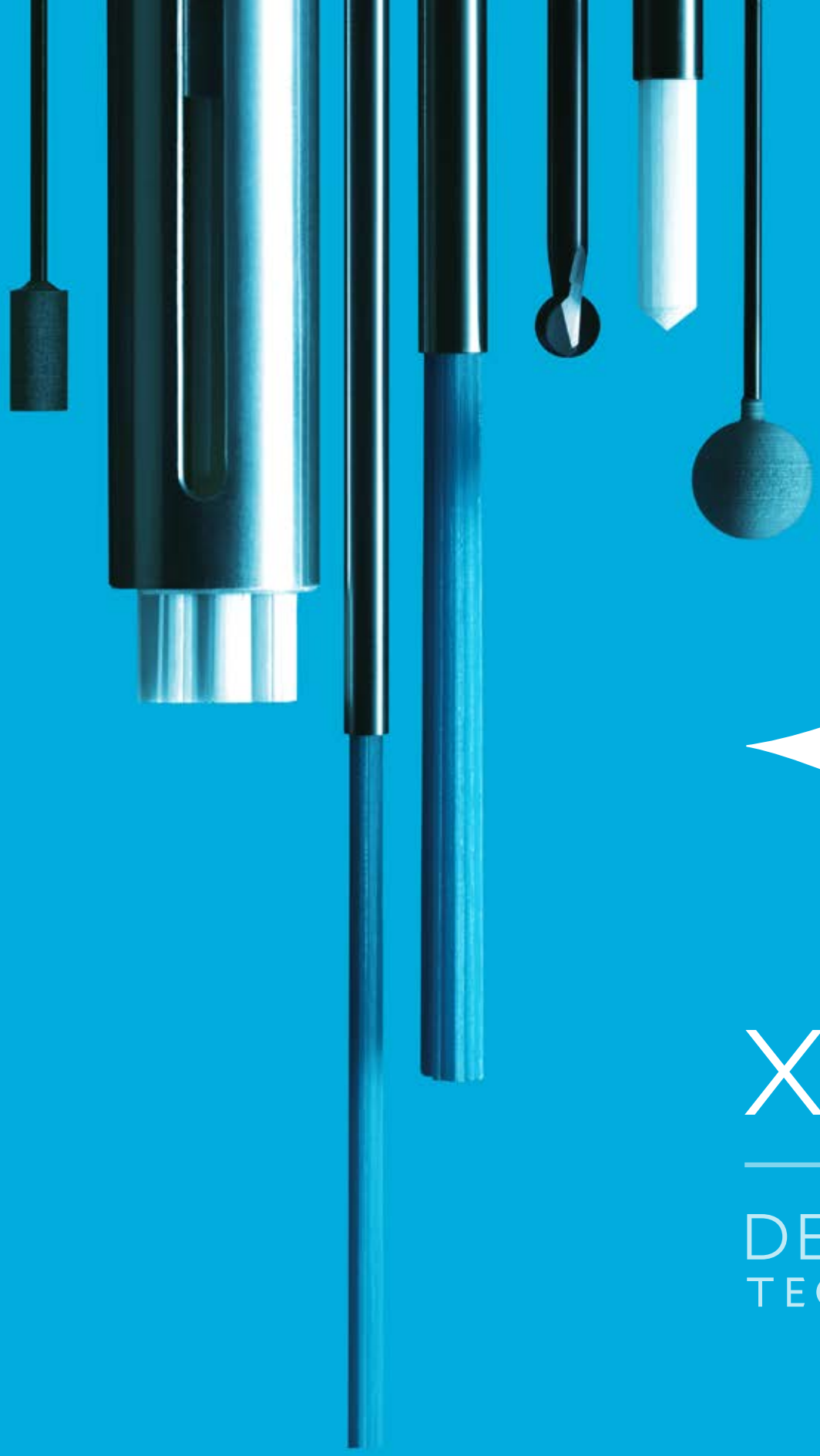


XEBEC®

DEBURRING
TECHNOLOGIES

Innovative Deburring
& Surface Finishing Solutions

deburringtechnologies.com

Xebec Ceramic Fiber 4
Successful Applications 6

Surface Deburring & Finishing

10

Surface Brush

Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling | Drilling Machine

11

Extra Large Surface Brush

Machining Center | Combined Lathe | Special Machine

12

Wheel Brush

Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling

13

Self Adjusting Sleeve

Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling

14

Burrless Chamfer Cutter

Machining Center | Combined Lathe

16

Floating Holder

Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling | Drilling Machine

16

Brush Length Adjustment Tool

Crosshole Deburring & Finishing

18 Crosshole Brush

Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling

20 Flexible Shaft Stone

Electric Rotary | Machining Center | Combined Lathe | Special Machine | Robot | Lathe with Milling

22 Back Burr Cutter & Path

Machining Center | Combined Lathe

Detailed Finishing

25 Xebec™ Micro Motor

26 End Type Brush

Electric Rotary | Machining Center | Combined Lathe | Robot | Lathe with Milling

27 Stone Mounted Point

Pneumatic Rotary | Electric Rotary

28 Stone Meister Finish

Electric Rotary | Hand Finishing | Ultrasonic | Pneumatic Rotary

29 Flexible Shaft Stone

Electric Rotary | Machining Center | Combined Lathe | Robot | Lathe with Milling

Operating Parameters 31

Cost Savings 34

Minimizing Burr Size 35

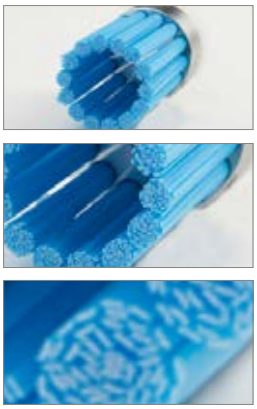
Xebec® Ceramic Fiber

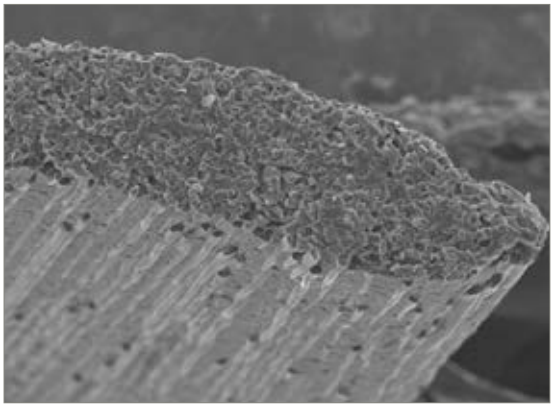
For use on materials up to 65Rc

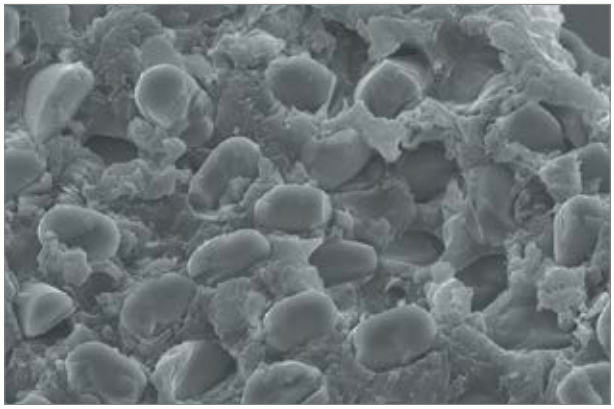
The ceramic fibers are woven to create self-sharpening filaments that maintain consistent cutting action on the tips. Unlike wire and abrasive impregnated nylon brush filaments, the unique design of the Xebec fiber rod maintains its shape with no deformation even after repeated use. This leads to consistent performance time after time.

FINE FINISHING
up to
3.937 Ra
µi microinches
(**0.1 *µm*** micrometers)

Continuous Ceramic Fibers







XEBEC Brush™

Ceramic Fibers are formed into bristles to produce tip cutting Brushes

Consistent cutting performance

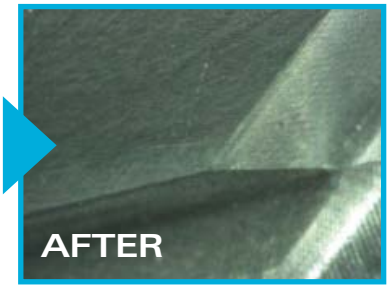
XEBEC Stone™

Ceramic Fibers are formed into Stones capable of cutting on all sides

Unsurpassed grinding power

Tip-To-Tip Consistent Performance

Self-sharpening effect always exposes new cutting edges. Solid fiber materials never deform by repeated use.

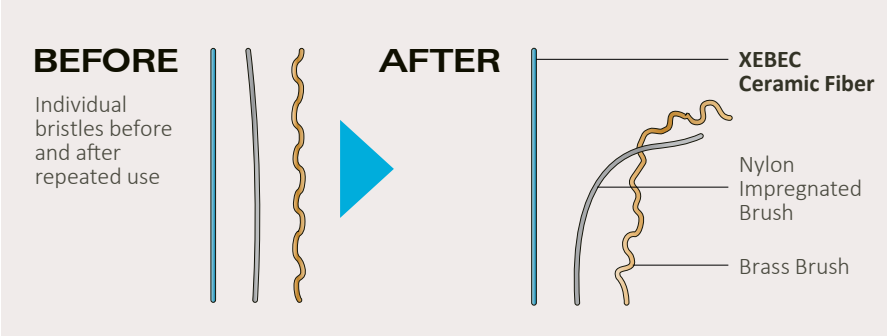


High Grinding Power

The tip of each Fiber works as abrasive. More than 80% of content is Ceramic Fiber.

