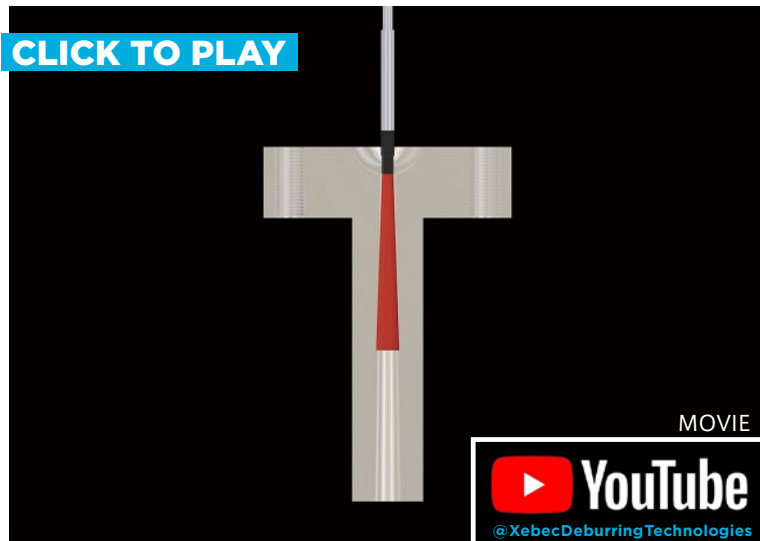


Mold (Sprue hole)



Workpiece information

| | |
|-----------------|-------------------|
| Industry | Mold |
| Part name | Mold (Sprue hole) |
| Material type | SKD2 |
| Cutting process | Others |

Processing conditions

| | |
|------------------------------------|--|
| Tool | XEBEC Brush Crosshole (CH-A12-3M) |
| Processing detail | Removal of cutter marks and polishing after electrical discharge machining |
| Spindle Speed (min ⁻¹) | 10,000 |
| Table Feed (mm/min) | — |

Before

Tool Round bar grindstone

Problem Manual use of rod grindstone. It was necessary to form the tip of the grindstone to polish the tapered portion. Manual processing resulted in unstable polishing quality.



After

Tool XEBEC Brush Crosshole (CH-A12-3M)

Result Work efficiency improved because the shape of a brush fits to the tapered portion of a workpiece. Enables to remove cutter marks in a shorter time.



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

