

# Exhaust manifold



## Workpiece information

Industry	Automotive
Part name	Exhaust manifold
Material type	AC4C
Cutting process	Front cutter processing

## Processing conditions

Tool	XEBEC Brush for Surface (A21-CB60M)
Processing detail	Deburring of the matching surface after face milling process.
Spindle Speed (min <sup>-1</sup> )	1,000
Table Feed (mm/min)	2,000
Depth of cut (mm)	0.5

### Before

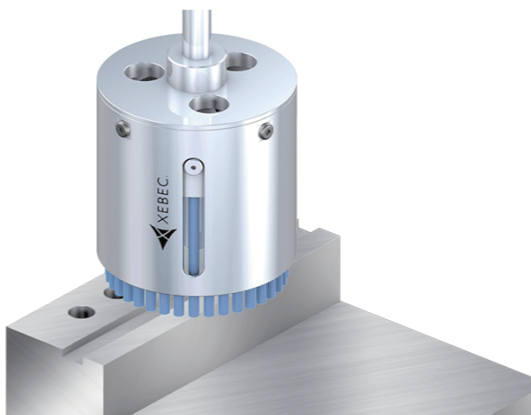
**Tool** File

**Problem** It took time for manual deburring. This caused unstable quality.

### After

**Tool** XEBEC Brush for Surface (A21-CB60M)

**Result** Automated deburring with stable quality in a shorter cycle time 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