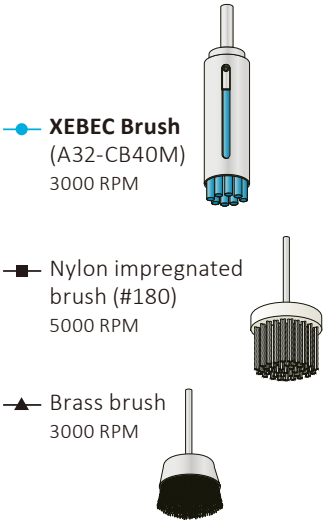
XEBEC Brush™

Ceramic Fiber bristles will not deform by repeated use.

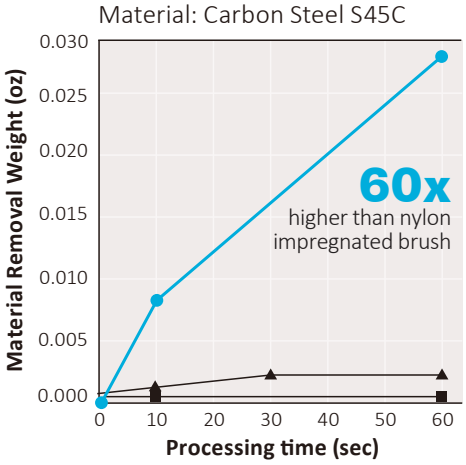


The Advantages of Ceramic Fiber

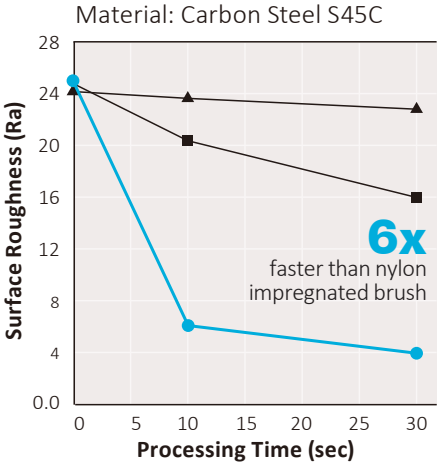
Xebec Ceramic Fiber brushes remove more material faster than nylon impregnated or brass finishing brushes.



Grinding power



Polishing capacity



Save time & money! Automate the deburring process.

Ceramic fiber products can be used in CNC, robotic or hand held devices

IMPROVE QUALITY

INCREASE PRODUCTIVITY

REDUCE COSTS

YouTube @Xebec Deburring Technologies

Successful Applications

MAJOR MARKETS SERVED

Our focus is identifying and demonstrating value added solutions for production machined parts. We have demonstrated particular success in the following market segments:

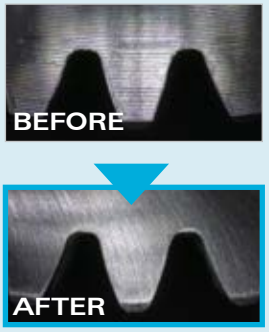
Production

- Valves
- Mold & Die
- Fittings
- Precision Parts
- Swiss Machined
- Bushings

Edge Deburring

Category	Machine Part
Workpiece	Spur Gear
Material	Carbon Steel S45C
Process Details	Edge deburring after gear cutting process

Precision parts that must be deburred while maintaining edge quality without secondary burrs.



XEBEC product used: A32-CB25M
Rotation Speed: 3500
Depth of Cut: 0.039 in
Feed: 98 IPM

Powertrain

- Cylinder Blocks
- Head Covers
- Crankshafts
- Camshafts
- Connecting Rods
- Fuel Injection

Fine Deburring

Category	Automotive Part
Workpiece	Cooling Fins
Material	Carbon Steel Aluminum Alloy
Process Details	Edge deburring

Fine deburring of surfaces, edge radiuses and small diameter bores. Deburring of fine burrs where the base thickness is 1mm (.040") or less after machine processing and finishing of edges.

XEBEC product used: A32-CB25M
Rotation Speed: 3500
Depth of Cut: 0.039 in
Feed: 98 IPM

Medical

- Tibia Trays
- Bone Screws
- Spinal Implants
- Knees
- Hips
- Shoulders

Cutter Mark Removal

Category	Medical Part
Workpiece	Artificial Hip Joint
Material	Titanium Alloy
Process Details	Cutter mark removal after ball end milling

Grinding and finishing of flat surfaces and uneven surfaces.

XEBEC product used: A21-CB25M
Rotation Speed: 1500
Depth of Cut: 0.039 in
Feed: 40 IPM

Find more examples on our website

Real parts for every industry with specific parameters and videos are available at:
deburringtechnologies.com/applications/

Industry guides and case studies are available at:
deburringtechnologies.com/industry-guides-case-studies/

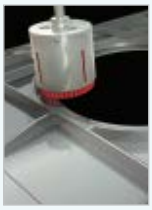
Aerospace

- Landing Gear
- Blades
- Fuel Systems
- Engine Components
- Structural Parts
- Actuation Systems

Fine Surface Finishing

Category	Airplane Part
Workpiece	Body
Material	Aluminum Alloy
Process Details	Deburring of end milled surface

Fine surface finishing of large parts, deburring of edge radiuses after machine processing and finishing of edges.



XEBEC product used:
A11-CB100M
Rotation Speed: 960
Depth of Cut: 0.026 in
Feed: 134 IPM

Firearms

- Slides
- Barrels
- Triggers
- Frame
- Hammers
- Cylinders

Detailed Surface Finishing

Category	Firearm Part
Workpiece	Trigger Assembly
Material	Stainless Steel
Process Details	Edge deburring and detailed surface finish

Fine surface finishing of detailed parts, deburring of edge radiuses and finishing of edges.

XEBEC product used:
A21-CB06M
Rotation Speed: 8100
Depth of Cut: 0.015 in
Feed: 40 IPM

Energy

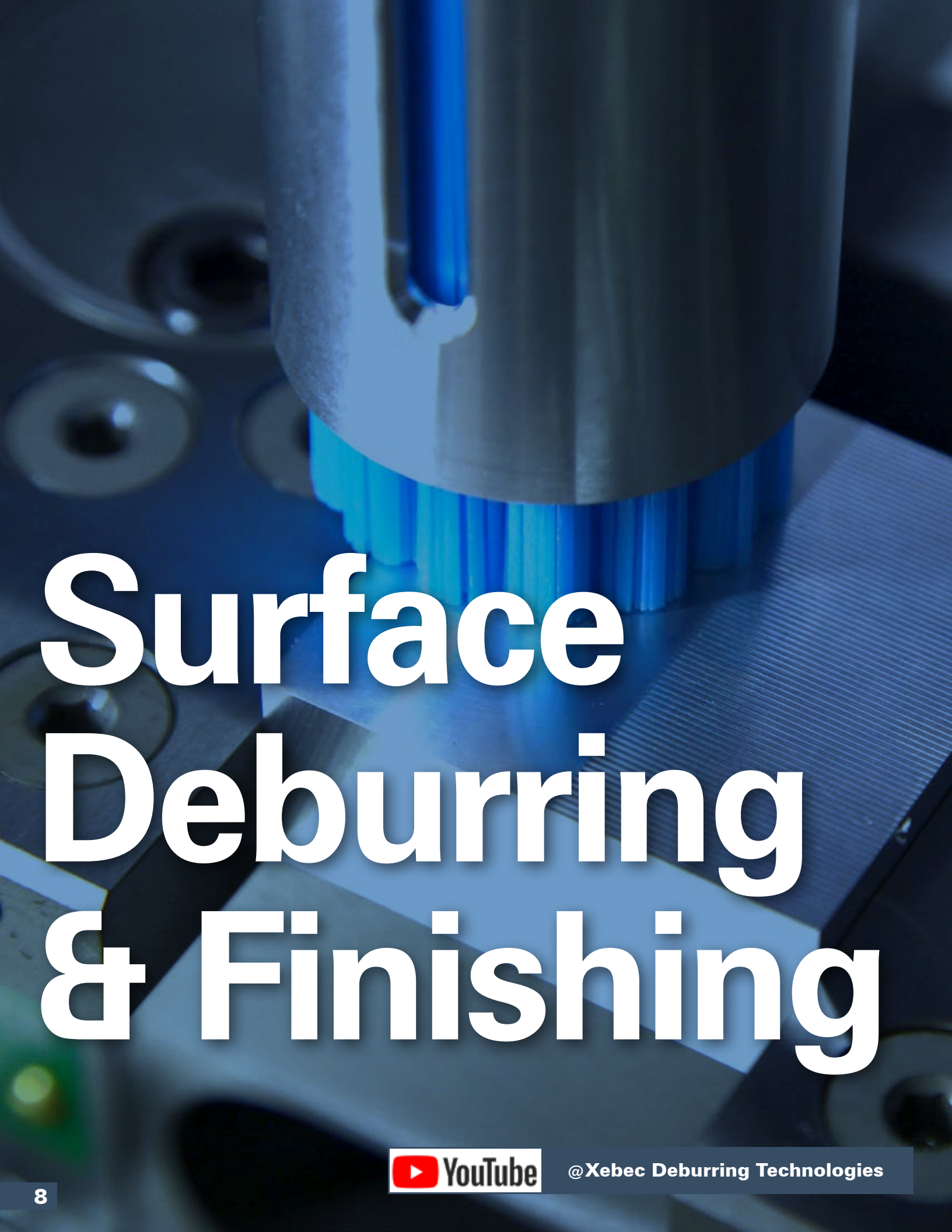
- Manifolds
- Blisks
- Turbine Blades
- Christmas Tree
- Rotor Blades End
- Rotor Blades Blend

Fine Surface Finishing

Category	Compressor Part
Workpiece	Turbine blade
Material	SUS316
Process Details	Deburring of ball end milled surface

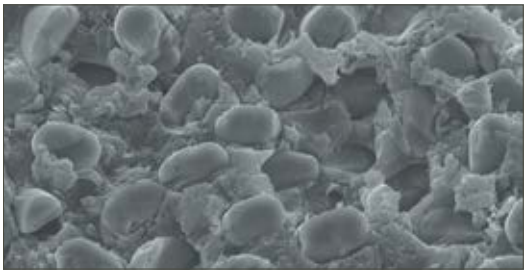
Fine surface finishing of parts, deburring of edge radiuses after machine processing and finishing of edges.

