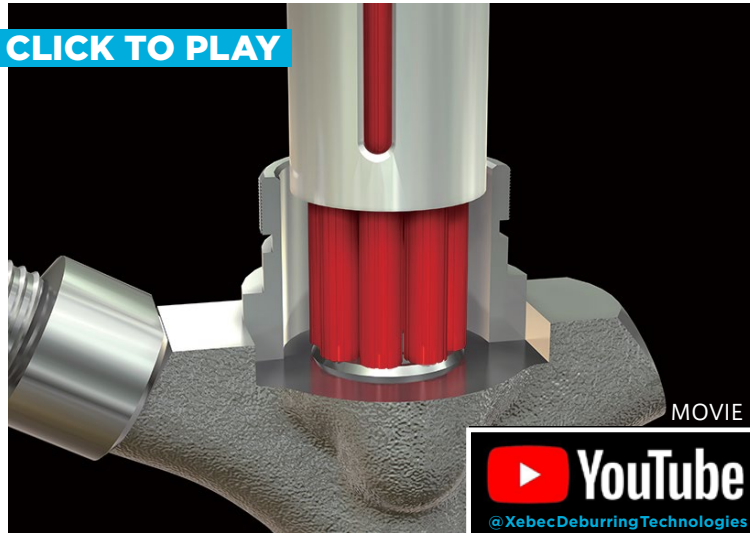


Injector body (Nozzles)



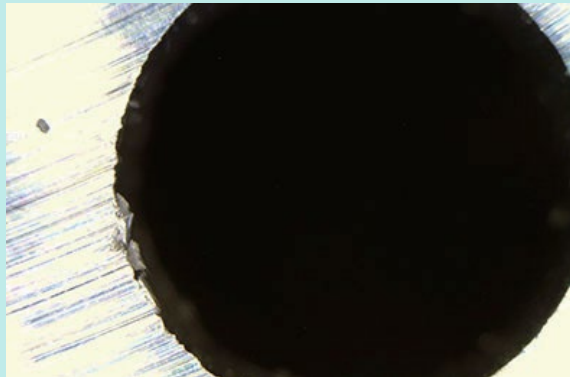
Workpiece information

Industry	Automotive
Part name	Injector body (Nozzles)
Material type	SCM
Cutting process	Drilling

Processing conditions

Tool	XEBEC Brush Surface (A11-CB15M) XEBEC Floating Holder (FH-ST12)
Processing detail	Deburring the edge face after drilling process
Spindle Speed (min ⁻¹)	2000
Depth of cut (mm)	4

Before

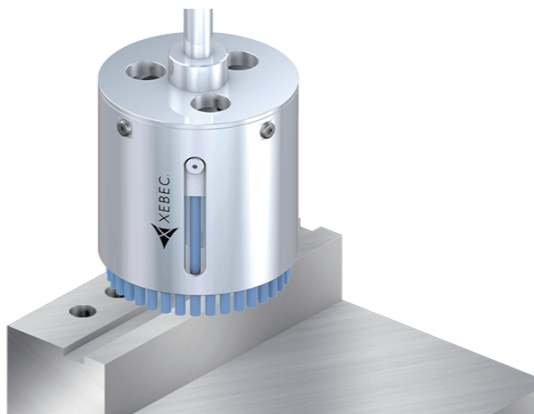


Tool Abrasive-impregnated nylon brush
Problem Burrs remained and full inspection required, resulting in high labor cost.

After



Tool XEBEC Brush for Surface (A11-CB15M), XEBEC Floating Holder (FH-ST12)
Result No burr remaining realized by automated deburring with machining center. Besides, this enabled introduction of random sampling instead of full inspection and cost reduction achieved. Surface roughness of processed area improved.



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

