

Common Rail

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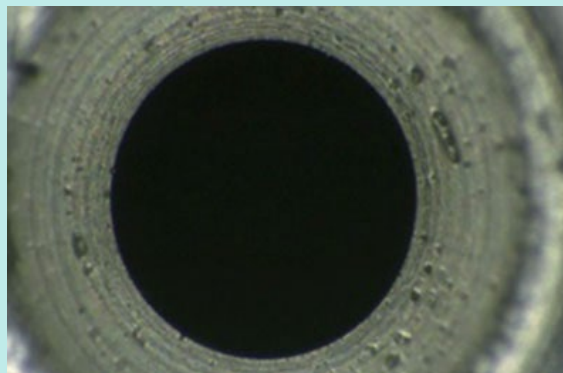
Workpiece information

Industry	Automotive
Part name	Common rail
Material type	S48C
Cutting process	Grinding

Processing conditions

Tool	XEBEC Brush Surface (A21-CB25M) XEBEC Floating Holder (FH-ST12)
Processing detail	Deburring the seal surface after grinding process
Spindle Speed (min ⁻¹)	3,000
Depth of cut (mm)	4

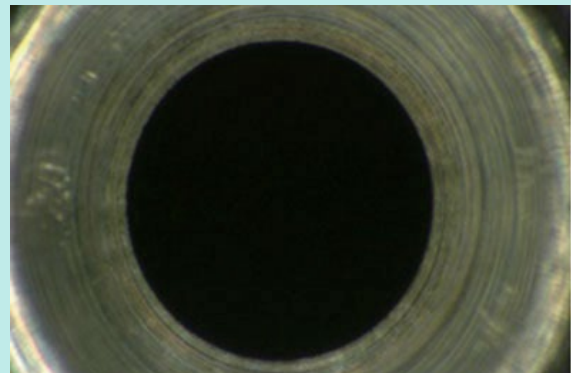
Before



Tool Sandpaper

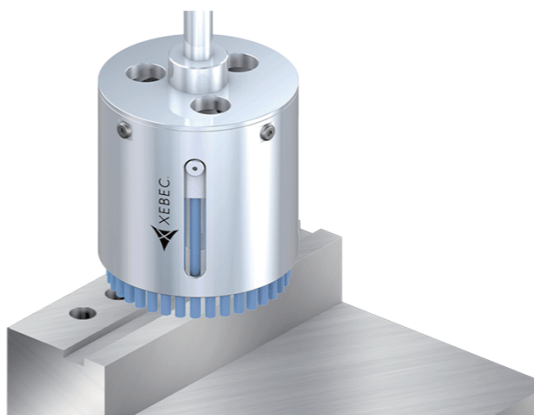
Problem Low production rate due to unstable surface roughness. Short tool life of sandpaper caused a cost problem.

After



Tool XEBEC Brush for Surface (A21-CB25M)
XEBEC Floating Holder (FH-ST12)

Result Required surface roughness realized in shorter cycle time. Reduction of labor costs corresponding to 20 hours of manual deburring work with sandpaper has been achieved.



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

Tool > XEBEC Brush™ Surface

Ideal for deburring, cutter mark removal and polishing on surface