XEBEC product used:
A11-CB25M
Rotation Speed: 1000
Depth of Cut: 0.020 in
Feed: 94 IPM

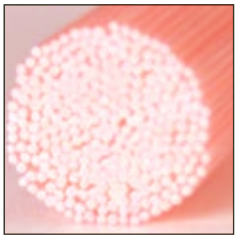
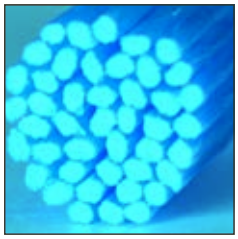


Surface Deburring & Finishing

YouTube @Xebec Deburring Technologies

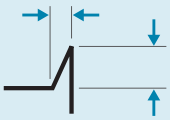


All Xebec brushes are made from the same proprietary ceramic fibers manufactured into rods, or bristles, of different thicknesses. **The greater the bristle thickness, the more aggressive the cutting action.**

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	❮ **Softest**		**Hardest** ❯	
	Resins, Plastics	Aluminum, Copper, Brass, General Steel		
				Cast Metal, Stainless, Heat-Resistant Steel
Target Burr Size	**Micro Fine**		**up to 0.008”**	
		up to 0.004”		
Target Finish				
	4 Ra or better	**Finish up to 4 Ra**		

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

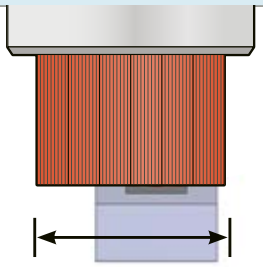
Burr Root Thickness



Burr Height

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

1.5-2x **larger than the surface width**



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.

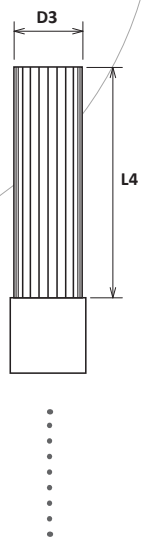
XEBEC BRUSH™ SURFACE

Surface Brush

Ideal for simultaneous cutter mark removal, deburring, surface finishing and edges.

Brush Requires Brush Sleeve to Operate

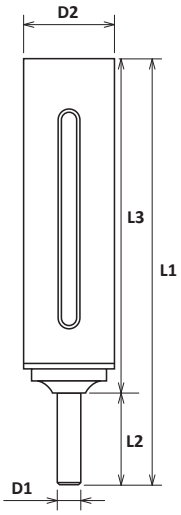
Brush Size (D3)		Aggressiveness Less ← → More				L4 Brush Length		Max RPM	Required Sleeve
MM	INCHES	Pink	Red	White	Blue	MM	INCHES		
6mm	0.236	**30015** A13-CB06M	**30006** A11-CB06M	**30012** A21-CB06M	**30045** A32-CB06M	30	1.181	10,000	40006
15mm	0.591	**30013** A13-CB15M	**30005** A11-CB15M	**30011** A21-CB15M	**30044** A32-CB15M	50	1.969	6,000	40005 or 40007*
25mm	0.984	-	**30004** A11-CB25M	**30010** A21-CB25M	**30043** A32-CB25M	75	2.953	5,000	40004
40mm	1.575	-	**30003** A11-CB40M	**30009** A21-CB40M	**30042** A32-CB40M	75	2.953	3,000	40003
60mm	2.362	-	**30002** A11-CB60M	**30008** A21-CB60M	**30041** A32-CB60M	75	2.953	2,000	40002
100mm	3.937	-	**30001** A11-CB100M	**30007** A21-CB100M	**30040** A32-CB100M	75	2.953	1,000	40001



Sleeve for use with Xebec™ Brush Surface

Size	EDP	Material	Part No.	D1 Shank Diameter		D2 Sleeve Diameter		L1 Overall Length		L2 Shank Length		L3 Shaft Length	
				MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES
6mm	40006	Aluminum	S06M	6	0.236	10	0.394	70	2.756	29	1.142	41	1.614
15mm*	40005	Aluminum	S15M-A	6	0.236	18	0.709	90	3.543	29	1.142	61	2.402
15mm*	40007	Plastic	S15M-P	6	0.236	18.5	0.728	90	3.543	29	1.142	61	2.402
25mm	40004	Aluminum	S25M	8	0.315	30	1.181	140	5.512	30	1.181	110	4.331
40mm	40003	Aluminum	S40M	10	0.394	45	1.772	140	5.512	30	1.181	110	4.331
60mm	40002	Aluminum	S60M	12	0.472	65	2.559	150	5.906	35	1.378	115	4.528
100mm	40001	Aluminum	S100M	16	0.630	110	4.331	162	6.378	40	1.575	122	4.803

*15mm Sleeve available in Aluminum or Plastic

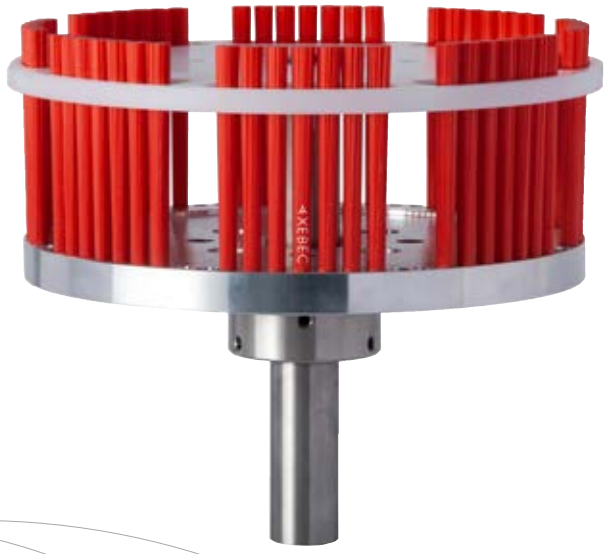


See Operating Parameters for Surface Brush page 32-33

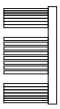
XEBEC BRUSH™ SURFACE

Extra-Large Brush

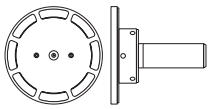
Ideal for deburring, cutter mark removal and surface polishing with a width of 4 inches or greater, such as cylinder heads, cylinder blocks and machinery beds.



Brush

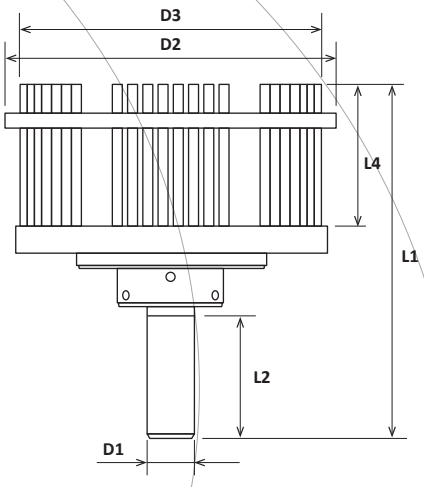


Slide Ring
Ring
Base holder
Shank



Brush Requires Slide Ring to Operate

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



Slide Ring for use with Extra-Large Surface Brush

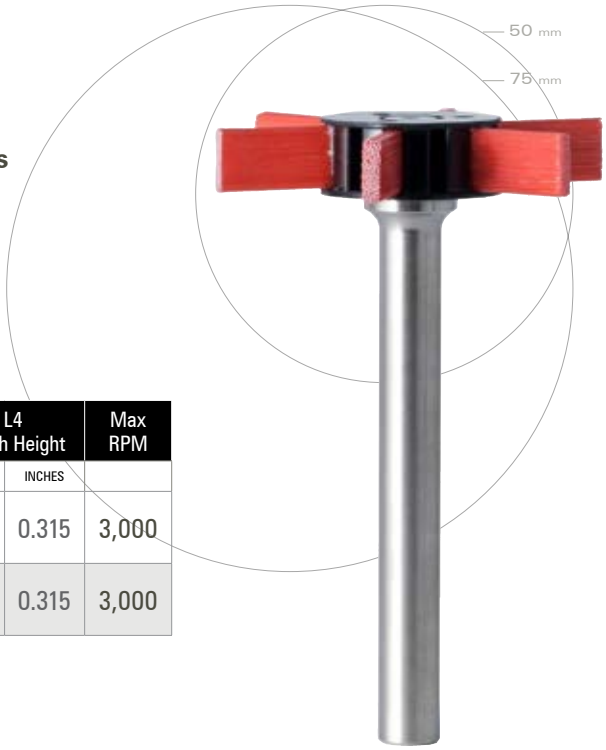
Size	EDP	Part No.	D1 Shank Diameter		D2 Ring Diameter		L1 Overall Length		L2 Shank Length	
			MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES
125mm	40010	SR125M	25	0.984	135	5.315	175	6.890	65	2.559
165mm	40011	SR165M			176	6.929				
200mm	40012	SR200M			211	8.307				

