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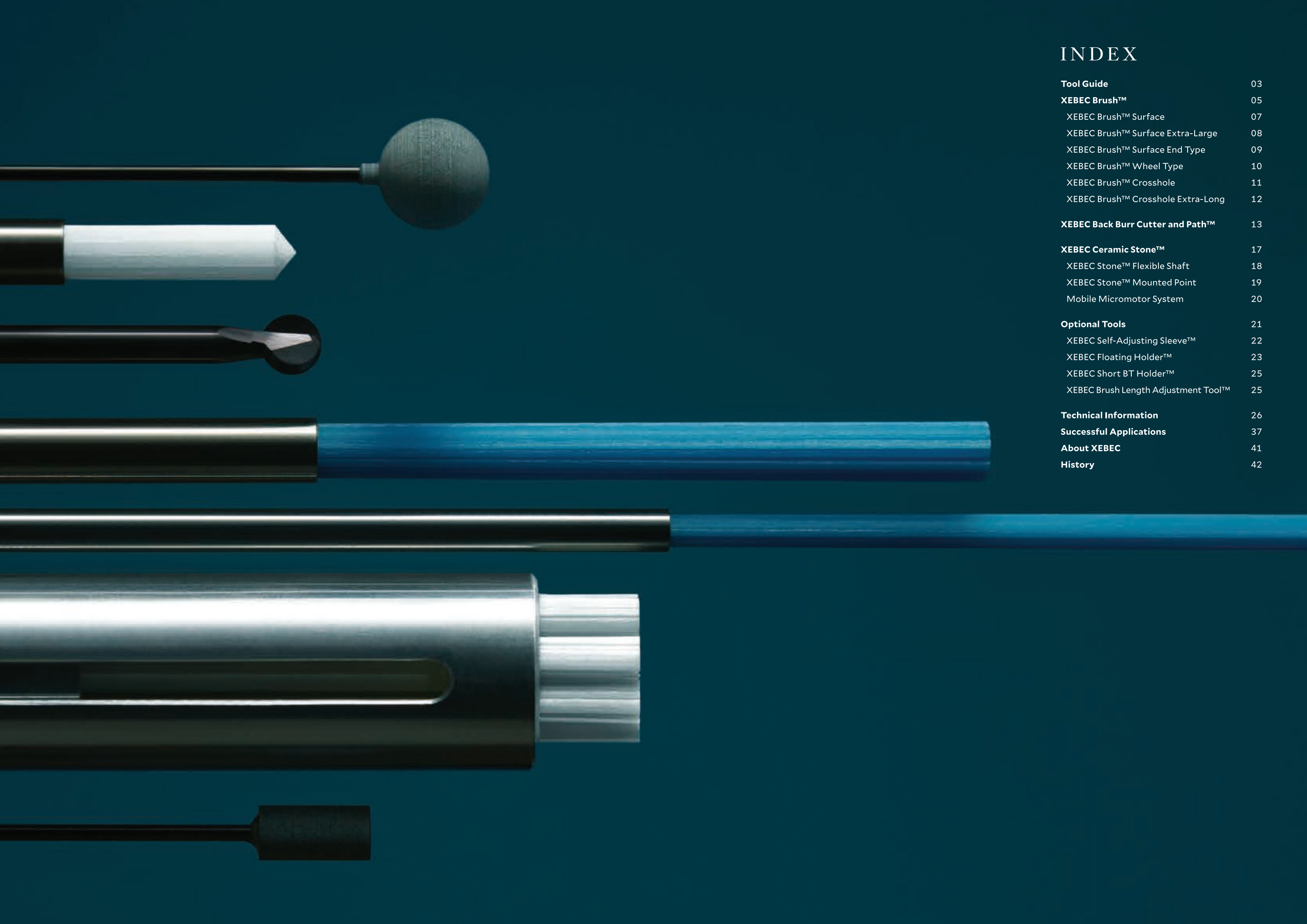
2018.10.2000at

BEAUTIFUL DEBURRING®

XEBEC TECHNOLOGY CO.,LTD.

BEAUTIFUL DEBURRING®





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Tool Guide

CNC deburring and polishing

P07 XEBEC Brush™ Surface



- Deburring after face-milling, end-milling and drilling
- Cutter mark removal and surface polishing

P10 XEBEC Brush™ Wheel Type



- Deburring after end-milling, threading, and drilling
- Polishing side surface and inner diameter

P11 XEBEC Brush™ Crosshole



- Deburring after drilling
- Cutter mark removal and inner diameter polishing

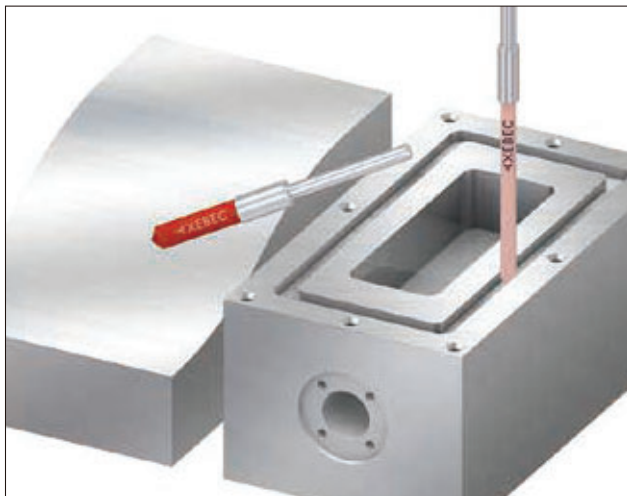
P15 XEBEC Back Burr Cutter and Path™



- Deburring after drilling

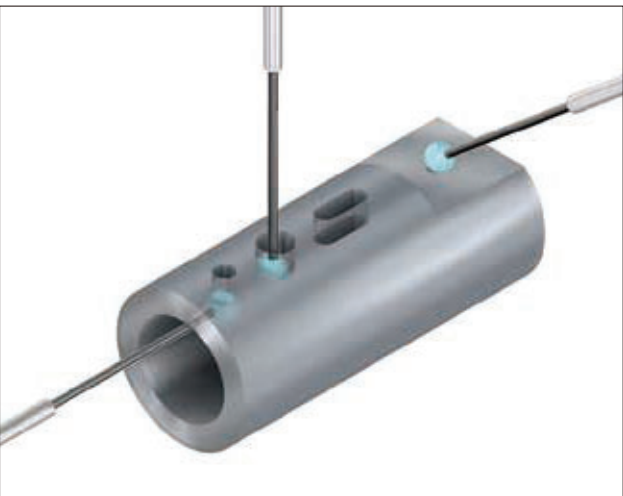
Hand tools

P09 XEBEC Brush™ Surface End Type



- Cutter mark removal and flat surface polishing

P18 XEBEC Stone™ Flexible Shaft



- Hole deburring

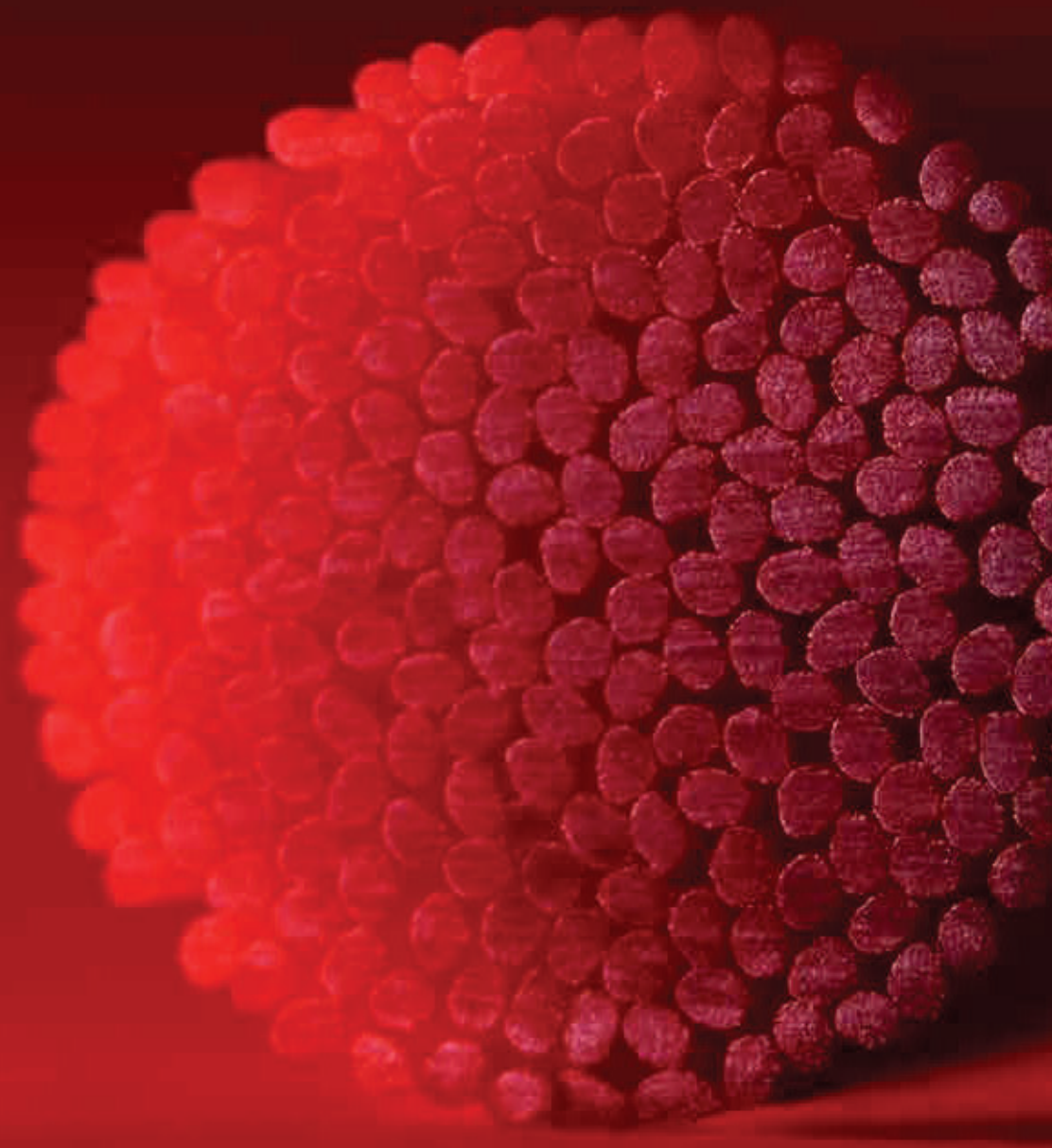
P19 XEBEC Stone™ Mounted Point



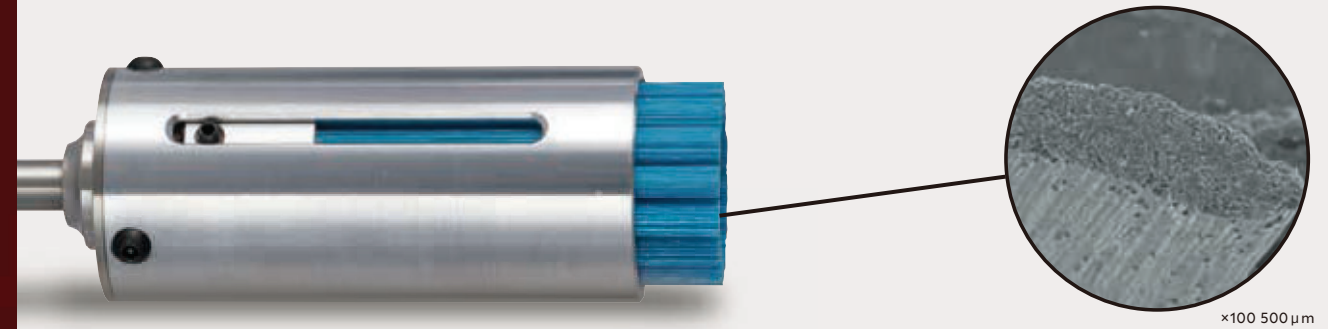
- Deburring

XEBEC Brush™

Complete deburring and polishing in your CNC machine

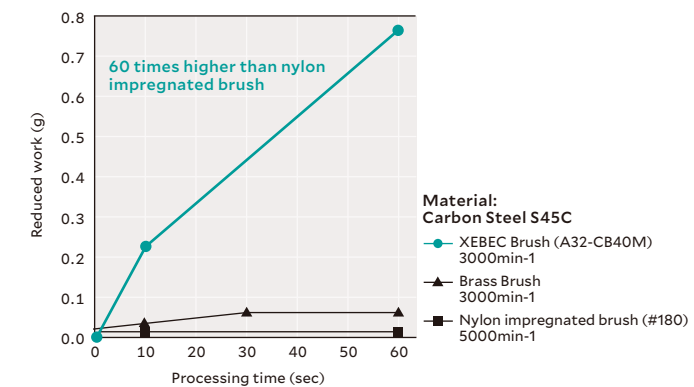


Overwhelming grinding power, Consistent cutting performance, No deformation
XEBEC Brush uses unique abrasive ceramic fiber material instead of abrasive grain.
One bristle consists of 1,000 ceramic fibers that work as cutting edges.
XEBEC Brush provides outstanding grinding ability to complete CNC deburring and polishing in your CNC machine.



