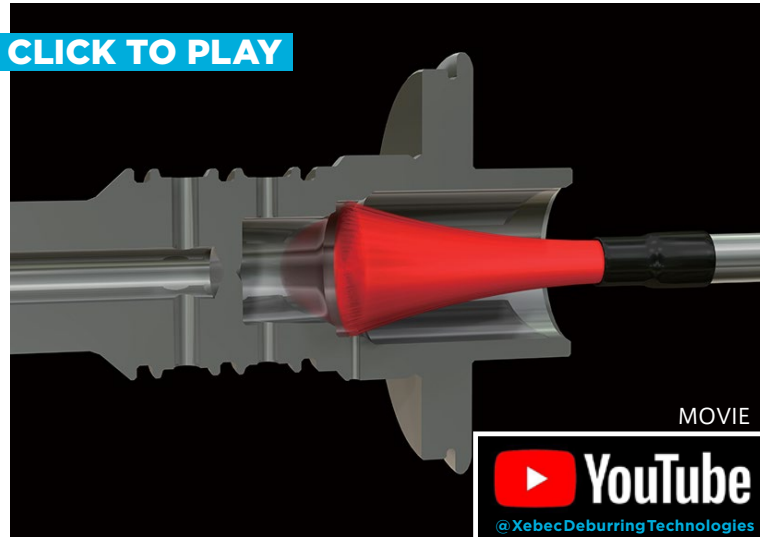


# Input shaft (Cross hole)



## Workpiece information

Industry	Automotive
Part name	Input shaft (Cross hole)
Material type	SCM
Cutting process	Drilling

## Processing conditions

Tool	XEBEC Brush™ Crosshole (CH-A12-5M + CH-A12-7M)
Processing detail	Crosshole deburring after drilling process
Spindle Speed (min <sup>-1</sup> )	9,000
Table Feed (mm/min)	300

### Before

**Tool** Abrasive-impregnated nylon brush

**Problem** Burrs are left by manual deburring. It caused low efficiency in processing.



### After

**Tool** XEBEC Brush for Cross hole (CH-A12-5M + CH-A12-7M)

**Result** Full automation realized with custom made machine. No burrs left and finish quality improved.



Deburring after drilling  
Cutter mark removal and polishing on inner diameter

## Tool > XEBEC Brush™ Crosshole

Ideal for deburring, polishing and cutter mark removal of inner diameter and counterbored part