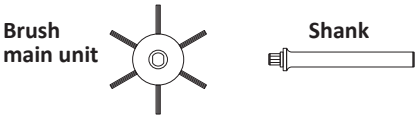
Brush Diameter (mm)	Depth of Cut (inches)					RPM		Feed Rate (inches/min)			Recommended Brush Projection (inches)
	Vertical Burr	Horizontal Burr	Cutter Mark Removal	Polishing	Max.	Initial	Max.	Burr Root Thickness 0.005 in	Burr Root Thickness 0.01 in	Cutter Mark Removal	
125	0.02	0.04	0.02 - 0.04	0.01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

XEBEC BRUSH™

Wheel Brush

Ideal for deburring and polishing of side surfaces and inner diameters





Wheel Brush Reusable Shank Sold Separately, See Below

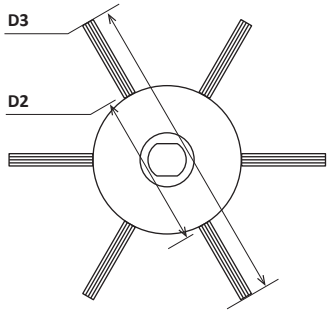
Size		EDP	Part No.	D2 Head Diameter		D3 Brush Diameter		L3 Head Thickness		L4 Brush Height		Max RPM
				MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
50mm		**60007**	W-A11-50	23	0.906	50	1.969	9.6	0.378	8	0.315	3,000
75mm		**60008**	W-A11-75	23	0.906	75	2.953	9.6	0.378	8	0.315	3,000

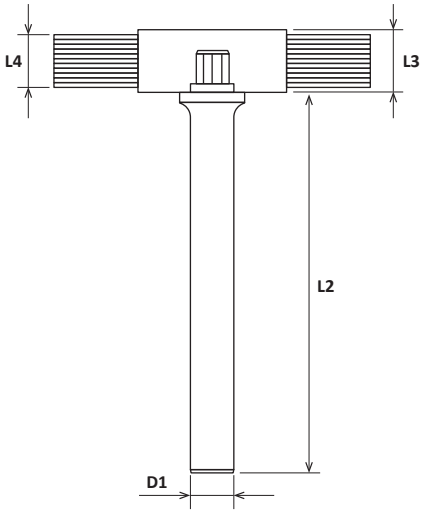
Insert shank into brush before use.

Shank Wheel Brush Required

Shank	EDP	Part No.	D1 Shank Diameter		L2 Shank Length	
			MM	INCHES	MM	INCHES
70 mm Shank	**60009**	WSM	8	0.315	70	2.756
150 mm Shank	**60010**	WSL	12	0.472	150	5.906

*Not suitable for use on hand held devices





Initial Processing Conditions

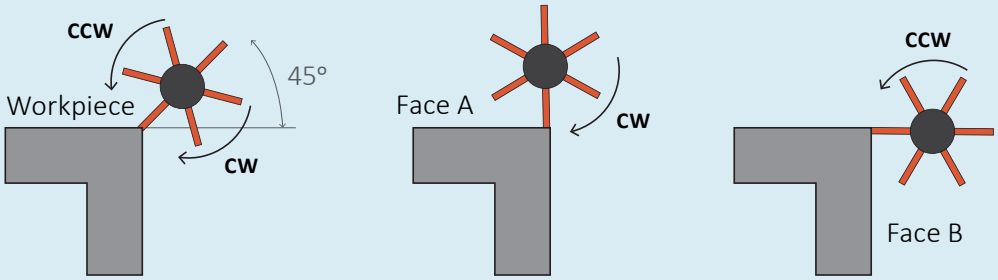
EDP	Minimum RPM	Depth of cut (inches)	Feed rate (in/min)
60007	1,600	0.008	190
60008	1,000	0.008	120

*As bristles wear, bristle length shortens and stiffness increases.
If bristle breakage occurs, decrease the depth of cut.

If burrs remain

1. Increase the number of passes
2. Decrease the feed rate in 10 to 20% increments
3. Increase Depth of Cut (up to 0.02 inches)

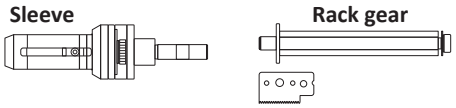
Rotational Direction

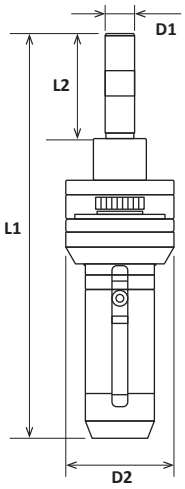


XEBEC BRUSH™

Self-Adjusting Sleeve™

Programmable brush length adjustment solution.
Completely automated allows for unmanned operations.
Maintains optimal cutting efficiency with reduced downtime.

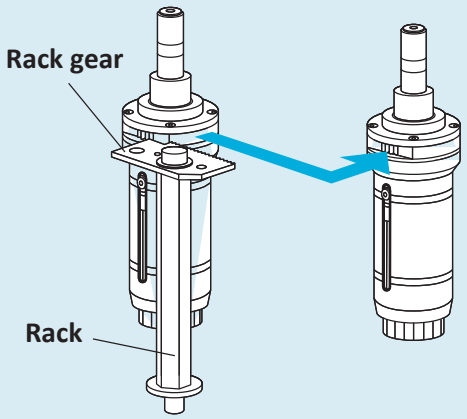




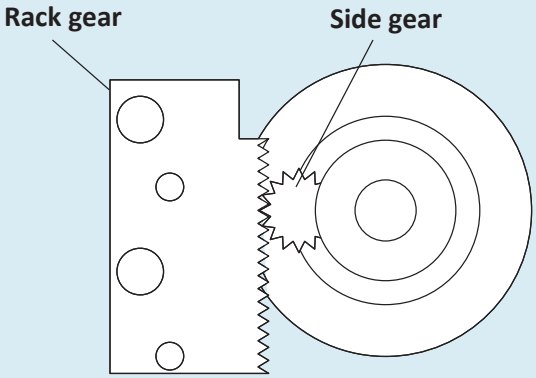
For Brush Diameter	EDP	Part No.	D1 Shank Diameter		D2 Neck Diameter		L1 Overall Length		L2 Shank Length		Weight (lbs)	Max RPM	Compatible Brush (EDP)
			MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES			
6 mm Brush	**50010**	XP-AUTO6M	10	0.394	37	1.457	124.1	4.886	35.0	1.378	0.485	10,000	30015, 30006, 30012, 30045
15 mm Brush	**50011**	XP-AUT15M	10	0.394	37	1.457	136.3	5.366	35.0	1.378	0.595	6,000	30013, 30005, 30011, 30044
25 mm Brush	**50012**	XP-AUT25M	16	0.630	60	2.362	189.0	7.441	41.5	1.634	1.753	5,000	30004, 30010, 30043
40 mm Brush	**50013**	XP-AUT40M	16	0.630	60	2.362	189.0	7.441	41.5	1.634	2.006	3,000	30003, 30009, 30042

Automated Brush Length Projection

Predetermined brush length is automatically projected when the embedded side gear passes the rack gear which is mounted in a machine.



Pass the side gear of main body through the rack gear as shown above.



Mesh the side gear of main body and the rack gear.

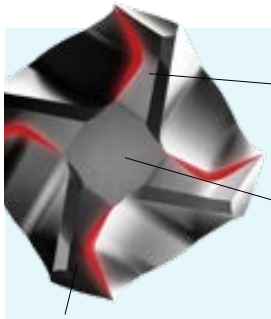
XEBEC™

Burrless Chamfer Cutter

- **Burrless chamfering with a patented, multi-blade, V-shaped design**
- **Cuts a clean, finished, burr-free chamfer**
- **Reduces cycle time and tool costs with fewer processes**

Machining Center

Combined Lathe



Patented V-shaped blades
Unique design cuts a finished chamfer without forming secondary burrs.

Flat tip
Ensures positional accuracy. The flat tip prevents rounding and chipping of the tool tip that could cause tool length measurement errors.

Multiple blades
Multi-blade design enables high feed rate for more efficient chamfering with reduced machining time.

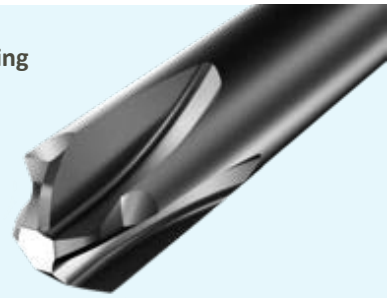
Heat-resistant AlTiCrN coating

Performs well in hard materials including Titanium and Inconel

Also available Uncoated

With a sharper edge for soft alloys and plastics

Made from Micro-Grain Cemented Carbide

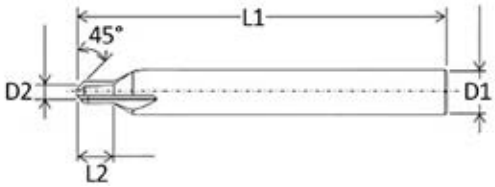


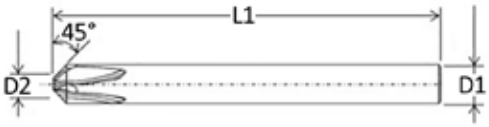
Burrless Chamfer Cutters

EDP (Product Number)		Chamfering Alignment Diameter (D2)		Shank Diameter (D1)		Overall Length (L1)		Length Under the Neck (L2)		Maximum Depth of Cut APMX (mm)		Cutting angle KAPR (°)	Blades	Target Chamfering Size	
COATED	UNCOATED	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES			MM	INCHES
60020 (XC-C-03-M)	**60022** (XC-C-03-N)	2	0.079	6	0.236	50	1.969	5	0.197	1	0.039	45°	3	0.3 - 0.6	0.012 - 0.024
60021 (XC-C-06-M)	**60023** (XC-C-06-N)	4	0.157	6	0.236	60	2.362	-	-	2	0.079	45°	4	0.7 - 1.5	0.024 - 0.059

