

COMBITWIST® knot brushes

The innovative twist for superior results



TRUST BLUE

- Highly aggressive brushing
- Exceptionally long brush life
- Superior rotational balance
- Excellent surface finish
- Fast stock removal

COMBITWIST® knot brushes

Introduction



COMBITWIST® is a variation on existing knot styles in which the knots are alternately twisted to offer superior balance during rotation. This construction style offers a more aggressive and effective brushing solution for cleaning and deburring applications.

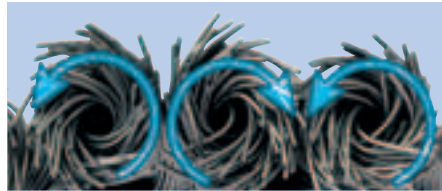
Filament material

The filament materials are colour-coded for easier recognition:

Carbon steel wire	-	grey
Stainless steel wire (INOX)	-	blue

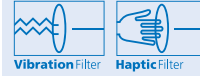
COMBITWIST® advantages

- More aggressive brushing
- Longer brush life
- Superior rotational balance
- Faster stock removal
- Reduced operator fatigue
- Better surface finish



PFERDERGONOMICS®

COMBITWIST® brushes from PFERD help to sustainably reduce vibration levels produced at the workplace and to improve working comfort.



PFERD brushes with COMBITWIST® knot construction feature smoother running due to better wheel balance and increased removal. The unique production style prevents the brushes recoiling even when used on tool edges and corners.



PFERDMEDIA

For more information and to see a product video, visit pferdusa.com/vcombitwist

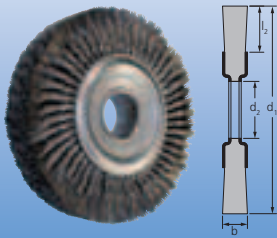
Brushes available in POP packaging are marked with a "P" in this catalogue. To order brushes in POP versions, please add a "P" to the end of the EDP number.



The minimum order quantity of POP items is printed in "blue" accordingly.

Knot wheel brushes

Pipe cleaning brushes, multi-section, full cable twist, COMBITWIST®

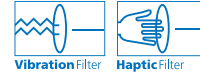


EDP 82094

This multisection knot wheel brush is designed to clean contaminants such as rust and dirt from pipe or steel sheets. It is also very effective in removing protective coatings from pipe OD. The COMBITWIST® knot design ensures long brush service life and superior surface conditioning performance.

Made in the USA.

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Diameter d_1 [Inches]	Arbor hole d_2 [Inches]	No. of knots	No. of rows	Trim length l_2 [Inches]	Face width b [Inches]	Width on arbor [Inches]	Wire diameter and EDP number .020	Recom. speed [RPM]	MSFS max. [RPM]	Adapter style	
Carbon steel wire											
10	2	200	4	2-1/4	2-1/8	2	82094	2,500 - 3,500	4,800	C	1

Full cable twist knot wheel brushes feature tightly twisted knots for low flex, high impact brushing action. Narrow face allows better control of surface contact area. Full cable twist is ideal for the toughest brushing applications where surface finish is a low priority.

For weld cleaning, weld spatter removal, scale removal, cleaning, deburring, and flash removal.

Recommendation for use

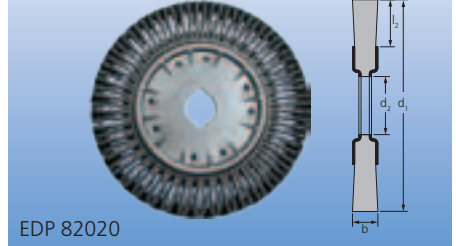
For optimal performance, use on angle grinders.

Made in the USA.


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Full cable twist, single row, COMBITWIST®



EDP 82020

Diameter d_1 [Inches]	Arbor hole d_2 [Inches]	No. of knots	Trim length l_2 [Inches]	Face width b [Inches]	Width on arbor [Inches]	Keyway dimensions [Inches]	Wire diameter and EDP number			Recom. speed [RPM]	MSFS max. [RPM]	Adapter style		
15	2	80	2-5/8	3/4	3/4	1/2 x 1/4	.020			82020	700 - 3,000	3,600	C	1

Carbon steel wire



Narrow face allows better control of surface contact area. Full cable twist is ideal for the toughest brushing applications where surface finish is a low priority.

Recommendation for use

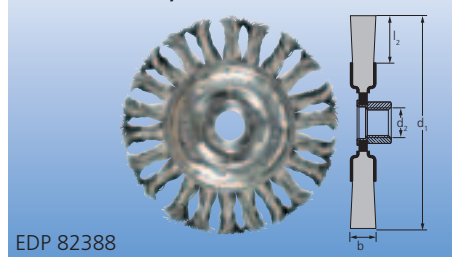
For optimal performance, use on angle grinders.

