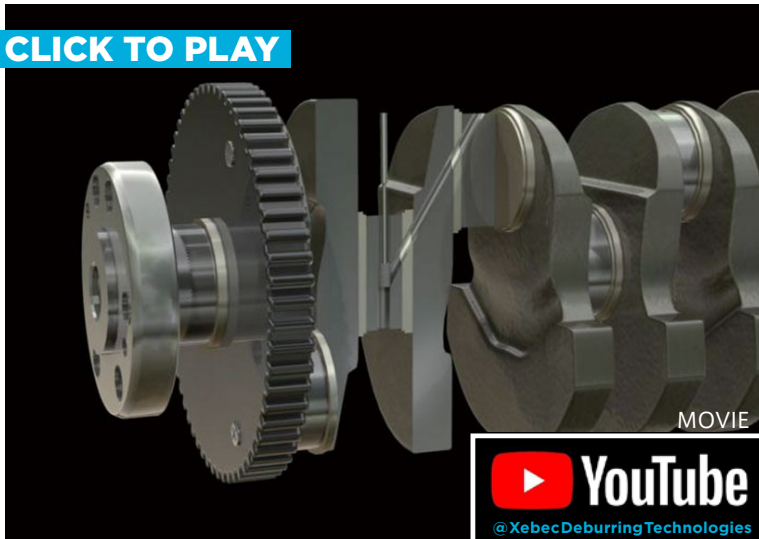


Crankshaft (Cross hole)

CLICK TO PLAY



Workpiece information

Industry	Automotive
Part name	Crankshaft (Cross hole)
Material type	S48C
Cutting process	Drilling

Processing conditions

Tool	XEBEC Stone Flexible Shaft (CH-PM-5R-C01)
Processing detail	Cross-hole deburring after drilling process
Spindle Speed (min ⁻¹)	1,350
Table Feed (mm/min)	—
Depth of cut (mm)	0.5
Machining time (sec)	—

Before

Tool Cutter

Problem Burrs left by manual deburring. Caused low production rate.

After

Tool XEBEC Stone Flexible Shaft (CH-PM-5R-C01)

Result By introduction of automated deburring with machining center, stable edge quality and cost reduction realized.



Hole deburring

Tool > XEBEC Stone™ Flexible Shaft

Flexible shaft allows soft contact with a workpiece and suppresses subtle vibration when being processed.

Ideal for deburring the front and back of drilled holes both.