AlTiCrN coated For steel, stainless steel, cast iron, titanium, nickel and heat resistant alloys

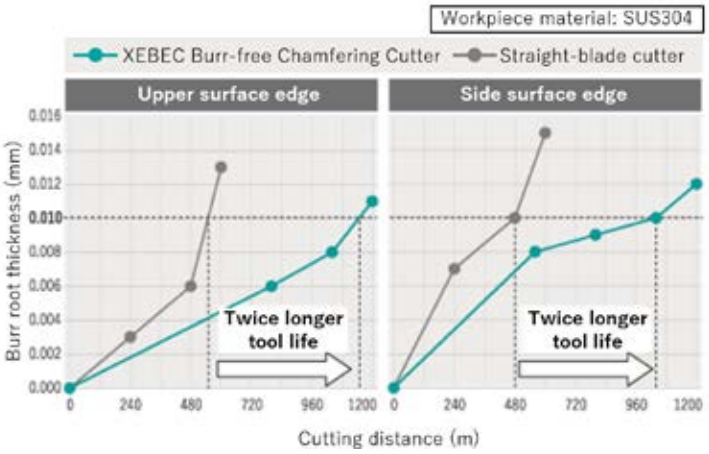
Uncoated For aluminum alloys, plastics and resins



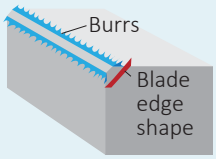


Twice the tool life of conventional straight-blade cutters

Internal tests have shown that the tool life of this cutter is twice as long as a conventional chamfering cutter.

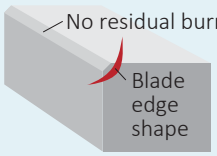


Traditional Straight Blade Chamfer Cutter

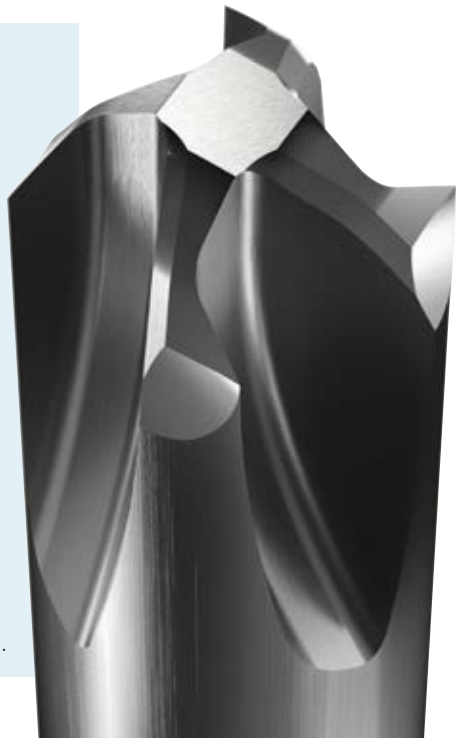


Leaves burrs along the upper and lower edges

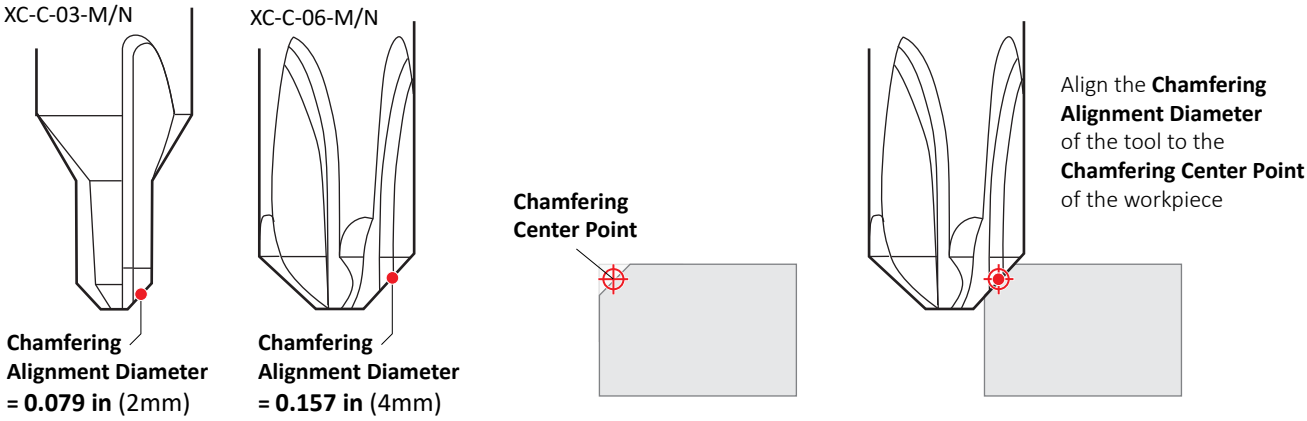
Improved Xebec V-Shaped Blade Design



Larger surface area cuts the chamfer, leaving a clean finished edge. Similarly to a snow plow, it sweeps the sides clean.



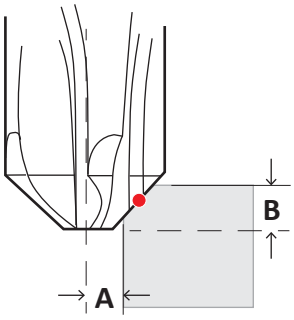
How to Use



Offset Reference Table

Tool	Chamfer Size (C)		Offset			
	mm	Inches	mm		Inches	
			A	B	A	B
XC-C-03-M/N	0.3	0.012	0.85	0.65	0.033	0.026
	0.4	0.015	0.8	0.7	0.031	0.028
	0.5	0.020	0.75	0.75	0.030	0.030
	0.6	0.024	0.7	0.8	0.028	0.031
XC-C-06-M/N	0.7	0.028	1.65	1.35	0.065	0.053
	0.8	0.031	1.6	1.4	0.063	0.055
	0.9	0.035	1.55	1.45	0.061	0.057
	1.0	0.039	1.5	1.5	0.059	0.059
	1.1	0.043	1.45	1.55	0.057	0.061
	1.2	0.047	1.4	1.6	0.055	0.063
	1.3	0.051	1.35	1.65	0.053	0.065
	1.4	0.055	1.3	1.7	0.051	0.067
	1.5	0.059	1.25	1.75	0.049	0.069

Create the machining program by referring to the offsets **A** and **B** in the table for desired chamfer size. This ensures that chamfer alignment diameter and the chamfer center point are aligned properly.



Machining Conditions

1. Rotational speed and feed rates are a guide for initial machining under standard machining conditions.

2. To improve the chamfering quality, please adjust the rotational speed, feed rate and the depth of cut.

3. If vibration or abnormal noise occurs, lower the rotational speed and feed rate, or adjust the depth of cut to be smaller.

4. If burrs are formed when chamfering a resin workpiece, please maintain the feed rate of 0.07 (mm/t) and adjust the rotational speed in accordance with the rotational speed of the currently used tool.

Starting Operating Parameters

Under standard machining conditions

XC-C-03-M/N

Material	Steel	SUS	64 Ti.	Inconel	Alum.	Resin
Product code (Coating)	XC-C-03-M *(AlTiCrN Coated)*				XC-C-03-N *(Uncoated)*	
Cutting speed SFPM (m/min)	197-328 (60-100)	131-262 (40-80)	148-197 (45-60)	66-98 (20-30)	656-984 (200-300)	197-328 (60-100)
RPM	12,000	9,000	8,000	4,000	40,000	12,000
IPM Feed rate (mm/min)	71 (1,800)	53 (1,350)	47 (1,200)	24 (600)	236 (6,000)	71 (1,800)
Feed amount (mm/t)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)

XC-C-06-M/N

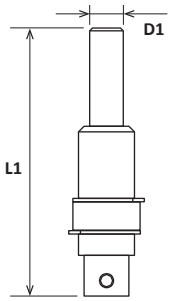
Material	Steel	SUS	64 Ti.	Inconel	Alum.	Resin
Product code (Coating)	XC-C-06-M *(AlTiCrN Coated)*				XC-C-06-N *(Uncoated)*	
Cutting speed SFPM (m/min)	197-328 (60-100)	131-262 (40-80)	148-197 (45-60)	66-98 (20-30)	656-984 (200-300)	197-328 (60-100)
RPM	6,300	4,800	4,000	2,000	20,000	6,300
IPM Feed rate (mm/min)	50 (1,260)	38 (960)	32 (800)	16 (400)	157 (4,000)	69 (1,760)
Feed amount (mm/t)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.002 (0.05)	0.003 (0.07)

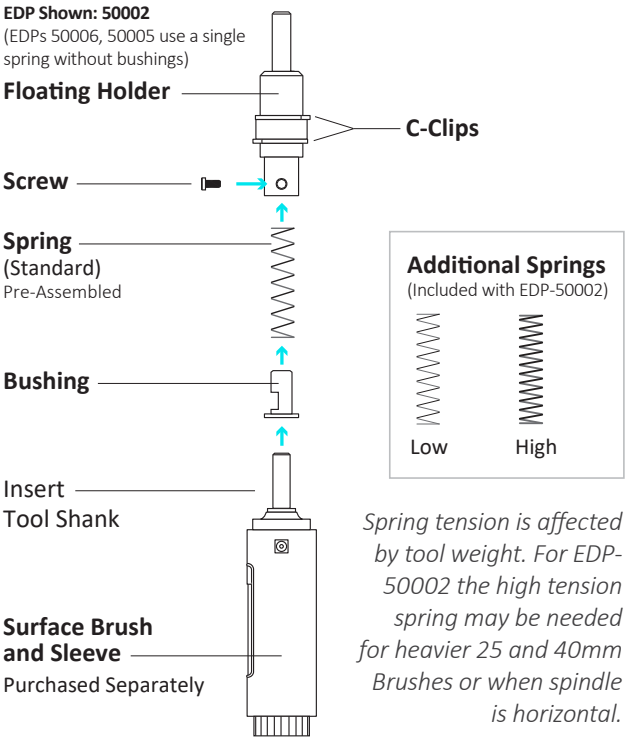
XEBEC BRUSH™

Floating Holder

Adjustable pressure control using a built-in spring.
Provides more consistent finish and longer brush life for heavy applications.