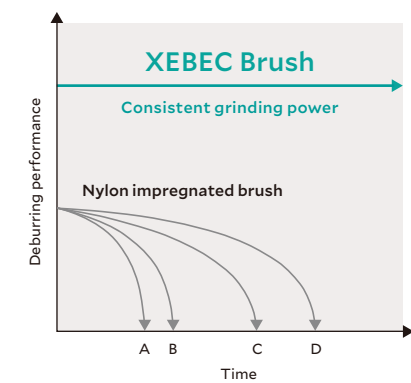
Grinding power

- The content ratio of ceramic fiber is approximately 80%
- Cutting edges on the Brush tips give overwhelming grinding power



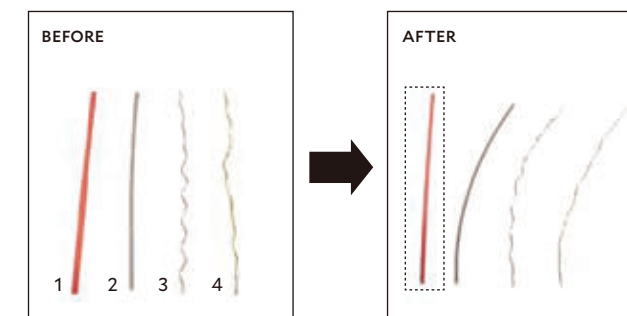
Consistent cutting performance

- New cutting edges are always exposed
- Consistent cutting performance to the end thanks to the structure of the continuous fiber



No deformation

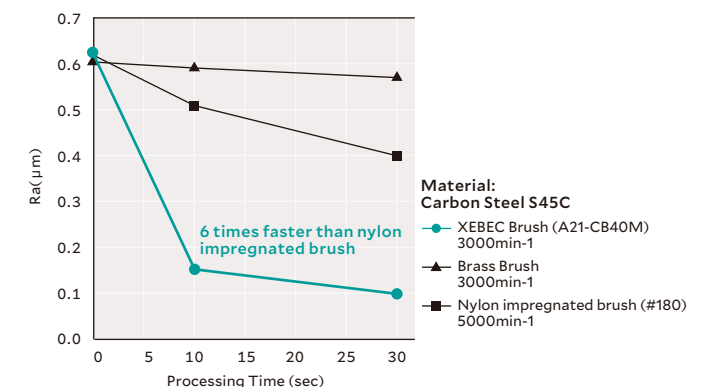
- Maintains its straight shape and does not spread out like a toothbrush
- Easy to manage on mass production lines



1. XEBEC Brush (A11 Red bristle)
2. Abrasive impregnated nylon brush
3. Steel wire brush
4. Brass wire brush

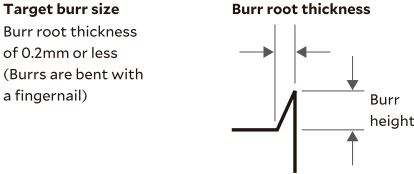
Polishing capacity

- High polishing capability of XEBEC Ceramic Stone is applied to a brush
- Best achievable surface roughness: Ra=0.1 μm or better (Rz=0.4 μm)



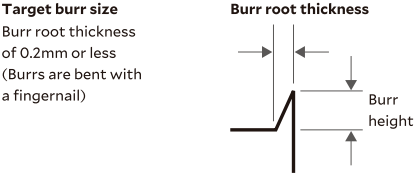
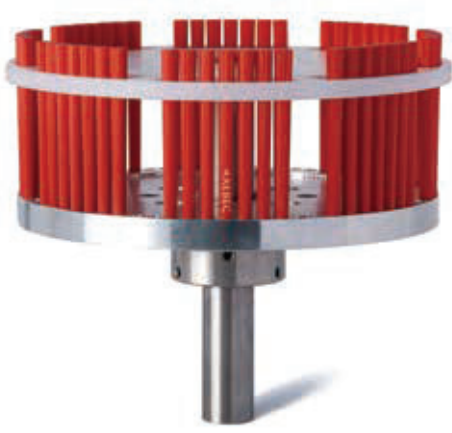
XEBEC Brush™ Surface Patented

Ideal for deburring, cutter mark removal and surface polishing



XEBEC Brush™ Surface Extra-Large Pat. Pending

Ideal for deburring, cutter mark removal and surface polishing with a width of 100mm or greater

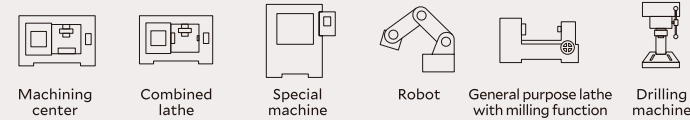


Tool composition

Brush and Sleeve are separate items.
Assemble Brush and Sleeve before use.



Applicable equipment



Tool composition

Brush and Slide Ring are separate items.
Assemble Brush to Slide Ring before use.

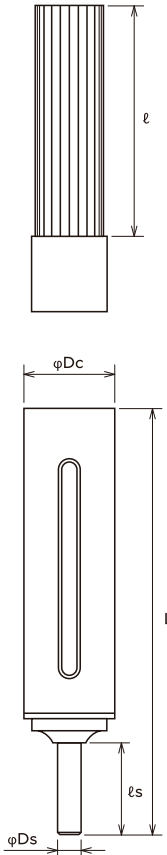


Applicable equipment



Brush

Brush (Color)	Product code	Brush diameter (mm)	Bristle length ℓ (mm)	Matching Sleeve
A13 (Pink)	A13-CB06M	φ 6	30	S06M
	A13-CB15M	φ 15	50	S15M-P
A11 (Red)	A11-CB06M	φ 6	30	S06M
	A11-CB15M	φ 15	50	S15M-P
	A11-CB25M	φ 25	75	S25M
	A11-CB40M	φ 40	75	S40M-SD10
	A11-CB60M	φ 60	75	S60M
	A11-CB100M	φ 100	75	S100M
A21 (White)	A21-CB06M	φ 6	30	S06M
	A21-CB15M	φ 15	50	S15M-P
	A21-CB25M	φ 25	75	S25M
	A21-CB40M	φ 40	75	S40M-SD10
	A21-CB60M	φ 60	75	S60M
	A21-CB100M	φ 100	75	S100M
A32 (Blue)	A32-CB06M	φ 6	30	S06M
	A32-CB15M	φ 15	50	S15M-P
	A32-CB25M	φ 25	75	S25M
	A32-CB40M	φ 40	75	S40M-SD10
	A32-CB60M	φ 60	75	S60M
	A32-CB100M	φ 100	75	S100M



* Bristle bundles are embedded in line on the periphery (except for the A13/A11/A21/A32-CB06M)
* The Brush size is approximate as the tip expands by rotating.

Sleeve

Product code	Brush diameter (mm)	External diameter Dc (mm)	Shank diameter Ds (mm)	Overall length L (mm)	Shank length ℓs (mm)	Matching Brush
S06M	φ 6	φ 10	φ 6	70	29	A13/A11/A21/A32-CB06M
S15M-P	φ 15	φ 18.5	φ 6	90	29	A13/A11/A21/A32-CB15M
S25M	φ 25	φ 30	φ 8	140	30	A11/A21/A32-CB25M
S40M-SD10	φ 40	φ 45	φ 10	140	30	A11/A21/A32-CB40M
S60M	φ 60	φ 65	φ 12	150	35	A11/A21/A32-CB60M
S100M	φ 100	φ 110	φ 16	162	40	A11/A21/A32-CB100M

* When in use, the length of the brush projection is added to the overall length of a sleeve.
* The external cylinder of the S15M-P is made of Fiber Reinforced Plastic (FRP).

Usage instructions on P27

Brush

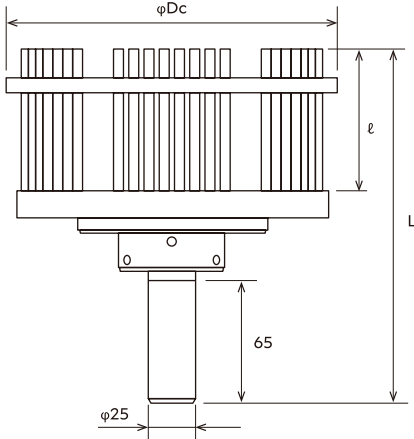
Brush (Color)	Product code	Brush diameter (mm)	Bristle length ℓ (mm)	Matching Slide Ring
A11 (Red)	A11-CB125M	φ 125	75	SR125M
	A11-CB165M	φ 165	75	SR165M
	A11-CB200M	φ 200	75	SR200M
A21 (White)	A21-CB125M	φ 125	75	SR125M
	A21-CB165M	φ 165	75	SR165M
	A21-CB200M	φ 200	75	SR200M
A32 (Blue)	A32-CB125M	φ 125	75	SR125M
	A32-CB165M	φ 165	75	SR165M
	A32-CB200M	φ 200	75	SR200M

* The Brush size is approximate as the tip expands by rotating.

Slide Ring

Product code	Brush diameter (mm)	Outer diameter Dc (mm)	Shank diameter (mm)	Overall length L (mm)
SR125M	φ 125	φ 135	φ 25	187
SR165M	φ 165	φ 176	φ 25	187
SR200M	φ 200	φ 211	φ 25	187

* The Slide Ring consists of a ring, a base holder, and a shank.
* Base holder and shank sizes are same across all Brush diameter. Ring size varies by Brush diameter.
* The total weight of a Brush and a Slide Ring. Φ125: 1920g, φ165: 2320g, φ200: 2750g



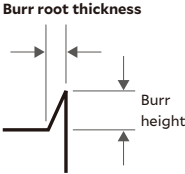
Usage instructions on P30

XEBEC Brush™ Surface End Type

Ideal for cutter mark removal and polishing sealed surface



Target burr size
Burr root thickness
of 0.1mm or less
(Burrs are easily bent
with a fingernail)



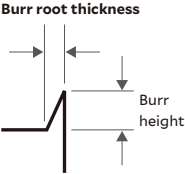
XEBEC Brush™ Wheel Type

Pat. Pending

Ideal for deburring and polishing of inner diameter, side surface and screw thread

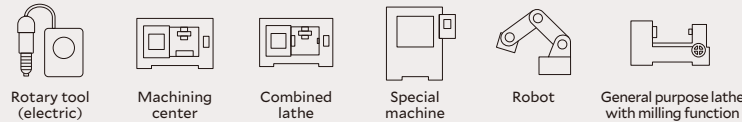


Target burr size
Burr root thickness
of 0.1mm or less
(Burrs are easily bent
with a fingernail)



Applicable equipment

The tool can be used with rotary tools and equipments that can control the rotational speed.

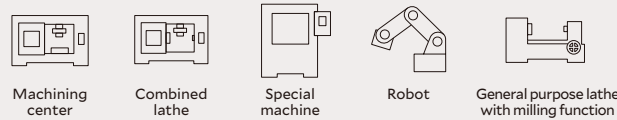


Tool composition

Brush main unit and Shank are separate items.
Assemble a main unit to a shank before use.

