

VCT housing



Workpiece information

Industry	Automotive
Part name	VCT housing
Material type	Sintered metal
Cutting process	Front cutter processing

Processing conditions

Tool	XEBEC Brush for Surface (A11-CB40M)
Processing detail	Deburring the edge face after milling process
Spindle Speed (min ⁻¹)	500
Table Feed (mm/min)	2,000
Depth of cut (mm)	0.5
Machining time (sec)	—

Before

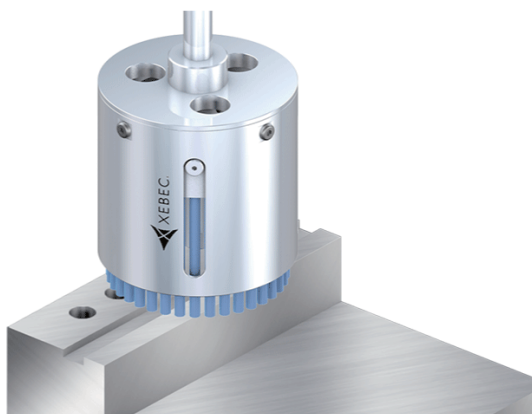


Tool	Abrasive-impregnated nylon brush
Problem	Deformation of nylon brush shape occurred in mass production process. It caused unstable quality due to insufficient deburring performance and burr remaining.

After



Tool	XEBEC Brush for Surface (A11-CB40M)
Result	No deformation of brush shape in mass production process. Stable cutting parameters with no burrs realized.



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