For Brush Diamter	EDP	Part No.	D1 Shank Diameter		L1 Overall Length		Axial Float		Gage Length		Compatible Sleeve (EDP)
			MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
6 mm	**50002**	FH-ST12-SL10	12	0.472	95.5	3.760	6	0.236	60.5	2.282	40006
15 mm											40005, 40007
25 mm											40004
40 mm											40003
60 mm	**50006**	FH-ST20-60	20	0.787	96.4	3.795	6	0.236	51.5	2.028	40002
100 mm	**50005**	FH-ST20-100	20	0.787	96.4	3.795	6	0.236	51.5	2.028	40001





Spring tension is affected by tool weight. For EDP-50002 the high tension spring may be needed for heavier 25 and 40mm Brushes or when spindle is horizontal.

Floating Holder Operation

For Floating Holder to operate effectively, it is necessary to preload the spring by adding tension at the contact point before initiating feed.

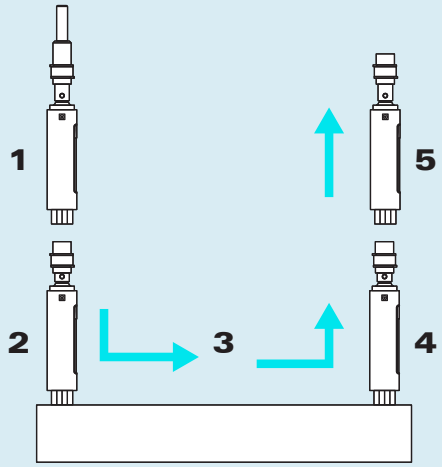
1. While Brush is not in motion, lower it vertically until contacting the workpiece. *Do not contact side of Brush with workpiece as it will damage the bristles.*

2. Set the depth of cut and contract the spring.

3. Begin rotation and start feeding.

4. When complete, stop rotation and feed.

5. Remove the tool upward



Ramping may also be used. Make sure to set preload before initiating feed.

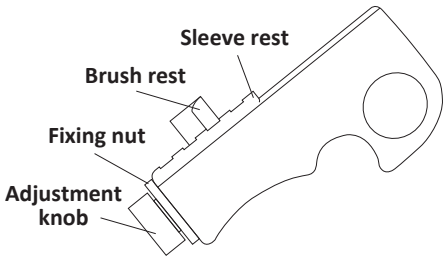
XEBEC BRUSH™

Length Adjustment Tool

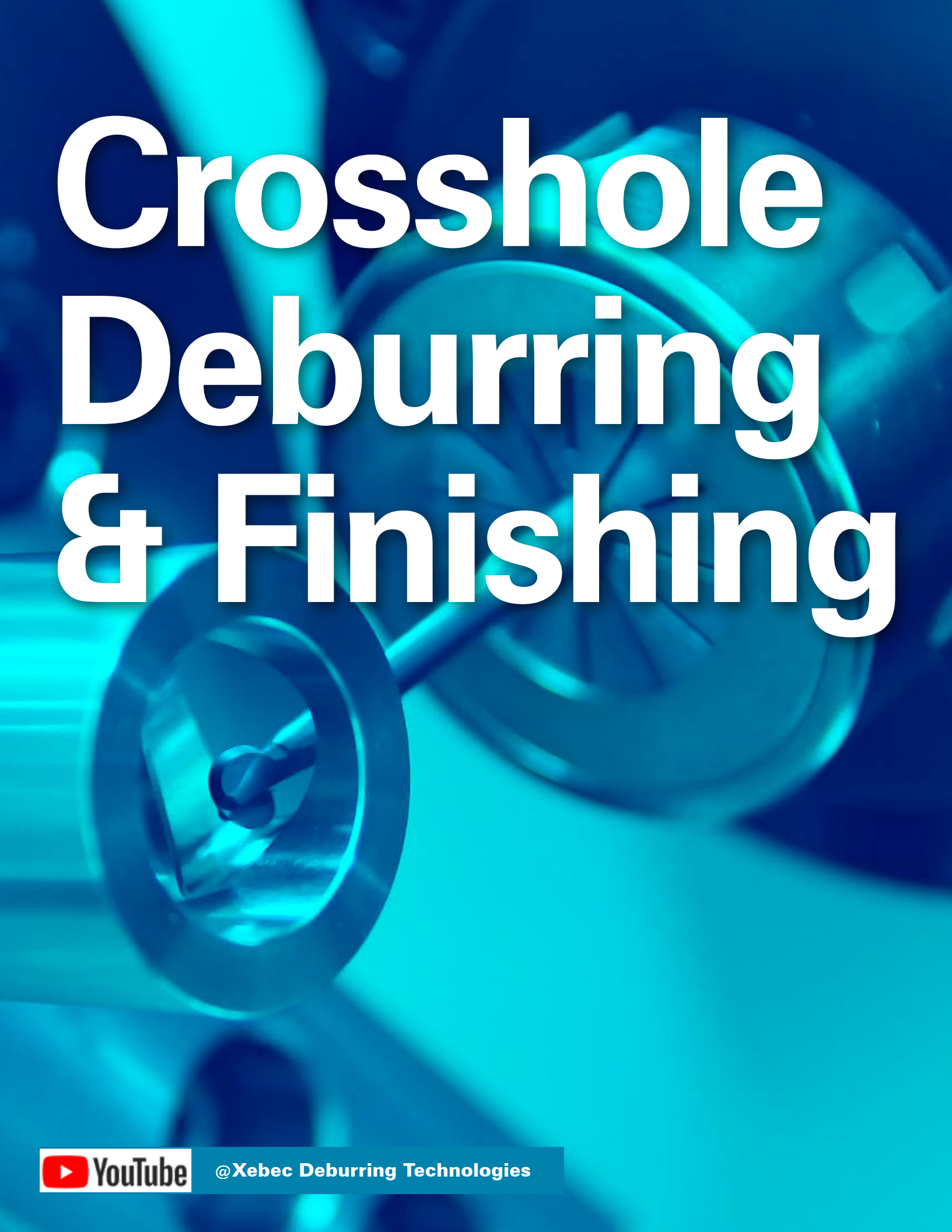
Quickly measure and adjust brush length manually without removing Brush from the machine.

EDP	Item	Part No.
50004	Brush Length Adjustment Tool	XP-EZ-001

For 15, 25, 40, 60, and 100mm diameter brushes.
Includes 1.5/2.0mm hexagonal wrench.



Crosshole Deburring & Finishing



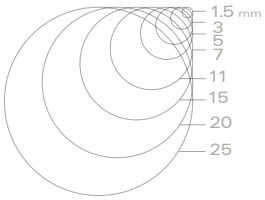
YouTube @Xebec Deburring Technologies

XEBEC BRUSH™ CROSSHOLE DEBURRING

Crosshole Brush

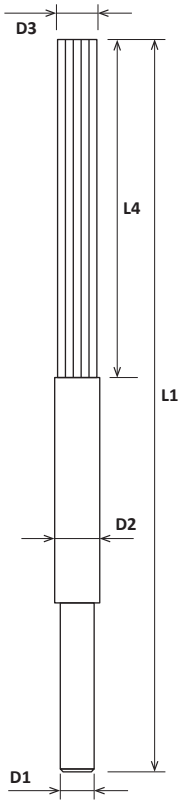
Crosshole diameter cannot exceed 50% of primary bore diameter.

- **Removal of fine burrs (base thickness is 0.1mm (.0039") or less) generated around cross-holes**
- **Polishing of inner wall surfaces of cylinders such as screw holes**
- **Polishing the bottom surface of dead-end holes**



Target Bore Diameter	Brush Size (D3)		L1 Overall Length		L4 Brush Length		D1 Shank Diameter		D2 Neck Diameter		Aggressiveness Less ⟷ More		Max RPM
	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	Red	Blue	
0.140 - 0.197" (3.5 - 5 mm)	**1.5**mm	0.060	120	4.724	50	1.969	3	0.118	2.5	0.098	**20007** CH-A12-1.5M	-	20,000
0.197 - 0.315" (5 - 8 mm)	**3**mm	0.118	120	4.724	50	1.969	3	0.118	4	0.157	**20001** CH-A12-3M-TL	-	12,000
			170	6.693			4	0.158			**20004** CH-A12-3L-TL	-	
			130	5.118	60	2.362	3	0.118			-	**20008** CH-A33-3M	
			180	7.087			4	0.158			-	**20012** CH-A33-3L	
0.315 - 0.394" (8 - 10 mm)	**5**mm	0.197	120	4.724	50	1.969	6	0.232	6	0.236	**20002** CH-A12-5M-TL	-	12,000
			170	6.693							**20005** CH-A12-5L-TL	-	
			130	5.118	60	2.362					-	**20009** CH-A33-5M	
			180	7.087								**20013** CH-A33-5L	
0.394 - 0.551" (10 - 14 mm)	**7**mm	0.276	120	4.724	50	1.969	6	0.232	8	0.315	**20003** CH-A12-7M-TL	-	12,000
			170	6.693			8	0.315			**20006** CH-A12-7L-TL	-	
			130	5.118	60	2.362	6	0.232			-	**20010** CH-A33-7M	
			180	7.087			8	0.315			-	**20014** CH-A33-7L	
0.551 - 0.787" (14 - 20 mm)	**11**mm	0.433	120	4.724	50	1.969	12	0.472	12	0.472	**20018** CH-A12-11M		12,000
			170	6.693							**20017** CH-A12-11L		
			130	5.118	60	2.362	12	0.472			-	**20011** CH-A33-11M	
			180	7.087							-	**20015** CH-A33-11L	
0.787 - 0.984" (20 - 25 mm)	**15**mm*	0.591	150	5.906	60	2.362	6	0.232	16	0.630	**A34 bristles** Dark Blue: formulated for improved flaring/ performance	**20021** CH-A34-15	9,000
0.984 - 1.181" (25 - 30 mm)	**20**mm*	0.787					8	0.315	21	0.827		**20022** CH-A34-20	
1.181 - 1.378" (30 - 35 mm)	**25**mm*	0.984					8	0.315	26	1.024	Reusable shank (sold separately) required	**20023** CH-A34-25	

