

Pipe parts for aircrafts (Cross hole)

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Workpiece information

Industry	Aerospace
Part name	Pipe parts for aircrafts (Cross hole)
Material type	SUS
Cutting process	Drilling

Processing conditions

Tool	XEBEC Stone Flexible Shaft Type (CH-PM-6B)
Processing detail	Cross hole deburring (back burr) after drilling process
Spindle Speed (min ⁻¹)	2,000
Table Feed (mm/min)	—
Depth of cut (mm)	—
Machining time (sec)	30sec/hole

Before

- Tool** Rubber grindstone in the rotating tool
- Problem** Finish quality varied from the skill of workers. It took around 40 minutes to deburr 16 holes (150 seconds/hole).

After

- Tool** XEBEC Stone Flexible Shaft Type (CH-PM-6B)
- Result** Insert the spherical grinding stone with the cross hole and contour the edge while pulling the tool lightly. Stable quality with shorter cycle time realized.



Hole deburring

Tool XEBEC Stone™ Flexible Shaft

Flexible shaft enables soft contact with a workpiece and suppresses chattering during process.

Ideal for deburring both front and back of drilled holes.