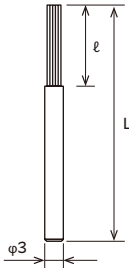


Applicable equipment

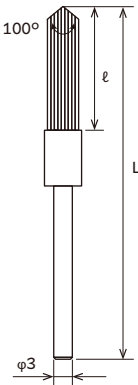


Brush (Color)	Product code	Brush diameter (mm)	Shank diameter Dc (mm)	Bristle length ℓ (mm)	Overall length L (mm)	Recommended rotational speed (min-1)	Maximum rotational speed (min-1)
A13 (Pink)	A13-EB01S	φ 1	φ 3	15	52	7000~12000	15000
	A13-EB015S	φ 1.5	φ 3	15	52	7000~12000	15000
	A13-EB02S	φ 2	φ 3	15	52	7000~12000	15000
	A13-EB025S	φ 2.5	φ 3	15	52	7000~12000	15000
	A13-EB03M	φ 3	φ 3	30	67	4000	6000
A11 (Red)	A11-EB01S	φ 1	φ 3	15	52	7000~12000	15000
	A11-EB015S	φ 1.5	φ 3	15	52	7000~12000	15000
	A11-EB02S	φ 2	φ 3	15	52	7000~12000	15000
	A11-EB025S	φ 2.5	φ 3	15	52	7000~12000	15000
	A11-EB06M	φ 5	φ 3	20	57	7000	12000
A21 (White)	A21-EB06M	φ 5	φ 3	20	57	7000	12000

* The Brush size is approximate as the tip expands by rotating.

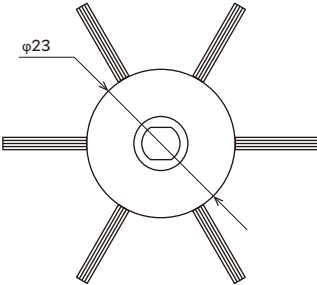


A11-EB06M
A21-EB06M



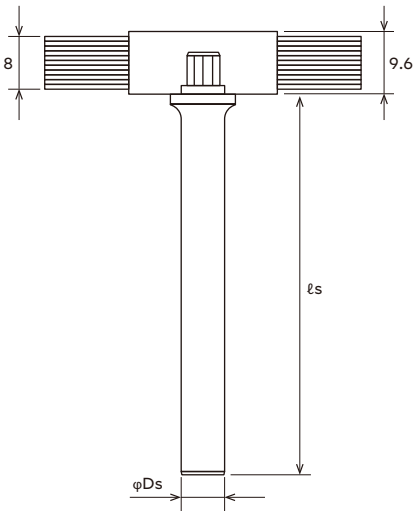
Brush main unit

Brush (Color)	Product code	Brush diameter (mm)	Number of bundles	Matching shank
A11 (Red)	W-A11-50	φ 50	6	W-SH-M/L
	W-A11-75	φ 75	6	



Shank

Product code	Shank diameter Ds (mm)	Shank length ℓs (mm)
W-SH-M	φ 8	70
W-SH-L	φ 12	150



Precautions for Use

The Brush will break off when:

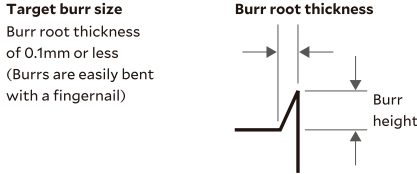
- being used beyond the maximum rotational speed
- being used with a pneumatic tool

Usage instructions on P30

Usage instructions on P31

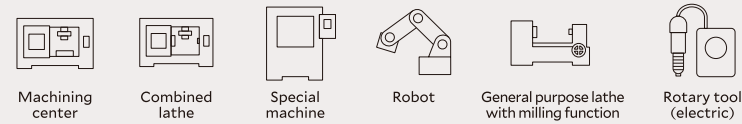
XEBEC Brush™ Crosshole

Ideal for deburring, polishing and cutter mark removal of inner diameter and counterbored part



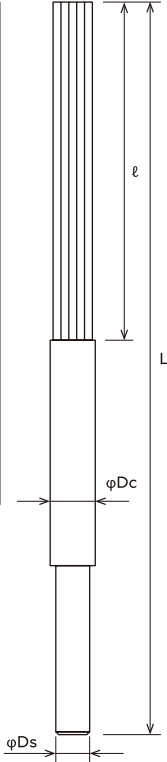
Applicable Equipment

The tool can be mounted on an equipment which can control the rotational speed. The tool must be rotated over 8000min-1.



Brush (Color)	Product code	Brush diameter (mm)	Shaft diameter Dc (mm)	Shank diameter Ds (mm)	Bristle length ℓ (mm)	Overall length L (mm)	Maximum rotational speed (min-1)	Target hole diameter (mm)
A12 (Red)	CH-A12-1.5M	φ 1.5	φ 2.5	φ 3	50	120	20000	φ 3.5-5
	CH-A12-3M	φ 3	φ 4	φ 3	50	120	14000	φ 5-8
	CH-A12-3L	φ 3	φ 4	φ 4	50	170	12000	φ 5-8
	CH-A12-5M	φ 5	φ 6	φ 6	50	120	14000	φ 8- 10
	CH-A12-5L	φ 5	φ 6	φ 6	50	170	12000	φ 8- 10
	CH-A12-7M	φ 7	φ 8	φ 6	50	120	14000	φ 10-20
	CH-A12-7L	φ 7	φ 8	φ 8	50	170	12000	φ 10-20
	CH-A12-11M	φ 11	φ 12	φ 12	50	120	14000	φ 14-20
	CH-A12-11L	φ 11	φ 12	φ 12	50	170	12000	φ 14-20
A33 (Blue)	CH-A33-3M	φ 3	φ 4	φ 3	60	130	14000	φ 5-8
	CH-A33-3L	φ 3	φ 4	φ 4	60	180	12000	φ 5-8
	CH-A33-5M	φ 5	φ 6	φ 6	60	130	14000	φ 8-10
	CH-A33-5L	φ 5	φ 6	φ 6	60	180	12000	φ 8-10
	CH-A33-7M	φ 7	φ 8	φ 6	60	130	14000	φ 10-14
	CH-A33-7L	φ 7	φ 8	φ 8	60	180	12000	φ 10-14
	CH-A33-11M	φ 11	φ 12	φ 12	60	130	14000	φ 14-20
	CH-A33-11L	φ 11	φ 12	φ 12	60	180	12000	φ 14-20

* The Brush size is approximate as the tip expands by rotating.
* CH-A12-3M/L, CH-A12-5M/L, and CH-A12-7M/L are equipped with a protection tube.



Precautions for Use

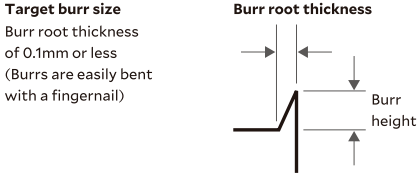
- The Brush will break off when:
- being machined beyond the maximum rotational speed
 - being used with a pneumatic tool
 - being rotated outside the cylinder (outside workpiece)

- In the following cases, the Brush may break off:
- off-center cross hole and angled cross hole
 - t-shaped hole: if the cross hole diameter is equal to or greater than the main bore diameter.
 - cross-shaped hole: if the cross hole diameter is more than 70% of the main bore diameter.

Usage instructions on P32

XEBEC Brush™ Crosshole Extra-Long

Suitable for deburring, polishing and cutter mark removal of inner diameter and counterbored part exceeding 150mm in depth



Tool composition

Brush, collar and shank are separate items.
(All special order items)

Applicable Equipment

The tool can be mounted on an full cover type equipment which can control the rotational speed. The tool must be rotated over 8000min-1.



Brush (Color)	Product code	Brush diameter (mm)	Shank diameter Ds (mm)	Overall length L (mm)	Maximum rotational speed (min-1)
A12 (Red)	*	φ 3	φ 4	400	12000
	*	φ 5	φ 6	400	12000
	*	φ 7	φ 8	400	12000
	*	φ 11	φ 12	400	12000
A33 (Blue)	*	φ 3	φ 4	410	12000
	*	φ 5	φ 6	410	12000
	*	φ 7	φ 8	410	12000
	*	φ 11	φ 12	410	12000

* This is a special order item. Please contact us for the details.
* The Brush size is approximate as the tip expands by rotating.

Precautions for Use

- The Brush will break off when:
- being machined beyond the maximum rotational speed
 - being used with a pneumatic tool
 - being rotated outside the cylinder (outside workpiece)

- In the following cases, the Brush may break off:
- off-center cross hole and angled cross hole
 - t-shaped hole: if the cross hole diameter is equal to or greater than the main bore diameter.
 - cross-shaped hole: if the cross hole diameter is more than 70% of the main bore diameter.

Usage instructions on P32



XEBEC Back Burr Cutter and Path™

Spherical deburring cutter and custom-made tool path

The combination of the spherical deburring cutter and the custom-made tool path enables hole deburring on a 3D curved edge in your CNC machine. High-speed and excellent quality deburring is achieved while maximizing the tool life. The tool path data can be used as soon as being installed on a NC program, saving your time to make your own program.

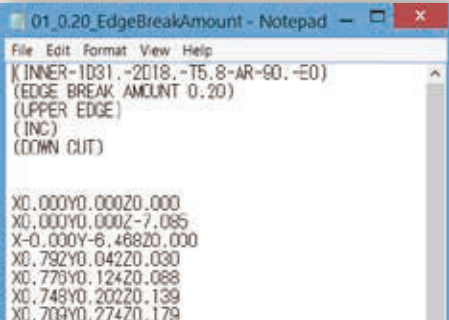
XEBEC Back Burr Cutter

- Micro-grain cemented carbide : Sharp and long lasting
- Highly heat-resistant AlTiCrN coating : Support materials from non-ferrous (e.g. aluminum) to difficult-to cut materials (e.g. titanium and inconel)
- Helical blade : Cleaner cutting edge and prevents secondary burrs



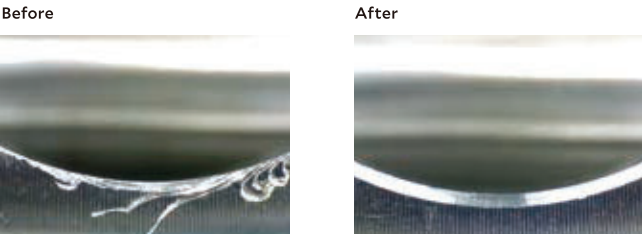
XEBEC Path

Custom-made tool path (point group data)



High quality

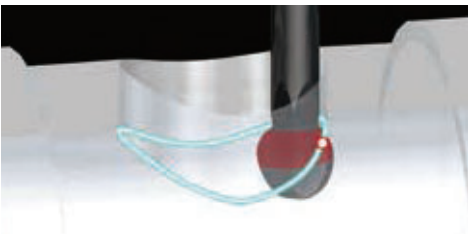
- Uniform edge shape thanks to an optimal tool path
- Inhibits secondary burrs by calculating optimal cutting angles



5 deburring amounts are provided for each Path. Refer to P33.