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Full cable twist, COMBITWIST®



EDP 82388

Dia. d_1 [Inches]	Thread size d_2 [Inches]	No. of knots	Trim length l_2 [Inches]	Face width b [Inches]	Wire diameter and EDP number			Recom. speed [RPM]	MSFS max. [RPM]	
					.014	.020	.023			
Carbon steel wire										
4	5/8-11	22	3/4	1/2	82387	82388 P	-	10,000 - 15,000	20,000	10/5
5	5/8-11	24	3/4	1/2	-	-	82684	7,500 - 15,000	15,000	10
6	5/8-11	30	1-1/4	1/2	-	-	82688	5,000 - 10,000	10,000	10
Stainless steel wire (INOX)										
4	5/8-11	22	3/4	1/2	82416	82417	-	8,000 - 15,000	20,000	10
6	5/8-11	30	1-1/4	1/2	-	-	82758	4,000 - 10,000	10,000	10

Standard twist knot wheel brushes with a threaded nut for easy change out. Features loosely twisted knots for aggressive brushing action with a good surface finish. They are ideal when heavy-duty or severe cleaning is required.

For weld cleaning, weld spatter removal, scale removal, cleaning, deburring, and flash removal.

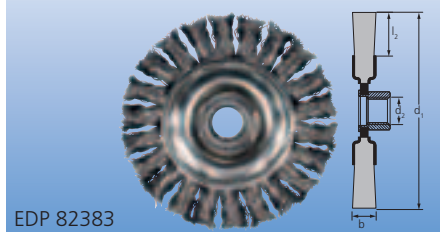
Recommendation for use


For optimal performance, use on angle grinders.

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Standard twist, COMBITWIST®



Diameter d ₁ [Inches]	Thread size d ₂ [Inches]	No. of knots	Trim length l ₂ [Inches]	Face width b [Inches]	Wire diameter and EDP number				Recom. speed [RPM]	MSFS max. [RPM]	
					.014	.016	.020	.023			

Carbon steel wire

4	5/8-11	22	7/8	5/8	82383	-	82384	-	10,000 - 15,000	20,000	10
5	5/8-11	24	5/8	5/8	-	-	82680	-	7,500 - 15,000	15,000	10
6	5/8-11	32	1-1/8	5/8	82681	82682	-	82683	4,500 - 9,000	9,000	10

Stainless steel wire (INOX)

4	5/8-11	22	7/8	5/8	82412	-	82413	-	8,000 - 15,000	20,000	10
5	5/8-11	24	5/8	5/8	-	-	82749	-	6,000 - 15,000	15,000	10
6	5/8-11	32	1-1/8	5/8	-	82752	-	82753	3,500 - 9,000	9,000	10

Stringer bead knot wheel brushes are tightly twisted for low flex, high impact brushing action. Designed for root and hot pass weld cleaning in pipe joining applications. Also for general use where a narrow face, aggressive brush is desired for controlled, confined surface contact area. Designed for applications requiring aggressive brushing action.

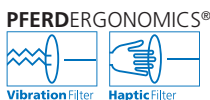
Recommendation for use

For optimal performance, use on angle grinders.

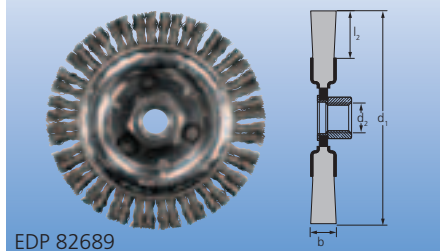
Made in the USA.


Ordering note

Please see page 6 for thread adapters.



Stringer bead twist, COMBITWIST®



Diameter d ₁ [Inches]	Thread size d ₂ [Inches]	No. of knots	Trim length l ₂ [Inches]	Face width b [Inches]	Wire diameter and EDP number	Recom. speed [RPM]	MSFS max. [RPM]	
					.020			

Carbon steel wire

4	5/8-11	32	3/4	3/16	82391 P	10,000 - 15,000	20,000	10/5
4-1/2	5/8-11	32	1	3/16	82392 P	10,000 - 15,000	20,000	10/5
4-7/8	5/8-11	48	3/4	3/16	82689	7,500 - 15,000	15,000	10
6	5/8-11	48	1-1/8	3/16	82693	6,000 - 12,500	12,500	10
6	5/8-11	56	1-1/8	3/16	82694	6,000 - 12,500	12,500	10
6	5/8-11	64	1-1/8	1/8	82695	6,000 - 12,500	12,500	10
6-7/8	5/8-11	56	1-1/8	3/16	82700	4,500 - 9,000	9,000	10
6-7/8	5/8-11	72	1-1/8	3/16	82701	4,500 - 9,000	9,000	10

Stainless steel wire (INOX)

4	5/8-11	32	3/4	3/16	82420	8,000 - 15,000	20,000	10
4-1/2	5/8-11	32	1	3/16	82421	8,000 - 15,000	20,000	10
4-7/8	5/8-11	48	3/4	3/16	82759	7,000 - 15,000	15,000	10
6	5/8-11	48	1-1/8	3/16	82763	5,000 - 12,500	12,500	10
6	5/8-11	56	1-1/8	3/16	82764	5,000 - 12,500	12,500	10
6	5/8-11	64	1-1/8	1/8	82765	5,000 - 12,500	12,500	10

This unique patented nut design solves the problem of brush interference with the guard when changing the mounting position of the brush, resulting in increased user safety.