NEW! Crosshole Brush Sizes* for bores up to 1.38"



*Requires a reusable shank to operate (sold separately)

Shank for 15mm brush: **EDP 20024**

Shank for 20 and 25mm brushes: **EDP 20025**

Custom Extra-Long Crosshole Brushes are available for depths exceeding 5.9 inches. This is a Special Order item consisting of brush collar and shank. Contact Customer Service for details.

For Target Bore Diameters larger than 1.38 inches use Surface Brush.

See Operating Parameters for Large Bore Crosshole page 31

Choosing Brush Color

Brush Color	Red	Blue
Aggressiveness	Least ←	→ Most
Workpiece Material	Resin	General steel
	Copper/Brass	Stainless steel
	Aluminum	
		Heat-resistant steel
		Cast-iron
		Hard-to-cut material
Burr Thickness	Micro fine burrs	
		Burr root thickness up to 0.004”
Target Finish	4 Ra or better	Up to 4 Ra

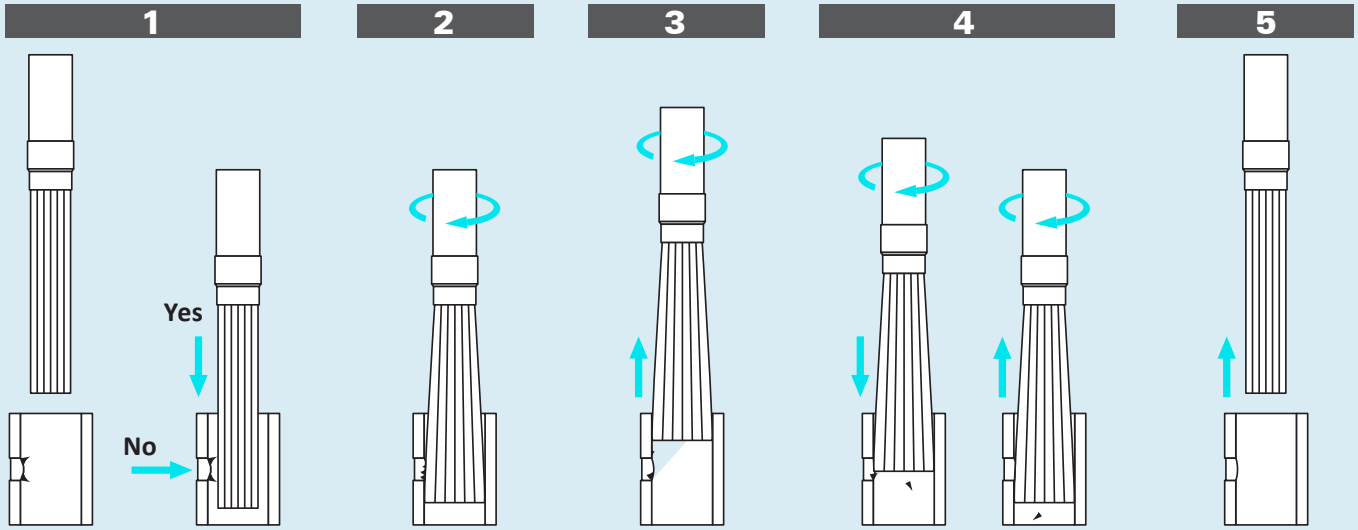
Suggested Starting Parameters

Feed Rate
12 to 15 IPM (inches/min)

Starting Speed (RPM)

	Red	Blue
1.5 mm	9,000-11,000	-
3 mm	7,000-10,000	7,500-9,000
5 mm	8,000-10,000	7,500-8,000
7 mm	7,000-9,000	6,500-8,000
11 mm	6,000-7,500	6,500-8,000
15 mm	-	7,000-9,000
20 mm	-	7,000-9,000
25 mm	-	7,000-9,000

How to Operate



1. Insert the Brush while at rest. Rotating brush outside cylinder may damage brush or injure operator.
2. Rotate the tool past the crosshole. (Rotate in both CW and CCW directions for best results.)
3. Process, pulling the brush back past crosshole to prevent burrs from laying flat against the interior.
4. If required, process bore again, pushing the brush forward past the crosshole and then back.
5 Stop brush rotation. Remove the brush while at rest.

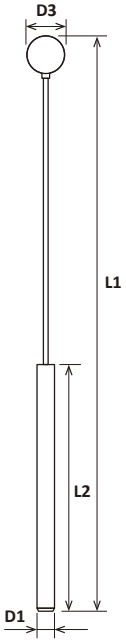
XEBEC STONE™

Flexible Shaft Stone

Soft contact abrasive ceramic fiber stone. Cutting edges exposed across the entire surface. For deburring crossholes and detailed finishing of parts

Ball Type

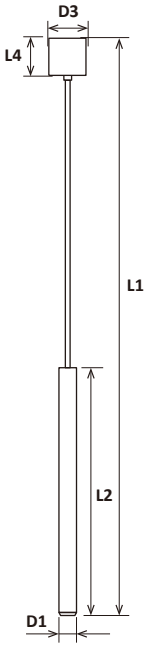
Ball Size (D3)		L1 Overall Length		D1 Shank Diameter		L2 Shank Length		Aggressiveness Less ⟷ More			Max RPM
MM	INCHES	MM	INCHES	MM	INCHES			Blue - #800	Orange - #400	Gray - #220	
3mm	0.118	71.5	2.815	3	0.118	30	1.181	10001 CH-PB-3B	10008 CH-PO-3B	10015 CH-PM-3B	15,000
4mm	0.157	73	2.874					10002 CH-PB-4B	10009 CH-PO-4B	10016 CH-PM-4B	13,000
5mm	0.197	72	2.835					10003 CH-PB-5B	10010 CH-PO-5B	10017 CH-PM-5B	12,000
6mm	0.236	75	2.953					10004 CH-PB-6B	10011 CH-PO-6B	10018 CH-PM-6B	10,000
10mm	0.393	72.5	2.854					-	-	10027 CH-PM-10B	7,000
3mm	0.118	152.5	6.004					-	-	10080 CH-PM-3B-L	1,000
4mm	0.157	151.5	5.965	2.3	0.091	-	-	-	-	10081 CH-PM-4B-L	3,000
5mm	0.197	153	6.024					-	-	10082 CH-PM-5B-L	3,000
6mm	0.236	152	5.984					-	-	10083 CH-PM-6B-L	3,000



10mm Ball Available Upon Request

Cylinder Type

Cylinder Size (D3 x L4)		L1 Overall Length		D1 Shank Diameter		L2 Shank Length		Aggressiveness Less ⟷ More			Max RPM
MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	Blue - #800	Orange - #400	Gray - #220	
3 x 3	0.118 x 0.118	71.5	2.815	3	0.118	30	1.181	10005 CH-PB-3R	10012 CH-PO-3R	10019 CH-PM-3R	15,000
4 x 4	0.157 x 0.157	72	2.835					10006 CH-PB-4R	10013 CH-PO-4R	10020 CH-PM-4R	13,000
5 x 5	0.197 x 0.197	72.5	2.854					10007 CH-PB-5R	10014 CH-PO-5R	10021 CH-PM-5R	12,000
5 x 10	0.197 x 0.393	75	2.953					-	-	10022 CH-PM-5R-C01	12,000



Disc Type

Disc Stone Size (D3 x L4)		L1 Overall Length		D1 Shank Diameter		Stone Disc Type	Requires Shaft (Sold separately)	Collet Sleeve (Optional) For tools with 2.3mm shaft	Max RPM
MM	INCHES	MM	INCHES	MM	INCHES	Gray - #220	Shaft	Allows use in rotary tools	
14 x 2	0.551 x 0.079	78	3.071	2.3	0.091	10030 CH-PM-14D	10031 CH-D-SH	10032 RMP3024X	5,000

NEW! A trial set is available that includes a Disc Type Stone and a Shaft - EDP: 10033 (CHPM14D-SET)

New 2.3 mm Collet Sleeve now available EDP: 10032**.** Allows the use of 2.3mm diameter shank tools in the Xebec Micro Motor.

XEBEC STONE™ FLEXIBLE SHAFT

Stone Color	Blue	Orange	Gray
Grit	#800	#400	#220

XEBEC Stone™

Ceramic Fibers are formed into Stones capable of cutting on all sides

Starting Operating Parameters

Stone should be about 25% larger than the crosshole, but smaller than the bore.

Do not flex the shaft of the tool more than 0.08 inches.