Long tool life

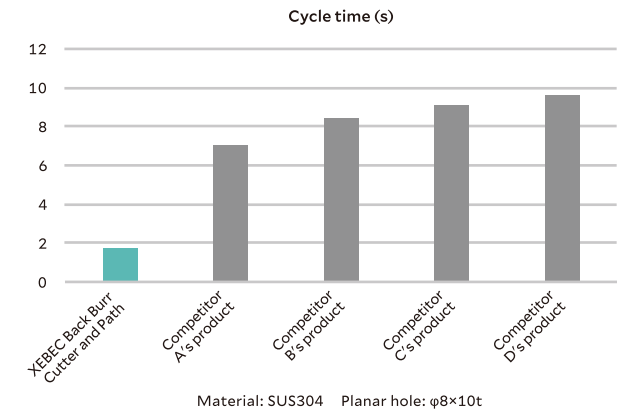
- Using the entire cutting blade by constantly shifting its contact point achieves longer tool life



Range of blade use

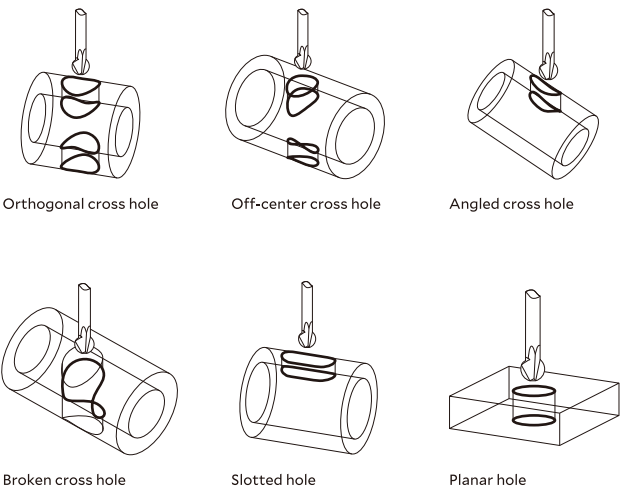
Super high-speed machining

- Cycle time is reduced because of single edge-contouring operation (5 to 10 times faster than conventional tools)



Applicable to various edge shapes

- 1 size of a Cutter supports various edges in different sizes and shapes. The cycle time is shortened by minimizing the number of tools used.

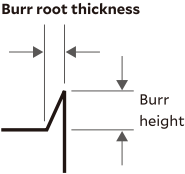


XEBEC Back Burr Cutter and Path™ Patented

Perfect for deburring both front and back of a drilled hole



Target burr size
Burr root thickness of 0.2mm or less (Burrs are bent with a fingernail)



Product component

Spherical deburring cutter and custom-made tool Path. Refer to P33 on how to order XEBEC Path.

Applicable equipment

The tool can be mounted on machining center (XYZ-axis) or combined lathe (XZY or XZC-axis). 3-axis simultaneous control is required.



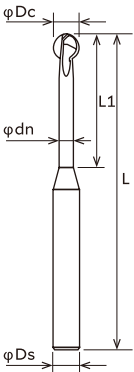
Machining center



Combined lathe

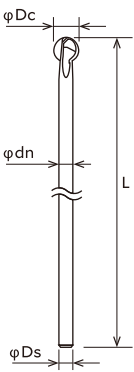
Regular type

Product code	Cutter diameter Dc (mm)	Cutter radius R (mm)	Neck diameter dn (mm)	Shank diameter Ds (mm)	Length under the neck L1 (mm)	Overall length L (mm)	Number of blades
XC-08-A	φ 0.8	0.4	φ 0.48	φ 3	5	60	2
XC-13-A	φ 1.3	0.65	φ 0.78	φ 3	8	60	2
XC-18-A	φ 1.8	0.9	φ 1.1	φ 3	10	60	2
XC-23-A	φ 2.3	1.15	φ 1.4	φ 3	12.5	70	2
XC-28-A	φ 2.8	1.4	φ 1.7	φ 4	15	70	2
XC-33-A	φ 3.3	1.65	φ 2.0	φ 4	17.5	70	2
XC-38-A	φ 3.8	1.9	φ 2.4	φ 4	20	70	2
XC-48-A	φ 4.8	2.4	φ 3.0	φ 4	25	70	2
XC-58-A	φ 5.8	2.9	φ 3.5	φ 4	30	70	2
XC-78-A	φ 7.8	3.9	φ 4.7	φ 8	40	100	3
XC-98-A	φ 9.8	4.9	φ 5.9	φ 10	50	120	3



Straight type

Product code	Cutter diameter Dc (mm)	Cutter radius R (mm)	Neck diameter dn (mm)	Shank diameter Ds (mm)	Overall length L (mm)	Number of blades
XC-18-B	φ 1.8	0.9	φ 1.1	φ 1.1	50	2
XC-23-B	φ 2.3	1.15	φ 1.4	φ 1.4	60	2
XC-28-B	φ 2.8	1.4	φ 1.7	φ 1.7	70	2
XC-33-B	φ 3.3	1.65	φ 2.0	φ 2.0	80	2
XC-38-B	φ 3.8	1.9	φ 2.4	φ 2.4	85	2
XC-48-B	φ 4.8	2.4	φ 3.0	φ 3.0	105	2
XC-58-B	φ 5.8	2.9	φ 3.5	φ 3.5	120	2



Precautions for Use

- XEBEC Buck Burr Cutter is designed for NC machines. Never use it as a hand tool.

Caution

- Advanced preview control function can reduce edge-shape error.
- The processing error of the hole position must be kept as small as possible.

Usage instructions on P33



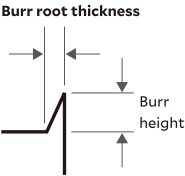
XEBEC Stone™

Made of unique ceramic fiber

XEBEC Stone™ Flexible Shaft

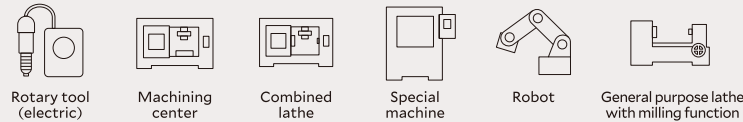
Flexible shaft allows soft contact with a workpiece and suppresses subtle vibration when being processed. Ideal for deburring both front and back of a drilled hole.

Target burr size
Burr root thickness
of 0.1mm or less
(Burrs are easily bent
with a fingernail)



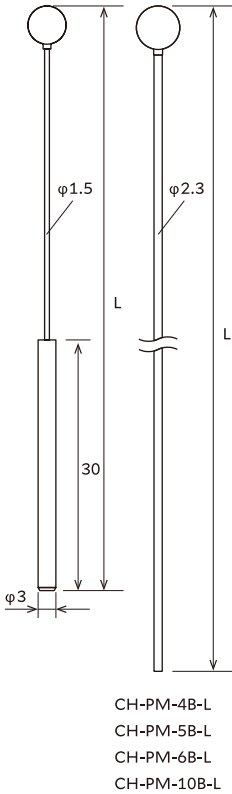
Applicable equipment

The tool can be mounted on an equipment which can control the rotational speed.



Ball type

Equivalent grit (Color)	Product code	Head size (mm)	Shaft diameter (mm)	Shank diameter (mm)	Overall length L (mm)	Recommended rotational speed (min-1)	Maximum rotational speed (min-1)
#800 (Blue)	CH-PB-3B	φ 3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PB-4B	φ 4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PB-5B	φ 5	φ 1.5	φ 3	70	5000-8000	12000
	CH-PB-6B	φ 6	φ 1.5	φ 3	70	5000-8000	10000
#400 (Orange)	CH-PO-3B	φ 3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PO-4B	φ 4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PO-5B	φ 5	φ 1.5	φ 3	70	5000-8000	12000
	CH-PO-6B	φ 6	φ 1.5	φ 3	70	5000-8000	10000
#220 (Gray)	CH-PM-3B	φ 3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PM-4B	φ 4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PM-5B	φ 5	φ 1.5	φ 3	70	5000-8000	12000
	CH-PM-6B	φ 6	φ 1.5	φ 3	70	5000-8000	10000
	CH-PM-10B	φ 10	φ 1.5	φ 3	70	4000-5000	6000
	CH-PM-3B-L	φ 3	φ 1.5	φ 3	150	—	1000
	CH-PM-4B-L	φ 4	φ 2.3	φ 2.3	150	—	3000
	CH-PM-5B-L	φ 5	φ 2.3	φ 2.3	150	—	3000
	CH-PM-6B-L	φ 6	φ 2.3	φ 2.3	150	—	3000
	CH-PM-10B-L	φ 10	φ 2.3	φ 2.3	150	—	2000



Cylinder type

Equivalent grit (Color)	Product code	Head size (mm)	Shaft diameter (mm)	Shank diameter (mm)	Overall length L (mm)	Recommended rotational speed (min-1)	Maximum rotational speed (min-1)
#800 (Blue)	CH-PB-3R	φ 3×3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PB-4R	φ 4×4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PB-5R	φ 5×5	φ 1.5	φ 3	70	5000-8000	12000
#400 (Orange)	CH-PO-3R	φ 3×3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PO-4R	φ 4×4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PO-5R	φ 5×5	φ 1.5	φ 3	70	5000-8000	12000
#220 (Gray)	CH-PM-3R	φ 3×3	φ 1.5	φ 3	70	5000-8000	15000
	CH-PM-4R	φ 4×4	φ 1.5	φ 3	70	5000-8000	13000
	CH-PM-5R	φ 5×5	φ 1.5	φ 3	70	5000-8000	12000
	CH-PM-5R-C01	φ 5x10	φ 1.5	φ 3	70	5000-8000	12000

Precautions for Use

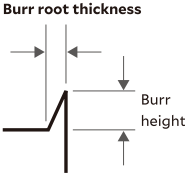
- The tool will break off when:
- being processed beyond the maximum rotational speed
 - being used with a pneumatic tool

XEBEC Stone™ Mounted Point

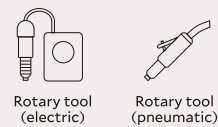
Suitable for using with a pneumatic tool at high rotational speed



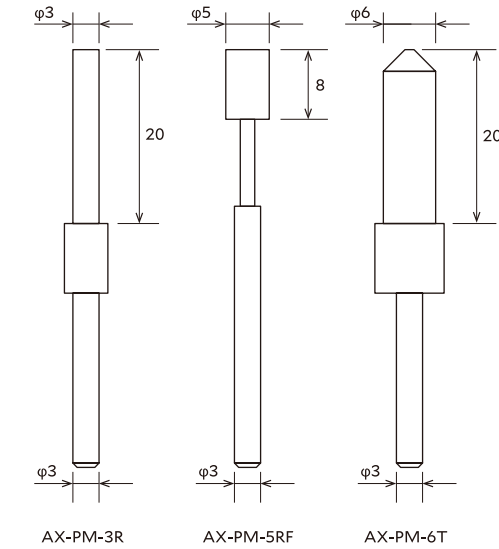
Target burr size
Burr root thickness
of 0.1mm or less
(Burs are easily bent
with a fingernail)



Applicable equipment



Equivalent grit (Color)	Product code	Head Size (mm)	Shank diameter (mm)	Head length (mm)	Maximum rotational speed (min-1)
#220 (Gray)	AX-PM-3R	φ 3	φ 3	20	60000
	AX-PM-5RF	φ 5	φ 3	8	30000
	AX-PM-6T	φ 6	φ 3	20	60000



Mobile Micromotor System

Designed for XEBEC products. Battery-powered tool which is usable where power supply is not available.
An ultra lightweight handpiece reduces work burden for long time use.



Product code	For use with	Maximum rotational speed (min-1)	Standard components
M2P33STX	φ3mm shank	30000	Handpiece with stand, controller on/off foot switch, power cable for charging

*About 5 hours of continuous use

Optional Tools

XEBEC Self-Adjusting Sleeve™

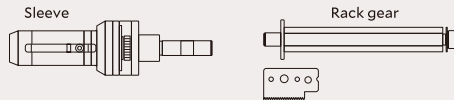
Predetermined brush length is automatically projected and assists unmanned operation.
Effective to eliminate human error, maintain optimal machining conditions and
consistent machining quality.

Target
XEBEC Brush Surface™
(φ6~40)



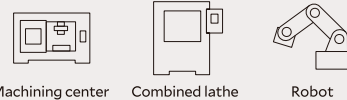
Tool schematic

It consists of a sleeve and a rack gear.
XEBEC Brush Surface is not included.

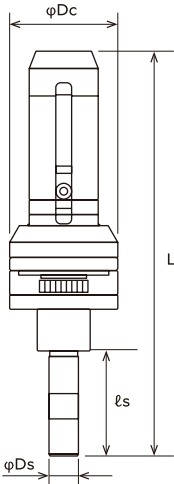


Applicable equipment

The tool can be mounted on a machine which enables to stop and
hold the sleeve at the fixed position.



