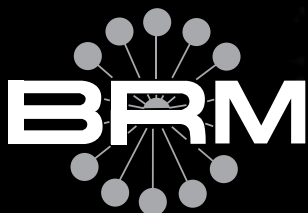


# FLEX-HONE<sup>®</sup>

for FIREARMS

FOR SHOTGUNS, RIFLES, AND HAND GUNS

INNOVATORS IN  
BRUSH TECHNOLOGY



BRUSH RESEARCH  
MANUFACTURING

Brush Research Manufacturing is proud to offer a specialty line of Flex-Hone for Firearms tools. Trusted by hobbyists, gunsmiths and manufacturers worldwide, these tools improve firearm performance. Used for finishing and polishing chambers, cylinders and shotgun barrels.



BRUSHRESEARCH.COM

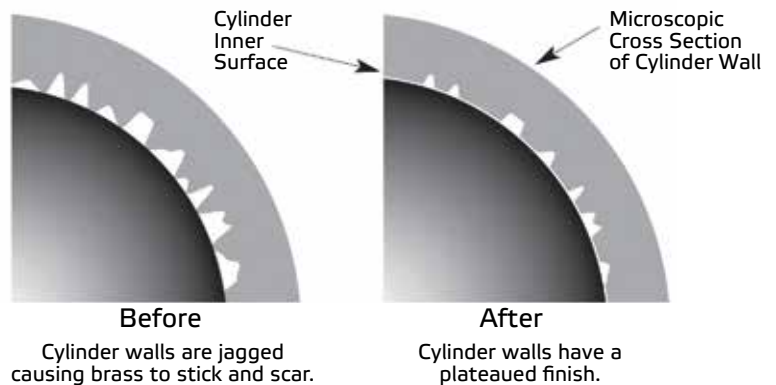
# FLEX-HONE®

## INTRODUCING THE FLEX-HONE FOR FIREARMS

The Flex-Hone Tool quickly and easily produces the optimum plateau surface finish in any type or size cylinder, slide, chamber, magazine tube or smooth bore barrel. The Flex-Hone Tool has been used for decades and is proven beneficial. Brush Research Manufacturing makes a complete line of Flex-Hone Tools for a variety of firearms applications.

The Flex-Hone process is a low-temperature, low pressure abrading process that exposes the undisturbed base metal structure to produce a long wearing surface. It is a method of developing a surface on a part which is free of fragmented, amorphous or smeared metal, pitting and oxidation. The tool produces this finish with a minimum of stock removal, ensuring that the bores of your firearm remain at the precise dimensions required. The tool is easily used in any hand drill or rotating spindle. The Flex-Hone is self-centering and self-aligning to the bore. Using the Flex-Hone is a great way to improve the function and extend the life of your firearms.

Metal surfaces of your firearm contain microscopic "peaks" and "valleys". The formation of corrosion is hastened by residual stresses present at the surface. The plateau finish produced by the Flex-Hone refines the peaks and reduces surface tension by removing highly stressed areas. The valleys produced by the Flex-Hone improve the surface's ability to hold oil. Many firearms companies are choosing the Flex-Hone for their final finish requirements.



### INSTRUCTIONS FOR USE

Always make sure that the magazine and chamber are empty prior to using the Flex-Hone Tool. Disassemble your firearm and secure the Flex-Hone firmly into the chuck of a lathe, drill press or hand drill. It is best to use the shortest shank possible for your application. The Flex-Hone Tool must always be used with a good quality cutting oil or honing fluid to keep heat to a minimum, and prevent the tool from loading and to suspend the abrasive material.

We offer a specially formulated Flex-Hone Oil for this tool. Although many lubricants are satisfactory including water soluble fluids, we highly recommended using Flex-Hone Oil for the finest finish and longest tool life possible.

Rotate the tool prior to entry and continue rotating until the tool is fully removed from the part. Stroke the tool at a smooth, constant speed. Clean the cylinder using a CLP type cleaner and brush the cylinder wall with a cleaning brush. Dry the cylinder and continue to clean with a lint free cloth coated with a light oil or mineral spirits. Continue until the lint free cloth remains clean. Oil the surface lightly after cleaning to preserve your finish. Your weapon will not only be free of microscopic imperfections, but you will be able to see the difference with a beautiful finish.



The Flex-Hone Tool is available in a variety of abrasives and grits.

The Flex-Hone Tool helps protect your valuable firearms allowing the brass to eject smoothly and cleanly.



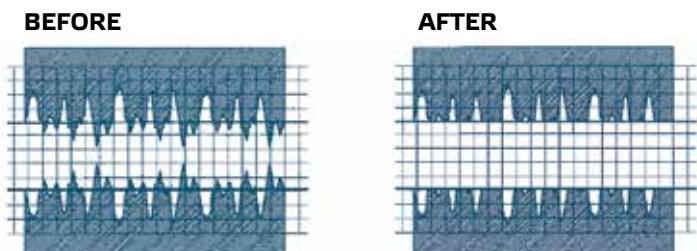
Any smooth bore cylinder on guns or rifles can benefit from use of the Flex-Hone.

