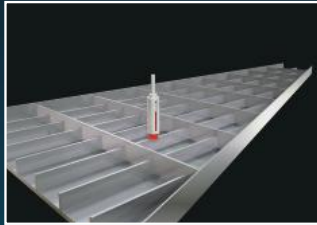
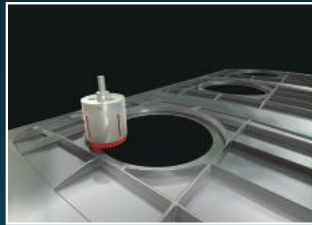


Part	Wing Rib
Material	Aluminum Alloy
Details	Deburring of end milled surface
Tool Used	Xebec Brush™ Surface A11-CB25M
Parameters	Rotation Speed: 4000min ⁻¹ Depth of Cut: 0.028in Feed: 134 IPM



Part	Body
Material	Aluminum Alloy
Details	Deburring of end milled surface
Tool Used	Xebec Brush™ Surface A11-CB100M
Parameters	Rotation Speed: 960min ⁻¹ Depth of Cut: 0.026in Feed: 134 IPM



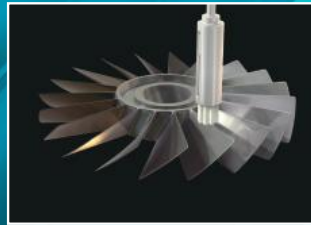
Part	Landing gear part
Material	Aluminum Alloy
Details	Deburring of milled surface
Tool Used	Xebec Brush™ Surface A11-CB40M
Parameters	Rotation Speed: 3000 ⁻¹ Depth of Cut: 0.031in Feed: 147 IPM



Part	Turbine disk
Material	Inconel
Details	Deburring of grinded surface
Tool Used	Xebec Brush™ Surface A31-CB40M
Parameters	Rotation Speed: 1500 ⁻¹ Depth of Cut: 0.020in Feed: 94 IPM



Part	Turbine blade
Material	SU316
Details	Deburring of ball end milled surface
Tool Used	Xebec Brush™ Surface A11-CB25M
Parameters	Rotation Speed: 1000 ⁻¹ Depth of Cut: 0.020in Feed: 94 IPM



Part	Blisk
Material	Inconel
Details	Deburring of ball end milled surface
Tool Used	Xebec Brush™ Surface A21-CB25M
Parameters	Rotation Speed: 4000 ⁻¹ Depth of Cut: 0.020in Feed: 94 IPM



Surface Brushes & sleeves

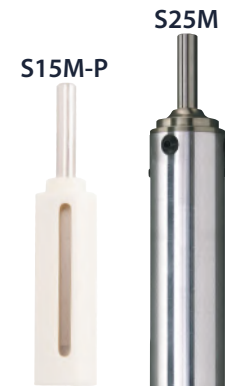


XEBEC Brush™ Surface

Brush Dimensions				Aggressiveness Less <<<<<<<<>>>>>>>>> More				Required sleeve to hold brush (see below)	Max RPM
Diameter		Length		Pink	Red	White	Blue		
mm	in	mm	in						
6	0.236	30	1.181	A13-CB06M EDP 30015	A11-CB06M EDP 30006	A21-CB06M EDP 30012	A31-CB06M EDP 30021	S06M	10,000
15	0.591	50	1.969	A13-CB15M EDP 30013	A11-CB15M EDP 30005	A21-CB15M EDP 30011	A31-CB15M EDP 30020	S15M-P	6,000
25	0.984	75	2.953		A11-CB25M EDP 30004	A21-CB25M EDP 30010	A31-CB25M EDP 30019	S25M	5,000
40	1.575	75	2.953		A11-CB40M EDP 30003	A21-CB40M EDP 30009	A31-CB40M EDP 30018	S40M	3,000
60	2.363	75	2.953		A11-CB60M EDP 30002	A21-CB60M EDP 30008	A31-CB60M EDP 30017	S60M	2,000
100	3.937	75	2.953		A11-CB100M EDP 30001	A21-CB100M EDP 30007	A31-CB100M EDP 30016	S100M	1,000

XEBEC Brush™ Sleeve

Sleeve Description	EDP#	Dimensions							
		Shank				Sleeve external diameter		Overall Length	
		Diameter mm	Diameter in	Length mm	Length in	mm	in	mm	in
S06M	40006	6	0.236	29	1.142	10	0.394	70	2.756
S15M-P	40007	6	0.236	29	1.142	18	0.709	90	3.543
S25M	40004	8	0.315	30	1.181	30	1.181	140	5.511
S40M	40003	8	0.315	30	1.181	45	1.771	140	5.511
S60M	40002	12	0.472	40	1.575	65	2.559	150	5.906
S100M	40001	16	0.630	35	1.378	110	4.330	162	6.378



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