Product code	Target brush (Product code)	Outermost diameter Dc (mm)	Shank diameter Ds (mm)	Overall length L (mm)	Shank length ℓs (mm)	Main body weight (g)	Maximum rotational speed (min-1)
XP-AUT06M	A13-CB06M	φ 37	φ 10	124.1	35	220	10000
	A11-CB06M						
	A21-CB06M						
	A32-CB06M						
XP-AUT15M	A13-CB15M	φ 37	φ 10	136.3	35	270	6000
	A11-CB15M						
	A21-CB15M						
	A32-CB15M						
XP-AUT25M	A11-CB25M	φ 60	φ 16	189	41.5	795	5000
	A21-CB25M						
	A32-CB25M						
XP-AUT40M	A11-CB40M	φ 60	φ 16	189	41.5	910	3000
	A21-CB40M						
	A32-CB40M						



XEBEC Floating Holder™

Straight shank type

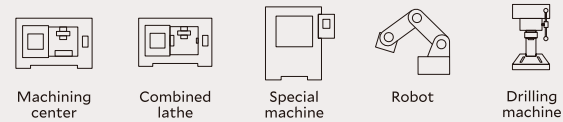
Patented

The built-in spring enables stable load, contributing to consistent edge quality and reduce the frequency to adjust the depth of cut.

Target
XEBEC Brush Surface™
(φ6~100)

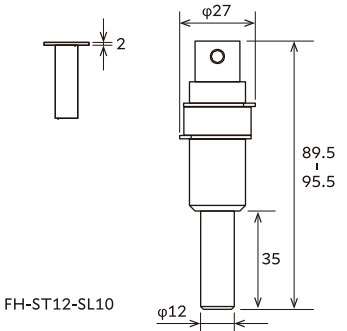


Applicable equipment

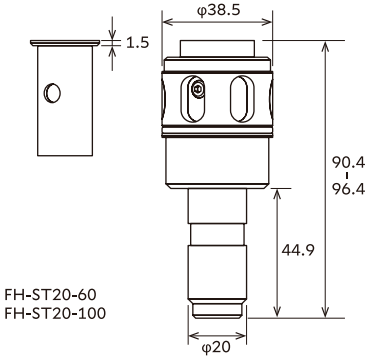


Product code	Target brush diameter (mm)	Diameter for the sleeve shank (mm)	Maximum rotational speed (min-1)	Accessories
FH-ST12-SL10	φ 6	φ 6 (with the supplied bush 1)	10000	1. φ 6 bush 2. φ 8 bush 3. Low-pressure spring 4. Standard spring* 5. High-pressure spring * Installed when shipped
	φ 15	φ 6 (with the supplied bush 2)	6000	
	φ 25	φ 8 (with the supplied bush 3)	5000	
	φ 40	φ 10	3000	
FH-ST20-60	φ 60	φ 12	2000	φ 12 bush
FH-ST20-100	φ 100	φ 16	1200	φ 16 bush

* Optional maximum pressure spring is available.
* Optional φ 3 bush is available.
* Please contact for the detail.



FH-ST12-SL10



FH-ST20-60
FH-ST20-100

Precautions for Use

- Approach the tool vertically when making it engaged with workpiece.
- It can not be used if there are intermittent machining or protrusions.
- Using on horizontal machining center, it may not function when spring load is low.

Usage instructions on P35

XEBEC Floating Holder™

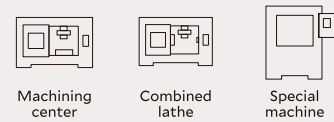
BT shank type

The built-in spring enables stable load, contributing to consistent edge quality and reduce the frequency to adjust the depth of cut.

Target
XEBEC Brush Surface™
(φ6~25)

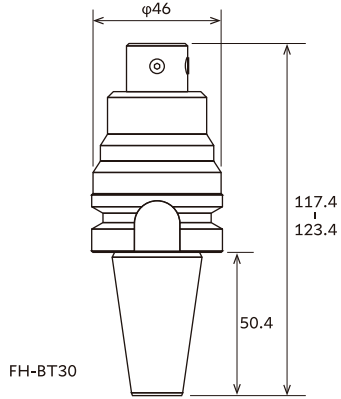


Applicable equipment

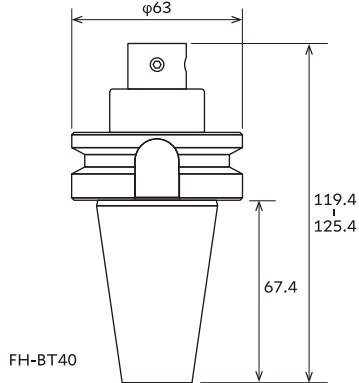


Product code	Target Brush diameter (mm)	Diameter for the sleeve shank (mm)	Maximum rotational speed (min-1)	Length under gauge line (mm)
FH-BT30	φ 6	φ6*	10000	75
	φ 15	φ6*	6000	
	φ 25	φ8	5000	
FH-BT40	φ 6	φ6*	10000	60
	φ 15	φ6*	6000	
	φ 25	φ8	5000	

* Optional φ 6 bush is available. Please contact for the detail.



FH-BT30



FH-BT40

Precautions for Use

- Approach the tool vertically when making it engaged with workpiece.
- It can not be used if there are intermittent machining or protrusions.
- Using on horizontal machining center, it may not function when spring load is low.

Usage instructions on P35

XEBEC Short BT Holder™

Compact tool holder whose length under the gage line is 23.5mm (including bush flange thickness 1.5mm). Effective where tool length is restricted.

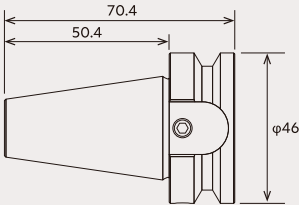
Product code	Target shank diameter (mm)
SH-BT30	φ20

* This is designed exclusively for XEBEC products.
* φ12 bush and φ16 bush are available. Please contact for the detail.



Target
XEBEC Brush Surface™
XEBEC Self-Adjusting Sleeve™
XEBEC Floating Holder™

Product schematic



Applicable equipment


Machining center


Combined lathe


Special machine

XEBEC Brush Length Adjustment Tool™

Jig for quick in-machine brush length adjustment.

Product code	Corresponding Brush diameter (mm)	Size of built-in hexagonal wrench (mm)
XP-EZ-001	φ15 / φ5 / φ40 / φ60 / φ100	1.5, 2.0



Target
XEBEC Brush Surface™
(φ15~100)

Usage instructions on P35

Technical Information

XEBEC Brush™ Surface

How to select

Refer to the chart below and select brush color based on the workpiece material, burr root thickness and target surface.

Deburring

Workpiece material	Resin	Copper / Brass		
		Aluminum		
		General steel		
			Stainless steel	
			Heat-resistant steel	Cast-iron
Thickness of burrs	Micro fine burrs			
		Burr root thickness (Up to 0.1mm)		
			Burr root thickness (0.1–0.2mm)	
Brush (Color)	A13(Pink)	A11(Red)	A21(White)	A32(Blue)
Grinding power	—————→ High			

Cutter mark removal and polishing

Workpiece material	Copper / Brass			
	Aluminum			
		General steel		
		Stainless steel		
		Heat-resistant steel		
Cast-iron				
	Hard-to-cut material			
Target Surface roughness	Ra0.1μm or better		Up to Ra0.1μm	
Brush (Color)	A13(Pink)	A11(Red)	A21(White)	A32(Blue)
Grinding power	—————→ High			

Processing conditions: Rotational speed

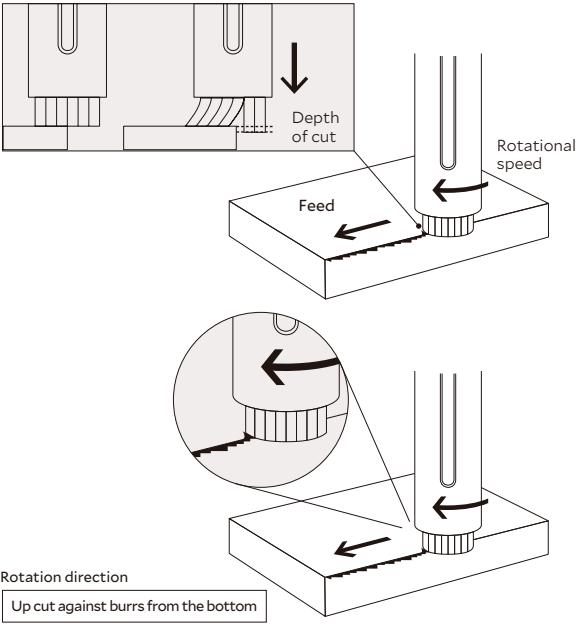
Recommended rotational speed and maximum rotational speed are different depending on Brush size. See the table below.

Feed rate

Burr root thickness	0.05mm (Can be bent easily)	→	4000mm/min
	0.1mm (Can be bent)	→	2500mm/min
Cutter mark removal		→	300mm/min

Depth of cut

Vertical burrs	→	0.5mm
Horizontal burrs	→	1.0mm
Cutter mark removal	→	0.5mm
Polishing	→	0.3–1.0mm



Initial processing conditions

Product code	Rotational speed (min ⁻¹)		Depth of cut (mm)				Feed rate (mm/min)			Brush projection (mm)
	Recommended	Maximum	Vertical burrs	Horizontal burrs	Cutter mark removal	Polishing	Burr root thickness 0.05mm	Burr root thickness 0.1mm	Cutter mark removal/ polishing	
A13-CB06M	8000	10000	0.5	0.5	0.5	0.3–0.5	4000	2500	300	10
A11-CB06M / A21-CB06M	8000	10000	0.5	0.5	0.5	0.3–0.5	4000	2500	300	10
A32-CB06M	8000	10000	0.3	0.3	0.3	0.2–0.3	4000	2500	300	10
A13-CB15M	4800	6000	1.0	1.0	0.5	0.3–0.5	4000	2500	300	10
A11-CB15M / A12-CB15M / A32-CB15M	4800	6000	0.5	1.0	0.5	0.3–0.5	4000	2500	300	10
A11-CB25M / A21-CB25M / A32-CB25M	4000	5000	0.5	1.0	0.5	0.3–0.5	4000	2500	300	15
A11-CB40M / A21-CB40M / A32-CB40M	2400	3000	0.5	1.0	0.5	0.3–0.5	4000	2500	300	15
A11-CB60M / A21-CB60M / A32-CB60M	1600	2000	0.5	1.0	0.5	0.3–0.5	4000	2500	300	15
A11-CB100M / A21-CB100M / A32-CB100M	960	1200	0.5	1.0	0.5	0.3–0.5	4000	2500	300	15

^{*}In the case of resin, workpiece material may melt or discolor depending on the material.
In such a case, decrease the rotational speed to about 1/10 of the recommended condition.

Dry/Wet Machining

The tool can be used for both dry and wet (oil-based and water-soluble) machining.
Wet machining may improve surface finish quality and tool life.

If burrs remain

1. Increase rotational speed

Increase the rotational speed to the maximum. If burrs still remain, then decrease the feed rate.

Brush diameter (mm)	Product code	Recommended rotational speed (min ⁻¹)	Maximum rotational speed (min ⁻¹)
φ 6	A13-CB06M / A11-CB06M / A21-CB06M / A32-CB06M	8000	10000
φ 15	A13-CB15M / A11-CB15M / A21-CB15M / A32-CB15M	4800	6000
φ 25	A11-CB25M / A21-CB25M / A32-CB25M	4000	5000
φ 40	A11-CB40M / A21-CB40M / A32-CB40M	2400	3000
φ 60	A11-CB60M / A21-CB60M / A32-CB60M	1600	2000
φ 100	A11-CB100M / A21-CB100M / A32-CB100M	960	1200
φ 125	A11-CB125M / A21-CB125M / A32-CB125M	800	1000
φ 165	A11-CB165M / A21-CB165M / A32-CB165M	600	750
φ 200	A11-CB200M / A21-CB200M / A32-CB200M	480	600

2. Check the rotation direction of the Brush

For horizontal burrs, up cut is recommended so that the brush tip pushes up the burrs.

3. Change the Brush color

Change the Brush with higher grinding power.
The grinding power of the Brush : Blue > White > Red > Pink
Make sure to select Brush color based on the workpiece material and burr root thickness.

If the edge is too rounded

1. Increase feed rate

To make sharp edge, increase the feed rate in 1000 mm/min increments within the range where burrs can be removed. Increasing the feed rate also helps reduce cycle time.