### FOR SHOTGUN BARRELS

Any smooth bore on your firearm can benefit from a quick Flex-Honing, including the barrel bore on your shotgun. By using the Flex-Hone Tool you can quickly, safely and thoroughly clean out any damage that has occurred from oxidation and corrosion, blend out scratches and remove the nicks that cause plastic adhesion. The Flex-Hone will produce a smooth finish that will prevent plastic from building up as quickly in the future. The abrasive globules on flexible nylon filaments remove the built up residue and leave a superior surface resulting in greater accuracy, reduced wear and longer life for your shotgun.

### FOR CYLINDERS & CHAMBERS

Emptying and reloading your firearm will be much smoother and easier after using the Flex-Hone in the cylinders and chamber. The improved finish will allow the rounds to "fall" from the cylinder with ease, and eject smoothly from your chamber. Reloads will enter quickly and smoothly with reduced brass scarring. A Flex-Honed bore will enable you to reload your brass more often and with less work.



### FOR SLIDES & MAGAZINE TUBES

The Flex-Hone Tool can be used on any type or size of cylinder and is not limited to barrels and chambers. Flex-Honing the slide on automatic pistols and the magazine tubes of shotguns and rifles will provide the benefit of a smooth, long wearing surface.

There are certain values we all place in our firearms: security, investment, tradition, education. The value can be enhanced and protected by proper care and the use of the Flex-Hone Tool.



# FLEX-HONES

## SHOTGUNS



Gauge	Barrel Hones			Chamber Hones		Forcing Cone Hones		
	180SC	400SC	800AO	400SC	800AO	180SC	400SC	800SC
10 Ga	00607	08260	00608	08301	00611			
12 Ga	00048	05397	00049	06459	00054	02985	08004	02986
16 Ga	00050	08261	00051	08302	00055	05611	08264	05612
20 Ga	00052	08262	00053	08303	00056	05613	08265	05614
28 Ga	11000	08362	11641	09828	03341		12241	12242
.410	00609	08263	00610	08304	00612			
	All Barrel Flex-Hones are 34" OAL. The stem wire is covered with a protective shrink tube coating to protect the barrel.			All Chamber Flex-Hones are 12" OAL. The stem wire is covered with a protective shrink tube coating to protect the barrel.		All Forcing Cone Flex-Hones have a 1-5/8" abrasive part and are 10" OAL.		
	Shotgun Port Cleaning Brush 1/8" 6" OAL - 06632 3/16" 7" OAL - 06633			Shotgun Handled Chamber Brush 12Ga - 06629 20 Ga - 06630		Gas Ring Brush 06631		

## RIFLES & PISTOLS



Pistol Chamber Hones	400SC	800SC
.32	05470	05471
.357 MAG/.38	00899	00900
.41 MAG	00901	00902
.44 MAG	00903	00904
.45 ACP	00905	00906
.45 COLT	00907	00908
9MM	07584	08309

All Pistol Flex-Hones have a 1 5/8" abrasive part and are 3" OAL.

Rifle Chamber Hones	400SC	800SC	OAL
.17 CAL/ .22 MAG	06380	08305	6"
.223 Remington	06262	06263	8"
.243	07643	08306	12"
.308	06498	08041	12"
.357 MAG	08310	03309	14"
25-06	07647	08307	12"
30-06	07409	08308	12"
.44 MAG	08312	03310	14"
.44 CAL	06381	08311	6"
.45 COLT	08313	03311	14"
50 BMG	07410	07411	12"
5.56 NATO	09246	09247	12"
6.8MM	09478	09479	8"
7.62X39MM SAAMI	08949	08950	8"
7.62X51MM NATO	09259	09260	12"
338 LAPUA	09435	09436	12"
416 BARRETT	11142	11143	16"
22 LR	12158	12159	6"
AR15	12256	12257	12"

Auto Pistol Hones	400SC	800SC
1911 Main Spring Housing	00909 OAL 4"	00910 OAL 4"
1911 Main Lug Area		BC18M800 OAL 8"
S&W, Barretta, SIG Internal Slide		BC12800 OAL 8"

## CAN'T FIND THE RIGHT FLEX-HONE?

We are constantly adding new tools to the Flex-Hone for Firearms line. Please let us know if you would like a tool designed for you.

## HAND TOOLS



Hand Drawn Wire Fill (Heavy Duty)		Fill Material		
Handle Material	Row	Stainless	Nylon	Brass
No. 93-A Laminated	2	93A-S250	93A-N250	93A-B250
Hardwood Plywood	3	93A-S375	93A-N375	93A-B375
	4	93A-S500	93A-N500	93A-B500

**Staple Set (Poly Handle)**  
 No. 93-AP .006 Stainless Wire Fill  
 No. 93-APB .006 Brass Fill  
 No. 93-APH Horse hair Fill  
 No. 93-APP .006 Phosphor Bronze Fill  
 No. 93-APN .012 Nylon Fill

**Staple Set (Wire Fill in Wood Handle)**  
 No. 93-AW .006SSFill

**Universal Bolt Brush - 06627**

Acid Brushes (Throw Away Type)		
#1	3/8"	6" OAL
#2	1/2"	6" OAL
#3	9/16"	6" OAL

Finest horse hair fill, tinned metal handle. Nylon available.

**M-16 Cleaning Brush - 93 DSN**  
**Armorer's Brush - 701**  
**Flex-Hone Oil - Pint, Quart, Gallon**