

# Injector body (Shoulder)

**CLICK TO PLAY**



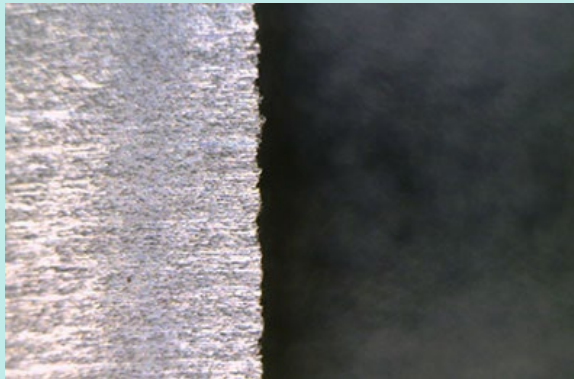
## Workpiece information

Industry	Automotive
Part name	Injector body (Shoulder)
Material type	SCM
Cutting process	End milling processing

## Processing conditions

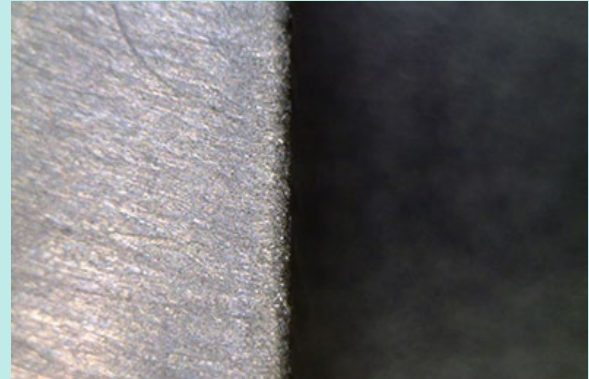
Tool	XEBEC Brush Surface (A21-CB06M) XEBEC Floating Holder (FH-ST12)
Processing detail	Deburring of boundary line on the casting surface after end milling
Spindle Speed (min <sup>-1</sup> )	5000
Depth of cut (mm)	4

### Before

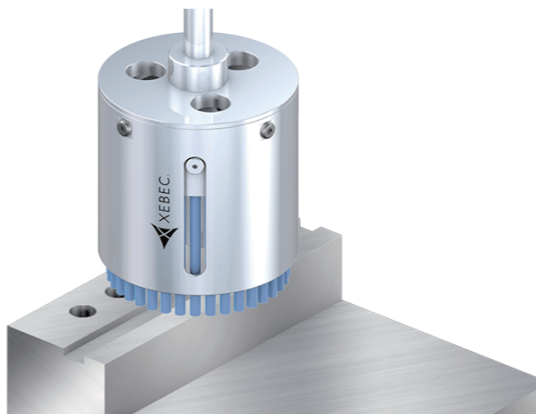


**Tool** Abrasive-impregnated nylon brush  
**Problem** Burrs remained and full inspection required, resulting in high labour cost.

### After



**Tool** XEBEC Brush for Surface (A21-CB06M)  
XEBEC Floating Holder (FH-ST12)  
**Result** Complete removal of burrs achieved by CNC deburring with machining center. Besides, this enabled introduction of random sampling instead of full inspection and cost reduction achieved. Besides, 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

