

Always operate within the recommended range of maximum speed of rotation, depth of cut and feed rate.

PRECAUTIONS FOR USE

Do not exceed the maximum rotation speed for use.

Operating above the maximum rotation speed may result in tool breakage.

Ensure any dust or debris generated during processing is collected, and work area is kept clean.

Even if there is no abnormal condition observed in the test run, stop use immediately if an abnormality is observed.

Do not use the tool at an unreasonable angle or under excessive pressure.

Do not use the tool in any place with risk of fire or explosion.

Do not grind with, alter or fabricate the shaft.

CONDUCT A TEST

Conduct a test run for 1 minute or more before starting the operation and 3 minutes or more after changing a tool. Check for any abnormality including excessive vibration or looseness in the mounting place of the tool.

OPERATOR SAFETY MEASURES

Use Protective Gear Always wear protective goggles, gloves and masks when operating the tool or entering the work area. Wear long sleeves, tight cuffs, and clothing to minimize skin exposure.

Take Precaution Be cautious in surrounding area. Use of machines at high speed can cause flying debris within the work area. Dust or debris generated by operating process could be hazordous.



WARNING!

Use caution and follow all safety measures at all times. Failure to do so could result in injury. A tool or a part of a tool may crack, drop off, distort or break. Broken pieces of a tool or grinding dust may stick into skin or eyes and cause injury.

XEBEC BRUSH[™] SURFACE EXTRA-LARGE

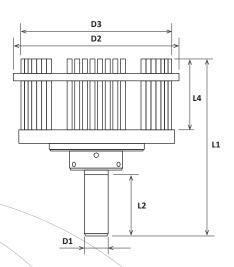
Selection

Brush Requires Slide Ring to Operate

Brush Size (D3)		Less ←		L4 Brush Length		Max RPM	
ММ	INCHES	Red	White	Blue	ММ	INCHES	
125 mm	4.921	30025 A11-CB125M	30026 A21-CB125M	30046 A32-CB125M	102	4.016	1,000
165 mm	6.496	30028 A11-CB165M	30029 A21-CB165M	30047 A32-CB165M	102	4.016	750
200 mm	7.874	30031 A11-CB200M	30032 A21-CB200M	30048 A32-CB200M	102	4.016	600

Slide Ring for use with Extra-Large Surface Brush

	-									
Size	EDP	Part No.	D1 Shank Diameter		D2 Ring Diameter		L1 Overall Length		L2 Shank Length	
			ММ	INCHES	MM	INCHES	MM	INCHES	MM	INCHES
125 mm	40010	SR125M			135	5.315				
165 mm	40011	SR165M	25	0.984	176	6.929	175	6.890	65	2.559
200 mm	40012	SR200M			211	8.307				



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165

125

200

ADDITIONAL LEARNING RESOURCES AVAILABLE ON OUR WEBSITE

3D Files (STEP, DXF), Dimensional Drawings and Safety Data Sheets (SDS)

deburringtechnologies.com/technical



Product Demonstration Videos

deburringtechnologies.com/video

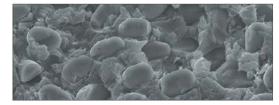
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XEBEC BRUSHTM SURFACE EXTRA-LARGE XEBEC. | DEBURRING



Choosing Color and Size

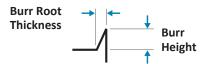


All Xebec brushes are made from the same proprietary ceramic fibers manufactured into rods, or bristles, of different thicknesses. The greater the bristle thickness, the more aggressive the cutting action.

Brush Color Signifies the relative thickness of the bristles	Will not change part dimensions or features	Will conform to slight workpiece variations	Able to run at higher speeds, extend tool life	3-4 times more aggressive than white		
Aggressiveness	Least ←			───→ Most		
Flexibility Ability to conform to the work piece						
Target Material	K So	ftest	Har	dest 💙		
	Resins, Plastics	Aluminu	um, Copper, Brass, General Steel			
				Cast Metal, Stainless, Heat-Resistant Steel		
Target Burr Size	Micro	o Fine	up to 0.008"			
101501 0011 0120		up to				
Target Finish						
	4 Ra or better					

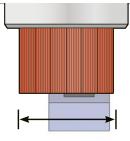
Target Burr Size

Burr Root Thickness of **0.008**" or less (Burrs are bent with a fingernail)



Choosing the Ideal Brush Size Choose a brush 1.5 to 2 times wider than the width of the work piece surface.





This allows the brush to engage the edge at 90° for optimal grinding power. Using a larger brush than the surface width will also require the fewest number of passes and minimize cycle time.

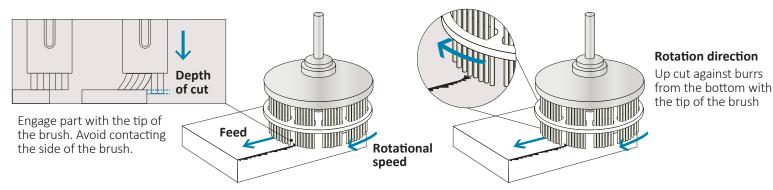
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Starting Operating Parameters

Brush	Depth of Cut (inches)				RPM		Feed Rate (inches/min)			Recommended	
Diameter Ve	Vertical Horizontal Burr Burr	Horizontal	Cutter Mark	Polishing	Max	Initial	Max.	Burr Root Thickness		Cutter Mark Removal	Brush Projection (inches)
		Removal	Polishing	Max.	Initial	ividX.	0.005 in	0.01 in			
125						800	1000				
165	0.02	0.04	0.02 - 0.04	0.01 - 0.02	0.06	600	750	160	100	15	0.6
200						480	600				

Workpiece Engagement



Maximizing Performance

Maximizing Deburring Operation

- 1 Increase RPM to the maximum allowed
- **2** Decrease feed rate in 10% increments
- 3 Do not change original parameters, but increase number of passes
- 4 Try a more aggressive brush that will increase grinding power

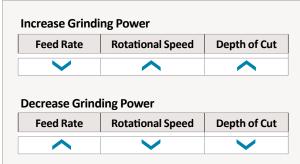
Maximizing Tool Life

- **1** Decrease RPM in 10% increments
- 2 Increase feed rate by 10% increments
- 3 Try another brush color A21 White, A11 Red, A32 Blue with the same parameters

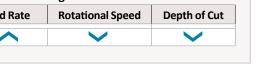
Adjustments for Improved Results

If burrs or cutter marks remain

- **Increase Rotational Speed** 1 In increments of 25%, Do not exceed Maximum RPM
- **Increase the Number of Passes** 2 Each pass will improve finish by approximately one half
- **Decrease Feed Rate** 3 In increments of 10 to 20%
- Use more aggressive Color of Brush 4 (Pink=Least Aggressive, Blue=Most Aggressive)



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Use of Coolant/Oil will optimize results

It will Extend Tool Life

> Improves Surface Finish

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