Reversing the mounting position of the brush takes advantage of the self-sharpening effect of the wire, resulting in longer service life, and improved brush performance.

Recommendation for use

For optimal performance, use on angle grinders.

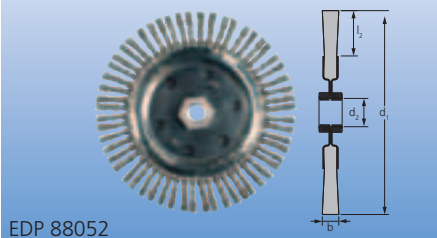
TWIN-NUT U.S. Patent No. 8425282


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TWIN-NUT, stringer bead twist, COMBITWIST®



Diameter d ₁ [Inches]	Thread size d ₂ [Inches]	No. of knots	Trim length l ₂ [Inches]	Face width b [Inches]	Wire diameter and EDP number .020	Recom. speed [RPM]	MSFS max. [RPM]	
Carbon steel wire								
6	5/8-11	56	1-1/8	3/16	88050	6,000 - 12,500	12,500	10
6-7/8	5/8-11	56	1-1/8	3/16	88052	4,500 - 9,000	9,000	10

For use on large surfaces where a great deal of brushing is required. Good for corners and angles, and removal of contaminants such as scale, concrete, slag, and marine growth.

Ordering note

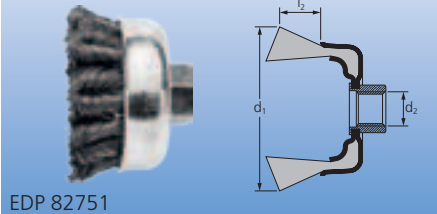
Please see page 6 for thread adapters.


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External nut, single row, standard twist, COMBITWIST®



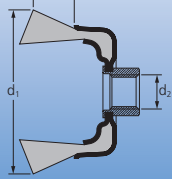
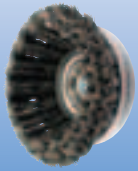
Diameter d ₁ [Inches]	Thread size d ₂ [Inches]	No. of knots	Trim length l ₂ [Inches]	Wire diameter and EDP number			Recom. speed [RPM]	MSFS max. [RPM]	
				.014	.020	.023			
Carbon steel wire									
2-3/4	5/8-11	18	7/8	82750 P	82751 P	-	7,000 - 14,000	14,000	5/5
3-1/2	5/8-11	20	7/8	82401	82402	-	6,000 - 12,500	12,500	1
4	5/8-11	24	1-1/4	82716	-	82717	4,500 - 9,000	9,000	1
5	5/8-11	30	1-3/8	-	-	82723	3,500 - 7,000	7,000	1
6	5/8-11	36	1-1/2	-	-	82725	3,000 - 6,000	6,000	1
Stainless steel wire (INOX)									
2-3/4	5/8-11	18	7/8	82855 P	82856	-	5,500 - 14,000	14,000	5/5
3-1/2	5/8-11	20	7/8	-	82431	-	4,000 - 9,000	12,500	5
4	5/8-11	24	1-1/4	82789	-	82790	3,500 - 9,000	9,000	5
5	5/8-11	30	1-3/8	-	-	82794	2,500 - 7,000	7,000	5

COMBITWIST® knot brushes

Knot cup brushes

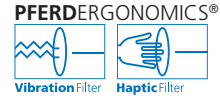


External nut, double row,
standard twist, COMBITWIST®



EDP 82557

Choose these double row knot cups for the most challenging applications. Very aggressive, high impact brushing action. Optimal removal rates and service life.



Ordering note

Please see below for thread adapters.

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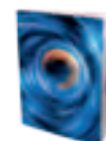
Diameter d_1 [Inches]	Thread size d_2 [Inches]	No. of knots	Trim length l_2 [Inches]	Wire diameter and EDP number			Recom. speed [RPM]	MSFS max. [RPM]	
				.014	.023	.035			
Carbon steel wire									
4	5/8-11	48	1-3/8	82552	82553	-	3,500 - 7,000	7,000	1
6	5/8-11	66	1-1/2	82556	82557	82558	3,000 - 6,000	6,000	1
Stainless steel wire (INOX)									
4	5/8-11	48	1-3/8	-	82657	-	2,500 - 7,000	7,000	1

Minigrinder adapter insert	Fits brush thread	Fits tool spindle thread	EDP number	
	5/8-11	M10x1.25	84645 P	5/5
	5/8-11	M10x1.50	84646 P	5/5
	5/8-11	3/8-24	84647 P	5/5

EDP 84646

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For more information on PFERD products, please refer to the **PFERD Tool Manual 22**. Order your own personal copy at www.pferd.com.