2. Decrease rotational speed

Decrease the rotational speed in 10 to 20% increments within the range where burrs can be removed.

3. Check the Brush color

The grinding power of the Brush : Blue > White > Red > Pink
Select Brush color based on the workpiece material and burr root thickness.

To extend tool life

1. Increase feed rate

Increase the feed rate in 1000 mm/min increments within the range where burrs can be removed.

2. Decrease rotational speed

Decrease the rotational speed in 10 to 20% within the range where burrs can be removed.

If the surface becomes rough

Check the Brush color

Change the Brush with higher edge quality.
Edge quality of the Brush : Pink > Red > White > Blue
Make sure to select Brush color based on the workpiece material and target surface roughness.

REFERENCE DATA: SURFACE ROUGHNESS AFTER DEBURRING			
	A11(Red)	A21(White)	A32(Blue)
A5052	Approx. Ra0.6 μm, Rz5.0 μm	—	—
S50C	—	Approx. Ra0.2 μm, Rz1.6 μm	—
SUS304	—	—	Approx. Ra0.3 μm,Rz2.4 μm

To improve surface roughness

1. Check the Brush color

Make sure to select appropriate Brush color. Edge quality of the Brush : Pink > Red > White > Blue

2. Wet machining

The tool can be used for both dry and wet (oil-based and water-soluble) machining. Wet machining may improve surface roughness and tool life.

3. Increase the number of passes

When comparing in the same cycle time, increasing the number of passes makes bigger difference than decreasing feed rate.

EXAMPLE

Rotational speed: 4000min-1 Depth of cut : 0.5mm Feed rate: 600mm/min The number of passes: 1	Rotational speed: 4000min-1 Depth of cut: 0.5mm Feed rate: 1200mm/min The number of passes: 2
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REFERENCE DATA: TOOL LIFE			
Material: Aluminum die-casting Process details: Deburring after face milling process Burr root thickness: 0.1mm Traveling distance: 1000mm/pcs Tool: A11-CB25M Rotational speed: 4000min-1 Feed rate: 2400mm/min Depth of cut: 1.0mm Used length: 50mm out of 75mm Tool life: 10km 10,000pcs (10km/1000mm)		Material: Carbon Steel S45C Process details: Deburring after end milling process Burr root thickness: 0.1mm Traveling distance: 200mm/pcs Tool: A21-CB25M Rotational speed: 4000min-1 Feed rate: 2000mm/min Depth of cut: 0.5mm Used length: 50mm out of 75mm Tool life: 3km 15,000pcs (3km/200mm)	

* Tool life significantly varies depending on processing conditions, burr conditions (size and direction) and workpiece material.
The above data is not guaranteed. Please use as a guide.

XEBEC Brush™ Surface Extra-Large

Initial processing conditions

Product code	Rotational Speed (min ⁻¹)		Depth of cut (mm)				Feed rate (mm/min)			Brush projection (mm)
	Recommended	Maximum	Vertical burrs	Horizontal burrs	Cutter mark removal	Polishing	Burr root thickness 0.05mm	Burr root thickness 0.1mm	Cutter mark removal/ Polishing	
A11-CB125M / A21-CB125M / A32-CB125M	800	1000	0.5	1.0	0.5	0.3-0.5	4000	2500	300	15
A11-CB165M / A21-CB165M / A32-CB165M	600	750	0.5	1.0	0.5	0.3-0.5	4000	2500	300	15
A11-CB200M / A21-CB200M / A32-CB200M	480	600	0.5	1.0	0.5	0.3-0.5	4000	2500	300	15

Please refer to the page of XEBEC Brush Surface for an improvement method when it does not work.

XEBEC Brush™ Surface End Type

How to select

Grinding power differs depending on Brush color.
Refer to the chart and select Brush color based on the workpiece material and burr root thickness.

Workpiece material	Resin	General steel	Stainless steel
	Copper/Brass		Heat-resistant steel
	Aluminum		Cast-iron
			Hard-to-cut material
Thickness of burrs	Micro fine burrs	Burr root thickness (Up to 0.1mm)	
Target Surface roughness	Ra0.1 μm or better		Up to Ra0.1 μm
Brush (Color)	A13(Pink)	A11(Red)	A21(White)
Grinding power	High		

XEBEC Brush™ Wheel Type

Initial processing conditions

Product code	Cutting speed (m/min)	Rotational speed (min-1)	Feed per bundle (mm/bundle)	Depth of cut (mm)	Feed rate (mm/min)
W-A11-50	250	1600	0.5	0.2	4800
W-A11-75	250	1000	0.5	0.2	3000

Pocessing Conditions Range

Product code	Cutting speed (m/min)	Feed per bundle (mm/bundle)	Depth of cut (mm)	Maximum rotational speed (min ⁻¹)
W-A11-50	150–350	1.5 or less	0.5 or less	3000
W-A11-75				

* As bristles are worn out, bristle length becomes shorter and increases stiffness, causing bristles to be broken. If bristles breakage occurs, decrease the depth of cut.

If burrs remain

- 1. Increase the number of passes
- 2. Decrease the feed rate in 10 to 20% increments

To extend tool life

Increase the feed rate in 10 to 20% increments

REFERENCE DATA: TOOL LIFE

Material: Carbon Steel S45C
Process details: Deburring after end milling
Burr root thickness: 0.1mm
Traveling distance: 120mm/pcs

Tool: W-A11-50
Cutting speed: 250m/min (Spindle Speed: 1600min-1)
Feed per bundle: 0.7mm/bundle (Feed rate: 7000mm/min)
Depth of cut: 0.2mm
Used length: 10mm out of 13.5mm

Tool life:
600m
5,000pcs (600m/120mm)

* Tool life significantly varies depending on processing conditions, burr conditions (size and direction) and workpiece material. The above data is not guaranteed. Please use as a guide.

XEBEC Brush™ Crosshole

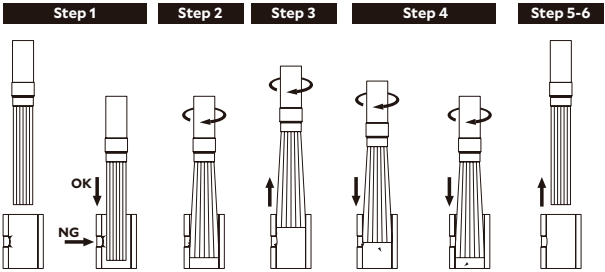
How to Select

Refer to the chart and select Brush color based on the workpiece material and burr root thickness.

Workpiece material	Resin	General steel
	Copper/Brass	Stainless steel
	Aluminum	
		Heat-resistant steel
		Cast-iron
Thickness of burrs	Micro fine burrs	
	Burr root thickness (Up to 0.1mm)	
Target Surface roughness	Ra0.1μm or better	
	Up to Ra0.1μm	
Brush (Color)	A12(Red)	A33(Blue)
Grinding power	High	

* XEBEC Brush has high grinding power on the tip. The Brush tip needs to be in contact with the processing area.

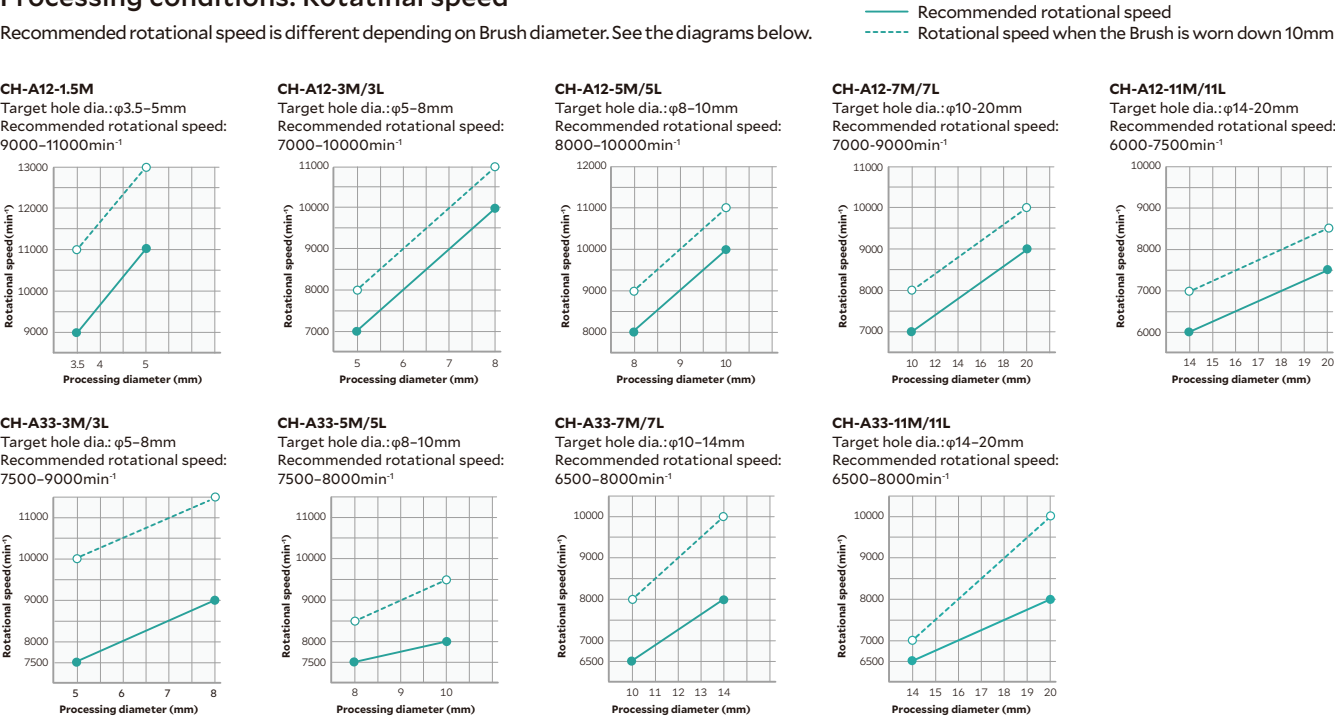
How to Use



- 1. Insert the Brush while not in motion.
 - * If you rotate the Brush outside the cylinder, the bristles may be damaged or scattered and may cause injury to an operator.
- 2. Rotate the tool past the crosshole
 - * Consistent edge quality can be obtained by rotating the tool in both CW and CCW direction.
- 3. Process while pulling the Brush back.
 - * Pulling the Brush back past the crossholes prevents burrs from being laid flat against the interior surface of the cylinder.
- 4. Process while pushing the Brush forward.
- 5. Stop the Brush rotation.
- 6. Remove the Brush while it is at rest.

Processing conditions: Rotatinal speed

Recommended rotational speed is different depending on Brush diameter. See the diagrams below.



FEED RATE: 300mm/min

If burrs remain

- 1. Increase rotational speed to the maximum in increments of 1000 min⁻¹
- 2. Increase the number of passes

If the workpiece cannot be deburred even by the above-mentioned procedures, the machining condition may be incorrect or the burr size is too large. Change the Brush with higher grinding power. The grinding power of the Brush : Blue > Red

To extend tool life

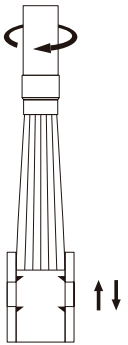
Decrease the rotational speed in 10% increments or increase the feed rate in 10% increments

REFERENCE DATA: TOOL LIFE

Material: Carbon Steel S45C
Process details: Cross hole deburring after drilling process
Burr root thickness: 0.1mm
Hole diameter :
Main bore Φ10mm
Cross hole Φ5mm

Tool: CH-A12-5M
Rotational speed: 10000min-1
Feed rate: 300mm/min
Used length: 10mm out of 50mm

Tool life : 4500 holes

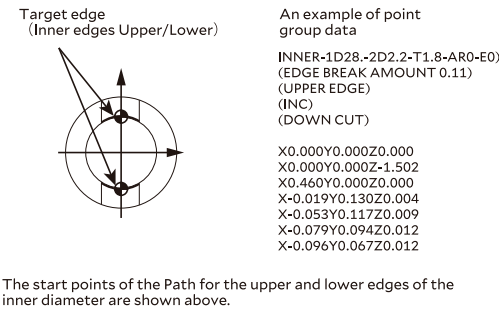


XEBEC Back Burr Cutter and Path™

Contents of XEBEC Path for Back Burr Cutter

- A set of Path data includes 2 cutting directions (up cutting/down cutting), 2 modes (incremental/absolute) and 5 kinds of deburring amounts. The contents differ depending on the edge type.
- Path data is provided as text data. (An example is shown on the right.)

