

Output Shaft (Oil hole)

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Workpiece information

Industry	Automotive
Part name	Output Shaft (Oil hole)
Material type	SCM
Cutting process	Drilling

Processing conditions

Tool	XEBEC Back Burr Cutter and Path (XC-28-A + α)
Processing detail	Back deburring after drilling
Spindle Speed (min ⁻¹)	12,500
Table Feed (mm/min)	1,000
Depth of cut (mm)	—
Machining time (sec)	—

Before

- Tool** Back deburring tools (cotter pin type)
- Problem** Poor deburring performances such as remained burrs, secondary burrs and uneven edges.



After

- Tool** XEBEC Back Burr Cutter and Path (XC-28-A + special path)
- Result** Uniform deburring amount without secondary burrs realized by high quality CNC deburring.



Deburring after drilling

Tool XEBEC Back Burr Cutter and Path™

Deburr and chamfer the front and back of multiple elliptical or off-center holes in a single pass.

