

Question: What are the starting parameters for deburring and polishing?

Answer:

Deburring Parameters

RPM: 80% of the maximum speed

D.O.C : 0.020" for vertical burr, 0.040" horizontal burr

Feed Rate: 160 inches/min when burr thickness is less than 0.004"*¹ 100 inches/min more than 0.004"*²

*1 Burr can be bent by fingernail *2 Burrs CANNOT be bent by fingernail




Polishing Parameters

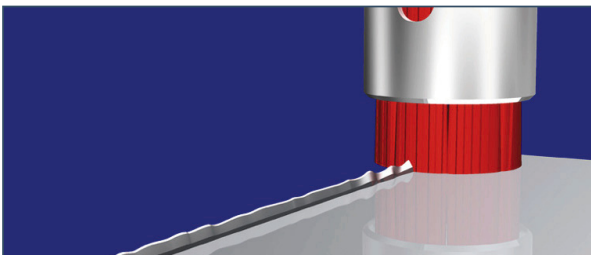
RPM: 80% of the maximum speed

D.O.C : .0.012"

Feed Rate: 20 inches/min

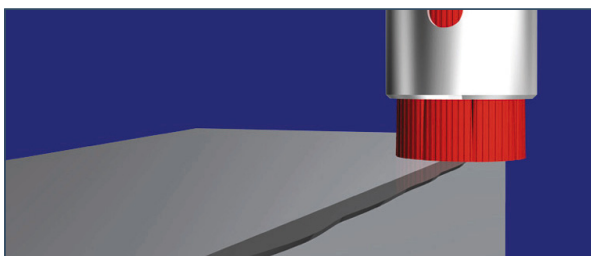
MATERIAL / BRUSH CHOICE

MATERIAL		1st Brush Choice	2nd Brush Choice
Aluminum		●	○
Steel		○	●
Hard to cut		●	○



VERTICAL BURR

Burr that is upwardly generated on edge after end milling or drilling. In this case, tip of a brush can contact the burr vertically.



HORIZONTAL BURR

Burr that is sideways-generated on edge after face milling. In this case, tip of a brush can contact the burr horizontally.