An example of Path data provided



How to order XEBEC Back Burr Cutter and Path



Online “hole-deburring application form”

Online hole-deburring application form is available at <https://xebec-backburr-cutter.com/>
You can check whether “XEBEC Back Burr Cutter and Path” is applicable for your hole-burr problem and environment. The result is immediately available.



Initial processing conditions

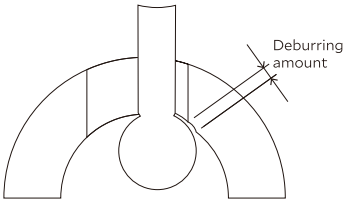
Product code	Cutter diameter (mm)	Projection amount	Spindle speed (min ⁻¹)	Feed rate (mm/min)
XC-08-A	φ 0.8	5D	43000	1300
XC-13-A	φ 1.3	5D	27000	800
XC-18-A	φ 1.8	5D	19500	580
XC-23-A	φ 2.3	5D	15000	750
XC-28-A	φ 2.8	5D	12500	1000
XC-33-A	φ 3.3	5D	10600	1060
XC-38-A	φ 3.8	5D	9200	1200
XC-48-A	φ 4.8	5D	7200	1100
XC-58-A	φ 5.8	5D	6000	900
XC-78-A	φ 7.8	5D	4500	1350
XC-98-A	φ 9.8	5D	3600	1080
XC-18-B	φ 1.8	10D*	4400	220
XC-23-B	φ 2.3	10D*	3500	220
XC-28-B	φ 2.8	10D*	2800	220
XC-33-B	φ 3.3	10D*	2400	190
XC-38-B	φ 3.8	10D*	2000	160
XC-48-B	φ 4.8	10D*	1600	120
XC-58-B	φ 5.8	10D*	1300	100

* Processing conditions above are for general steel or stainless steel. Refer to an instruction manual for aluminum alloy.
* Processing conditions of straight type (B) depends on projection amount. (Conditions on the table above are for projection amount 10D.)
* The spindle speed and table feed are rough standards for initial processing.
* If the spindle speed and /or table feed fail to meet the standard conditions listed in the table, or an abnormal vibration or noise occurs, decrease the spindle speed and table feed at an equal rate. Make sure to maintain the feed per rev (fn).

Deburring amounts and cumulative error

Product code	Cutter diameter (mm)	Deburring Amount (mm)					Allowable Cumulative Error (mm)
		1	2	3	4	5	
XC-08-A	φ 0.8	0.02	0.04	0.06	0.08	0.10	0.03
XC-13-A	φ 1.3	0.04	0.06	0.08	0.10	0.12	0.05
XC-18-A / B	φ 1.8	0.07	0.09	0.11	0.13	0.15	0.08
XC-23-A / B	φ 2.3	0.07	0.09	0.11	0.13	0.15	0.09
XC-28-A / B	φ 2.8	0.08	0.11	0.14	0.17	0.20	0.10
XC-33-A / B	φ 3.3	0.08	0.11	0.14	0.17	0.20	0.11
XC-38-A / B	φ 3.8	0.09	0.13	0.17	0.21	0.25	0.12
XC-48-A / B	φ 4.8	0.10	0.15	0.20	0.25	0.30	0.15
XC-58-A / B	φ 5.8	0.10	0.15	0.20	0.25	0.30	0.18
XC-78-A	φ 7.8	0.10	0.15	0.20	0.25	0.30	0.18
XC-98-A	φ 9.8	0.10	0.15	0.20	0.25	0.30	0.18

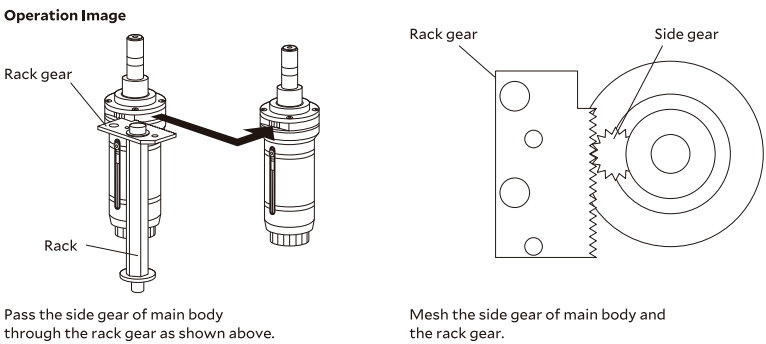
Deburring amount is a width of an edge after deburring with the Cutter as shown in the picture.



XEBEC Self-Adjusting Sleeve™

Mechanism

Predetermined brush length is automatically projected when the embedded side gear passes the rack gear which is mounted in a machine.

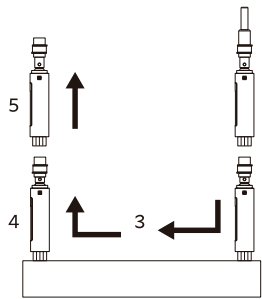


XEBEC Floating Holder™

How to use

Approach the Brush vertically when making it engaged with a workpiece. Don't contact the side of the Brush because it will cause damage to the bristles.

- 1. Approach the tool from above to the workpiece while not in motion.
- 2. Set the depth of cut and make the spring contracted.
- 3. Rotate the tool and start feeding.
- 4. Stop rotation and feeding of the tool when machining is completed.
- 5. Remove the tool upward



Spring load

FH-ST12-SL10

Spring type		Outer diameter (mm)	Spring constant (N/mm)	Overall length (mm)	Load by stroke (N)	
					0mm	6mm
Standard spring	Installed	φ10	0.3	40	4.5	6.3
Low-pressure spring	Attachment	φ10	0.3	30	1.5	3.3
High-pressure spring	Attachment	φ10	0.55	39	7.2	10.5
Maximum load spring	Sold separately	φ10	3.03	30	15.2	33.4

FH-BT30/40

Load adjustment	Load by stroke (N)		Adjustment Screw Position
	0mm	6mm	
Standard Float	2	6	When load adjustment screw 2 is at the end of the shaft.
Higher Float	6	10	When load adjustment screw 2 is at the back of the shaft.

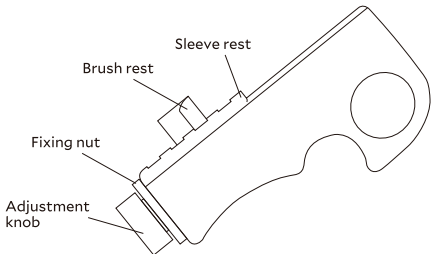
Maintenance

If the floating function doesn't work smoothly, sludge may have entered the tool. Disassemble the tool and clean the inside. Regular maintenance is recommended. See the instruction manual for the details. Lithium soap grease is recommended.

XEBEC Brush Length Adjustment Tool™

How to use

- 1. Move the brush rest using the adjustment knob to set the amount of brush projection.
- 2. Tighten the fixing nut.
- 3. Hold the unit in one hand, and align the sleeve rest with sleeve tip.
- 4. Loosen the screws to allow the brush to drop to the brush rest.
- 5. Tighten the screws to secure the Brush in place.



Please make sure to read the instruction manual before use.

In order to ensure safety, be sure to observe the operator safety protection and precautions for use listed below.

Precautions here in described are made available for the products to be used safely and to prevent injuries and/or damages from occurring to others. In order to specify the level of severity and urgency, they are classified as “warning” and “caution”. Be sure to observe the contents as all are related to safety.

“Warning”: Those with the potential to cause death or serious injury to people or to occur property damage if handled improperly.

“Caution”: Those with the potential to cause injuries to people or to occur property damage if handled improperly.



WARNING

Operator Safety Protection

Use of protective equipment

Wear safety glasses, protective gloves and masks when processing the tool. Wear clothing with long sleeves or other clothing that does not expose the skin, and fasten the cuffs and hems tightly.

Use of protective cover

Install covers on the machine tool and special-purpose machine, and use them while they are protected safely with the covers. Implement sufficient safety measures in order to ensure one's physical safety in the unlikely event of fragments scattering.

Beware of cutting particles

Cutting particles and burrs may scatter within the work area as the brush rotates ; please stay clear of this area.

Caution to your surroundings

The work area is hazardous in case fragments or cutting particles scatter, enclose the work area to prevent other people from entering, or have people around the work area wear protective equipment.

If these safety measures are neglected, there are following risks.

- Fragments and/or cutting particles can get into the eyes and cause loss of sight in the worst case.
- Fragments and/or cutting particles pierce skin of workers and cause injury.
- Dust generated from processing can cause lung damage, irritate skin, and bring on allergic reactions.



CAUTION

Be sure to collect dust during processing and clean thoroughly after processing.

If the dust collection and cleaning are insufficient, dust may adversely affect the sliding parts of machines.

Precautions for use

Perform test operation for 1 minute or more before starting work, and for 3 minutes or more after the machine tool or product was changed. Check that there is no looseness and vibration. Stop the operation immediately with any sign of abnormality of the machine and the part where the product is installed.

There is the risk of operator loss of sight or injury resulting from the product detaching from the processing equipments, bristles breaking off, workpieces breaking, etc.

Stop the operation immediately with any sign of abnormality such as vibration while in use.

There is the risk of operator loss of sight or injury resulting from the product detaching from the processing equipments, bristles breaking off, workpieces breaking, etc.

Never use at a rotational speed exceeding the maximum rotational speed.

Make sure to set the processing conditions based on the instruction manual. Usage over maximum rotational speed may result in not only breakage of tools, machines and workpieces but also blindness or injury.

Usage over maximum rotational speed may cause the risk of operator loss of sight or injury resulting from bristles breaking off, workpieces breaking, etc.

Successful Applications



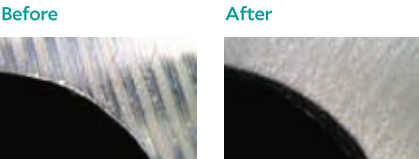
Gasoline-fueled vehicles

Adopted in engine parts which require high precision among other automotive parts.

Cylinder head - deburring



Material : ADC12
Previous process :
Face milling
Tool :
XEBEC Brush™ Surface
(A11-CB100M)



Problem
Deburring with a nylon brush was time-consuming and burrs remained after the deburring process. Sludges of a nylon brush contaminated the coolant and caused extra work to remove the dirt attached to the workpiece.

Effect
Achieved high-feed processing and cycle time shortened by 80%. Additionally, the dirt of the coolant was reduced to 1/3 or less and saved a lot of time washing off the dirt on workpiece.

Camshaft - deburring



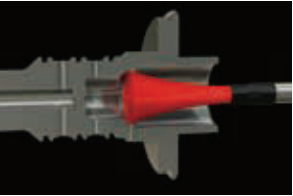
Material : FCD
Previous process : Drilling
Tool :
XEBEC Back Burr Cutter and Path™
(XC-38-A)

Pulley - deburring



Material : Scr420
Previous process : Side milling
Tool :
XEBEC Brush™ Surface
(A32-CB25M)

Input shaft - deburring



Material : SCM
Previous process : Drilling
Tool :
XEBEC Brush™ Crosshole
(CH-A12-7M)

Electric and hybrid vehicles

Introduced in electric and hybrid vehicle parts.

Cooling parts - deburring



Problem
Burrs are generated on the outer periphery of the pins. Manual deburring was time-consuming and the edge quality was inconsistent. Horizontal burrs were not removed completely by a nylon brush.

Effect
Succeeded in CNC deburring with a simple tool path. The edge quality becomes stable and the cycle time was decreased.

