times. A turn over station allows processing on both sides of the components.

Right picture: Magnetic turn over wheel

The brushes are driven using a planetary brush head platform as the tool. The planetary brush head ensures that the workpieces passing linearly under the brushes are de-burred and radiused evenly.

