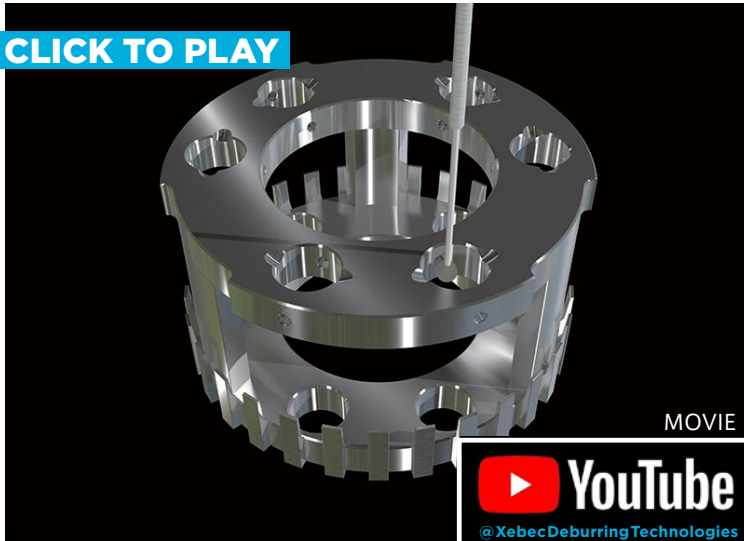


Carrier



Workpiece information

Industry	Automotive
Part name	Carrier
Material type	Press
Cutting process	Drilling

Processing conditions

Tool	XEBEC Stone Flexible Shaft (CH-PM6B)
Processing detail	Cross hole deburring after drilling process
Spindle Speed (min ⁻¹)	9,000
Table Feed (mm/min)	—
Depth of cut (mm)	0.5
Machining time (sec)	—

Before

- Tool** Rotary bar and rotating tool
- Problem** Rotary bar used with rotary tool is used for processing. Edge shape damaged and secondary burr (back burr) generated.

After

- Tool** XEBEC Stone Flexible Shaft (CH-PM6B)
- Result** Stable edge shape realized without generating the secondary burr.



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 a drilled hole both.