Pinion gear - deburring



Material : S45C
Previous process : Gear cutting
Tool :
XEBEC Brush™ Surface
(A32-CB40M)

Yoke - deburring



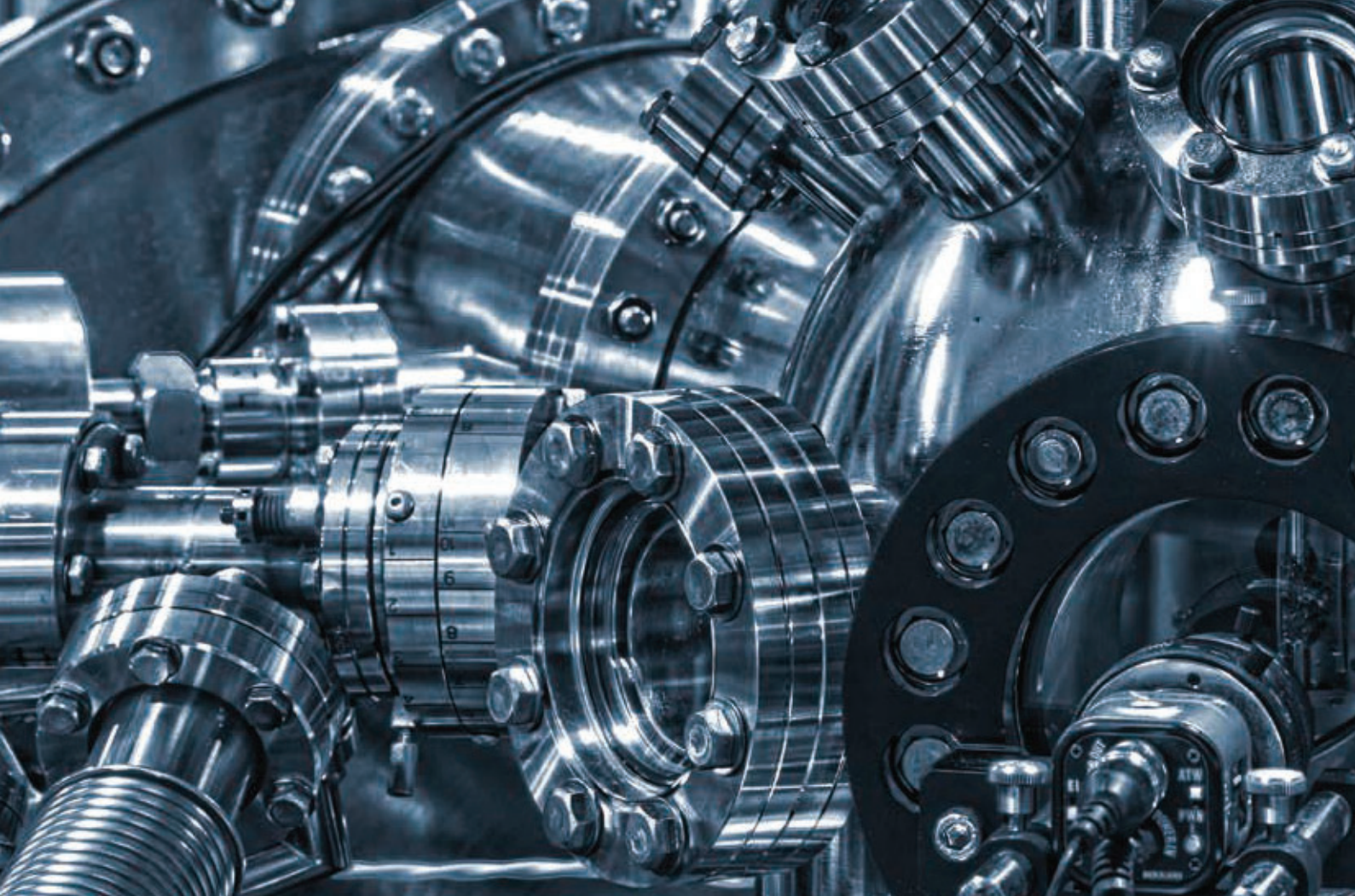
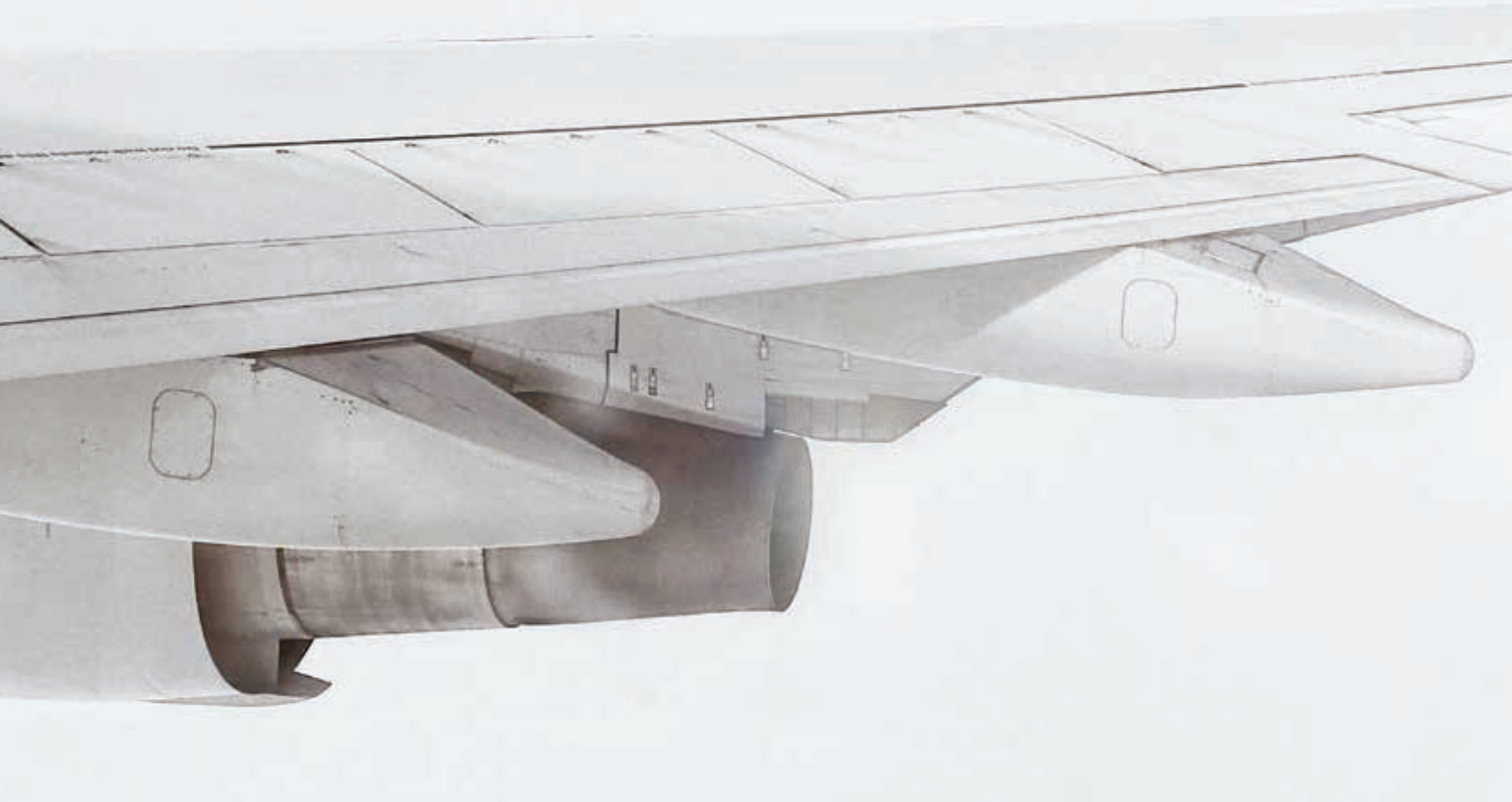
Material : SCM
Previous process : Drilling
Tool :
XEBEC Back Burr Cutter and Path™
(XC-58-A)

Control box - deburring



Material : Aluminum alloy
Previous process : Face milling
Tool :
XEBEC Brush™ Surface
(A11-CB25M)

Successful Applications



Aircrafts

Adopted in deburring and polishing of aircraft parts which require high precision.

Turbine blade - deburring



Material : SUS316
Previous process :
Ball-end milling
Tool :
XEBEC Brush™ Surface
(A11-CB25M)



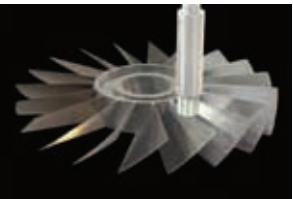
Problem

In order to avoid defective pieces, the parts were manually deburred using a file but it was time-consuming.

Effect

CNC deburring shortened cycle time and the scrap rate went to zero.

Blisk - deburring



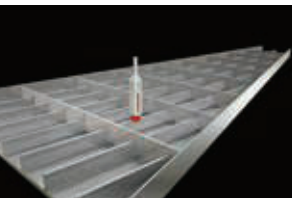
Material : Inconel
Previous process :
Ball-end milling
Tool :
XEBEC Brush™ Surface
(A21-CB25M)

Turbine disk - deburring



Material : Inconel
Previous process :
Grinding
Tool :
XEBEC Brush™ Surface
(A11-CB40M)

Wing rib - deburring

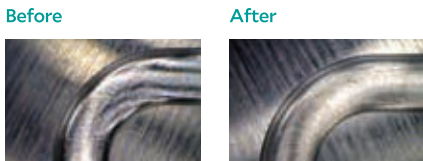
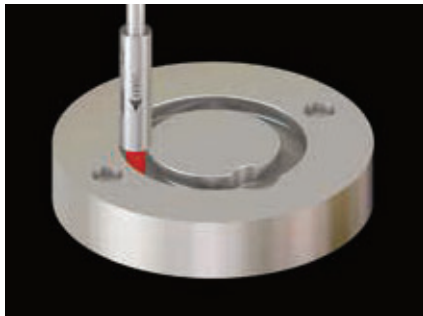


Material : Aluminum
Previous process : End milling
Tool :
XEBEC Brush™ Surface
(A11-CB25M)

Other fields

Adopted in various fields such as semiconductor, construction machinery and medical parts.

Vacuum device - cutter mark removal



Problem

Manual polishing on sealing surface was time-consuming. Polishing process was depending on a worker's skill and daily workload was limited.

Effect

Rough to medium polishing was successfully operated on machine and manual polishing was shortened from 35 minutes to 1 minute.

Tool holder - deburring



Material : Iron-based
Previous process :
Face milling
Tool :
XEBEC Brush™ Surface
(A32-CB40M)

Hydraulic component - deburring



Material : SCM
Previous process : Drilling
Tool :
XEBEC Back Burr Cutter and Path™
(XC-58-A)

Artificial bone - cutter mark removal



Material : SUS
Previous process : End milling
Tool :
XEBEC Brush™ Surface
(A32-CB06M)

About XEBEC

Beautiful deburring

Since 2002, XEBEC has been assisting machine workshops around the world in CNC deburring.

Today, we are challenging to minimize lead time which takes to solve deburring problems as close to zero by making the best of our knowledge and experiences.

“Change the myth of deburring and enhance the value of the finishing process.”

“Creating the world where people can use their talent in creative fields.”

This is what XEBEC will strive for.

XEBEC’s 3 innovations

Technology Innovation	In order to provide essential and overwhelming solutions, we will continue technological innovation through the integration of scientific technologies, from material to software and hardware.
Process Innovation	We will continue to offer the best and innovative methods beyond the established concepts for all business processes such as marketing, manufacturing, sales and delivery.
Precision Management	We will continue to focus on quality and precision management in all aspects, including consistent product quality, shipping accuracy and swift and careful customer support.

Corporate Outline			
Corporate Name	XEBEC TECHNOLOGY CO.,LTD.	President & CEO	Norihiko Sumiyoshi
Incorporated	June 3, 1996	Location	Head Office Fuerte Kojimachi 1・7 Building 8th floor, 1-7-25 Kojimachi, Chiyoda-ku, Tokyo, 102-0083, Japan
Business area	Development, manufacturing and sales of industrial deburring and polishing tools		
Capital	99 million Japanese Yen		TEL.+81-3-3239-3481 FAX.+81-3-5211-8964

History

