



XEBEC[®]
 Deburring Technologies, LLC

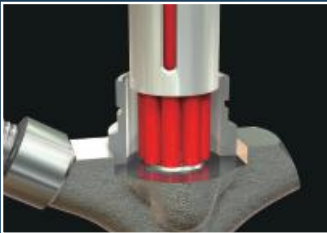
Successful Applications
AUTOMOTIVE

Part Rocker Arm
Material SCr420
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A11-CB40M
Parameters Rotation Speed: 3000min⁻¹
 Depth of Cut: 0.020in
 Feed: 80 IPM



Part Exhaust Manifold
Material AC4C
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A21-CB60M
Parameters Rotation Speed: 1000min⁻¹
 Depth of Cut: 0.020in
 Feed: 120 IPM

Part Injector Body
Material SCM
Details Deburring of grinded surface
Tool Used Xebec Brush™ Surface
 A11-CB15M
Parameters Rotation Speed: 1800min⁻¹
 Depth of Cut: 0.017in
 Feed: —



Part Cam Cap
Material ADC12
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A11-CB40M
Parameters Rotation Speed: 1941min⁻¹
 Depth of Cut: 0.020in
 Feed: 147 IPM



Part Connecting Rod
Material S45C
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A31-CB60M
Parameters Rotation Speed: 1300min⁻¹
 Depth of Cut: 0.016in
 Feed: 54 IPM



Part Crank Shaft
Material S48C
Details Crosshole deburring
Tool Used Xebec Stone™ Flexible Shaft
 CH-PM-5R-C01
Parameters Rotation Speed: 1350min⁻¹
 Depth of Cut: 0.020in
 Feed: —



Part Housing
Material Sintered metal
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A11-CB40M
Parameters Rotation Speed: 500min⁻¹
 Depth of Cut: 0.020in
 Feed: 80 IPM



Part Cylinder Head
Material ADC12
Details Deburring of milled surface
Tool Used Xebec Brush™ Surface
 A11-CB100M
Parameters Rotation Speed: 900min⁻¹
 Depth of Cut: 0.030in
 Feed: 160 IPM

106 West Ohio Avenue | Mount Vernon, OH 43050 | 1-800-306-5901

www.deburringtechnologies.com

XEBEC Brush™ Surface

Brush Dimensions				Aggressiveness				Required sleeve to hold brush (see below)	Max RPM
Diameter		Length		Less <<<<<<<<>>>>>>>> More					
mm	in	mm	in	Pink	Red	White	Blue		
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 Stone™ Flexible Shaft

Head		Aggressiveness			Max RPM
Shape	Size	Less <<<<<<<<>>>>>>>> More			
		Blue - #800	Orange - #400	Gray - #220	
Ball	3 mm 0.118 in	CH-PB-3B EDP 10001	CH-PO-3B EDP 10008	CH-PM-3B EDP 10015	15,000
	4 mm 0.157 in	CH-PB-4B EDP 10002	CH-PO-4B EDP 10009	CH-PM-4B EDP 10016	13,000
	5 mm 0.197 in	CH-PB-5B EDP 10003	CH-PO-5B EDP 10010	CH-PM-5B EDP 10017	12,000
	6 mm 0.236 in	CH-PB-6B EDP 10004	CH-PO-6B EDP 10011	CH-PM-6B EDP 10018	10,000
	10 mm 0.393 in			CH-PM-10B EDP 10027	7,000
Cylinder	3 x 3 mm 0.118 x 0.118 in	CH-PB-3R EDP 10005	CH-PO-3R EDP 10012	CH-PM-3R EDP 10019	15,000
	4 x 4 mm 0.157 x 0.157 in	CH-PB-4R EDP 10006	CH-PO-4R EDP 10013	CH-PM-4R EDP 10020	13,000
	5 x 5 mm 0.197 x 0.197 in	CH-PB-5R EDP 10007	CH-PO-5R EDP 10014	CH-PM-5R EDP 10021	12,000
	5 x 10 mm 0.197 x 0.393 in			CH-PM-5R-C01 EDP 10022	12,000

Win the Race for Productivity with Xebec!

106 West Ohio Avenue | Mount Vernon, OH 43050 | 1-800-306-5901

www.deburringtechnologies.com