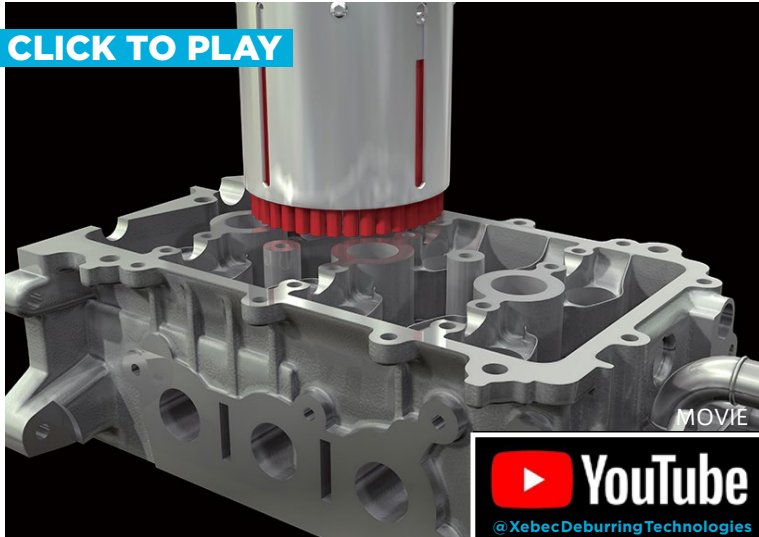


Cylinder head (Matching surface)



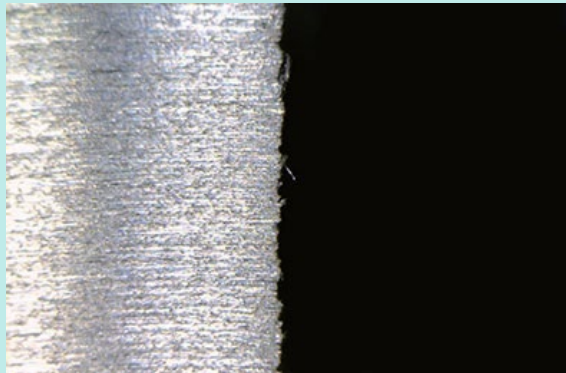
Workpiece information

Industry	Automotive
Part name	Cylinder head (Matching surface)
Material type	ADC12
Cutting process	Face milling processing

Processing conditions

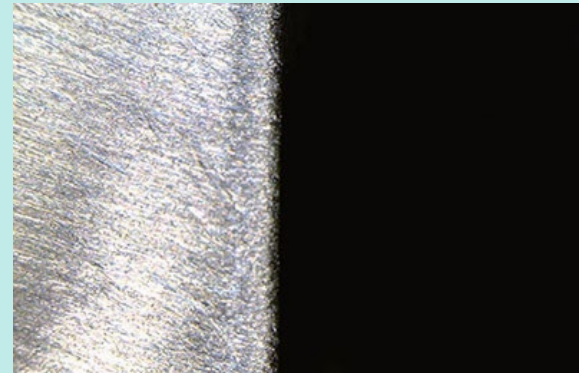
Tool	XEBEC Brush Surface (A11-CB100M)
Processing detail	Deburring of the matching surface after face milling process.
Spindle Speed (min ⁻¹)	1,350
Table Feed (mm/min)	2,000
Depth of cut (mm)	0.5
Machining time (sec)	—

Before

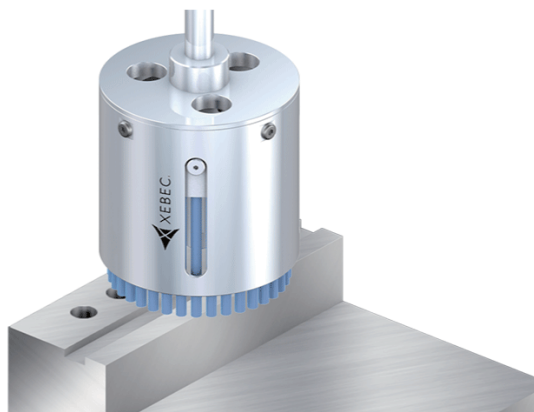


Tool	Abrasives-impregnated nylon brush
Problem	It took long hours for deburring and burrs still remained after processing due to low grinding power. Moreover, workpiece was stained by nylon brushes and man-hour is required for cleaning.

After



Tool	XEBEC Brush for Surface (A11-CB100M)
Result	Shorter cycle time was realized by high-feed processing. Coolant contamination was reduced to one third and man-hour for cleaning saved.



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

