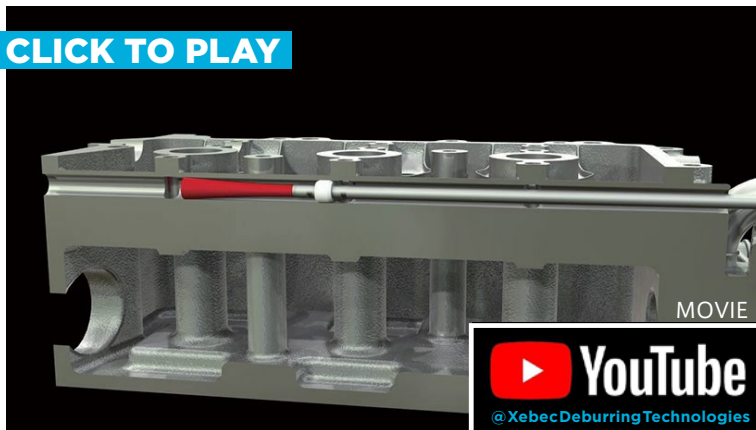


Cylinder head (Oil gallery)

CLICK TO PLAY



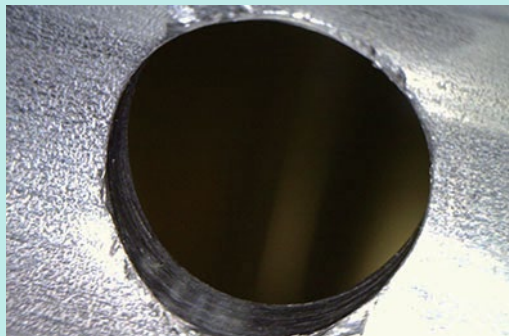
Workpiece information

Industry	Automotive
Part name	Cylinder head (Oil gallery)
Material type	ADC12
Cutting process	Drilling

Processing conditions

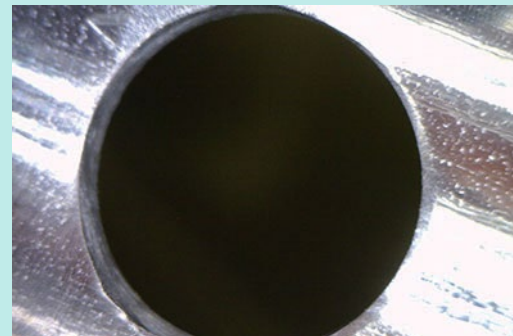
Tool	XEBEC Brush Crosshole Extra-Long (CH-A12-5F)
Processing detail	Cross hole deburring and internal polishing after drilling process
Spindle Speed (min ⁻¹)	7,200
Table Feed (mm/min)	2,000
Depth of cut (mm)	—

Before



Tool Abrasive-impregnated nylon brush
Problem Burrs were not removed completely. This caused the problem of quality inspection.

After



Tool XEBEC Brush Cross hole Extra-Long (CH-A12-5F)
Result Deburring and polishing quality stabilized.



Deburring after drilling
 Cutter mark removal and polishing on inner diameter

Tool

XEBEC Brush™ Crosshole Extra-Long

Suitable for deburring, polishing and cutter mark removal of inner diameter and counterbored part exceeding 150 mm in depth

