



XE BEC

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TECH TIP

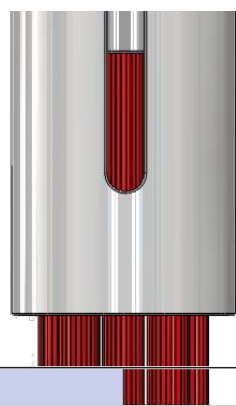
Question: How to compensate for tool wear?

Answer:

After running a series of parts, calculate approximate tool wear and program an automatic offset.

UNUSED CONDITION

Depth of cut: 0.020"



Depth of cut: 0.020"

AFTER 100 PCS DEBURRING

Tool wear: 0.004" Depth of Cut: 0.016"



Depth of Cut: 0.016"
Tool wear: 0.004"

OFFSET PROGRAM SETTING

Offset Cut: 0.004" per 100pcs Depth of Cut: 0.020"

Offset 0.1mm



Depth of cut: 0.020"

- Set depth of cut (0.020")
- After running a series of parts, measure the brush length to calculate tool wear. For example, when it wears 0.004" after 100 pcs.
- Offset 0.004" per 100 pcs. When you offset at shorter intervals as 0.039 inch/pc, you can expect longer tool life.
- Projection length from a sleeve needs to be adjusted, when it becomes shorter than 0.20"