Material	Description	3mm Stone*	4mm Stone*	5mm Stone*	6mm Stone*
		RPM	RPM	RPM	RPM
Aluminum Castings	1000- 3000	12,000	9,100	7,000	6,100
Aluminum Castings	5052- 6061	13,000	9,900	7,600	6,600
Copper Brass	C93200- B- 148-52	12,000	9,100	7,000	6,100
Carbon Steel Alloys	1010- 1060	13,500	10,200	7,800	6,800
Low Alloy Steel	S1- O2- 4140- 5150	13,700	10,300	8,000	7,000
High Alloy Steel	H11- T15- M42	13,900	10,400	8,200	7,200
Stainless Steel/ Castings	403- 405- 17- 4 PH	13,500	10,200	8,000	7,000
300 Series Stainless	304- 316	12,200	9,300	7,200	6,200
Cast Iron - Gray & Nodular	All	13,200	9,900	7,600	6,600
White/Hardened Cast Iron	All	14,500	11,000	8,700	7,600
Titanium	TiAL6V4- 6V6AL2Sn	14,000	10,500	8,200	7,300
High Temp Alloys	Inconel- Hastelloy	14,500	11,000	8,700	7,600
	Maximum RPM	15,000	13,000	12,000	10,000

*Speeds shown for standard (72 mm) length stones only. Do not exceed maximum RPM for longer (150 mm) length stones.

XEBEC™

Back Burr Cutter & Path

Spherical deburring Cutter with a custom-made tool Path. For CNC deburring of entry and exit holes in a single pass.

Spherical Cutting Tool

Custom Path Data

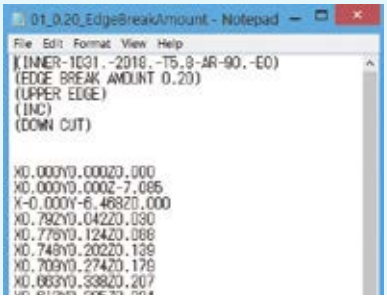
The tool can be mounted on machining center (XYZ-axis) or combined lathe (XZY or XZC-axis). 3-axis simultaneous control is required.

Machining Center

Combined Lathe

Xebec™ Back Burr Cutter

Xebec™ Generated Custom Tool Path



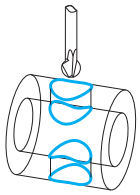
Custom Point Group Data

- Up and Down Cutting Directions
- Incremental and Absolute Modes
- 5 levels of Depth of Cut
- Performance is guaranteed

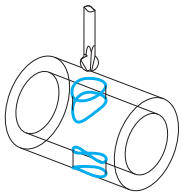
For a variety of edge shapes

One Cutter size supports various edges in different sizes and shapes.

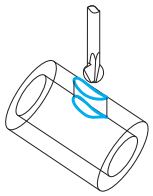
Orthogonal cross hole



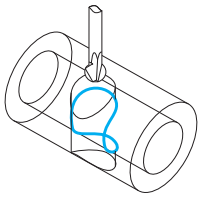
Off-center cross hole



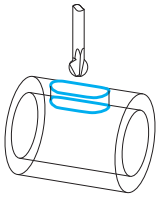
Angled cross hole



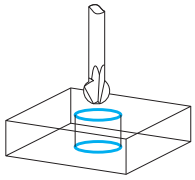
Broken cross hole



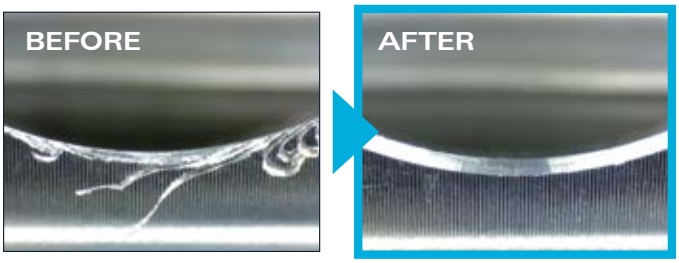
Slotted hole



Planar hole

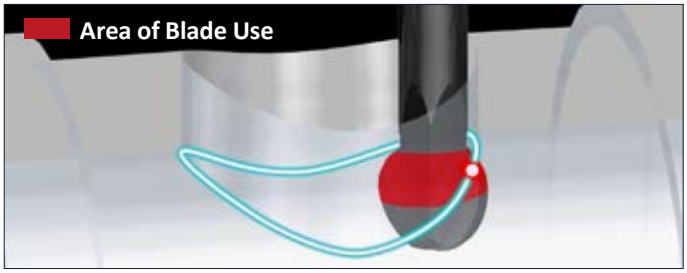


Stainless Steel

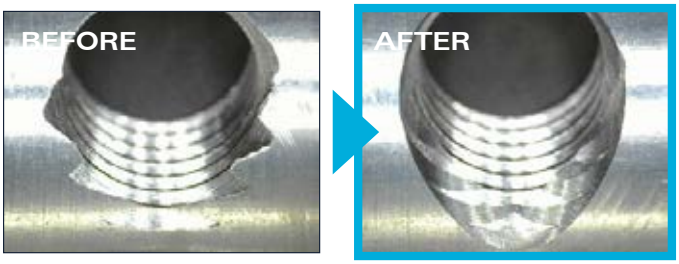


Longer Tool Life

Uses the entire cutting blade by constantly shifting the contact point

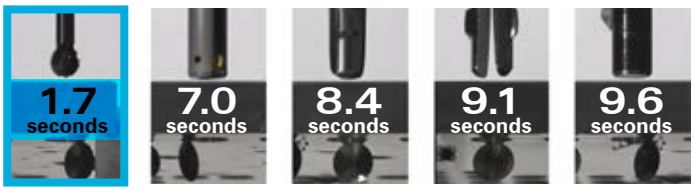


Tapped Holes



Uniform edge shape by consistent deburring amount

3 to 5 times Faster than Similar Tools



Back Burr Cutter & Path	Tool A	Tool B	Tool C	Tool D

YouTube Watch the video on our website or our YouTube Channel

Try our online Application Tool

Determine if your application is a fit for XEBEC™ Back Burr Cutter & Path. Results are immediately available.

https://xebec-backburr-cutter.com/

Uncoated cutter also available

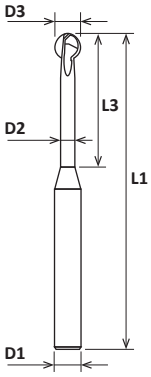
Allows a sharper edge. Perfect for soft and "sticky" materials like aluminum and plastic.

Neck Down Shank

EDP	Part No.	D1 Shank Diameter		D2 Neck Diameter		D3 Cutter Diameter		L1 Overall Length		L3 Neck Length		Blades	Uncoated EDP
		MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES		
51000	XC-08-A	3	0.118	0.48	0.019	0.8	0.031	60	2.362	4.2	0.165	2	**51032**
51001	XC-13-A	3	0.118	0.78	0.031	1.3	0.051	60	2.362	6.7	0.264	2	**51033**
51002	XC-18-A	3	0.118	1.1	0.043	1.8	0.071	60	2.362	8.2	0.323	2	**51034**
51013	XC-23-A	3	0.118	1.4	0.056	2.3	0.091	70	2.756	12.5	0.492	2	**51035**
51003	XC-28-A	4	0.157	1.7	0.067	2.8	0.110	70	2.756	12.2	0.480	2	**51036**
51014	XC-33-A	4	0.157	2	0.079	3.3	0.130	70	2.756	17.5	0.689	2	**51037**
51004	XC-38-A	4	0.157	2.4	0.094	3.8	0.150	70	2.756	16.2	0.638	2	**51038**
51005	XC-48-A	6	0.236	3	0.118	4.8	0.189	70	2.756	20.2	0.795	2	**51039**
51006	XC-58-A	6	0.236	3.5	0.138	5.8	0.228	70	2.756	24.2	0.953	2	**51040**
51015	XC-78-A	8	0.315	4.7	0.185	7.8	0.307	100	3.937	40	1.575	3	**51041**
51016	XC-98-A	10	0.394	5.9	0.232	9.8	0.354	120	4.724	50	1.969	3	**51042**

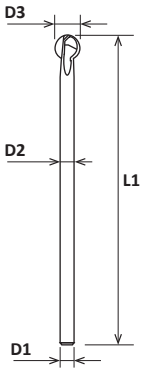
3-Bladed (with shorter neck)

EDP	Part No.	D1 Shank Diameter		D2 Neck Diameter		D3 Cutter Diameter		L1 Overall Length		L3 Neck Length		Blades
		MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
51021	XC-08-AS-3F	3	0.118	0.48	0.019	0.8	0.031	60	2.362	3	0.118	3
51022	XC-13-AS-3F	3	0.118	0.78	0.031	1.3	0.051	60	2.362	5	0.197	3
51023	XC-18-AS-3F	3	0.118	1.1	0.043	1.8	0.071	60	2.362	6	0.236	3
51024	XC-23-AS-3F	3	0.118	1.4	0.056	2.3	0.091	70	2.756	7.5	0.295	3
51025	XC-28-AS-3F	4	0.157	1.7	0.067	2.8	0.110	70	2.756	9	0.354	3
51026	XC-33-AS-3F	4	0.157	2	0.079	3.3	0.130	70	2.756	10.5	0.413	3
51027	XC-38-AS-3F	4	0.157	2.4	0.094	3.8	0.150	70	2.756	12	0.472	3
51028	XC-48-AS-3F	6	0.236	3	0.118	4.8	0.189	70	2.756	15	0.591	3
51029	XC-58-AS-3F	6	0.236	3.5	0.138	5.8	0.228	70	2.756	18	0.709	3
51030	XC-78-AS-3F	8	0.315	4.7	0.185	7.8	0.307	100	3.937	24	0.945	3
51031	XC-98-AS-3F	10	0.394	5.9	0.232	9.8	0.354	120	4.724	30	1.181	3

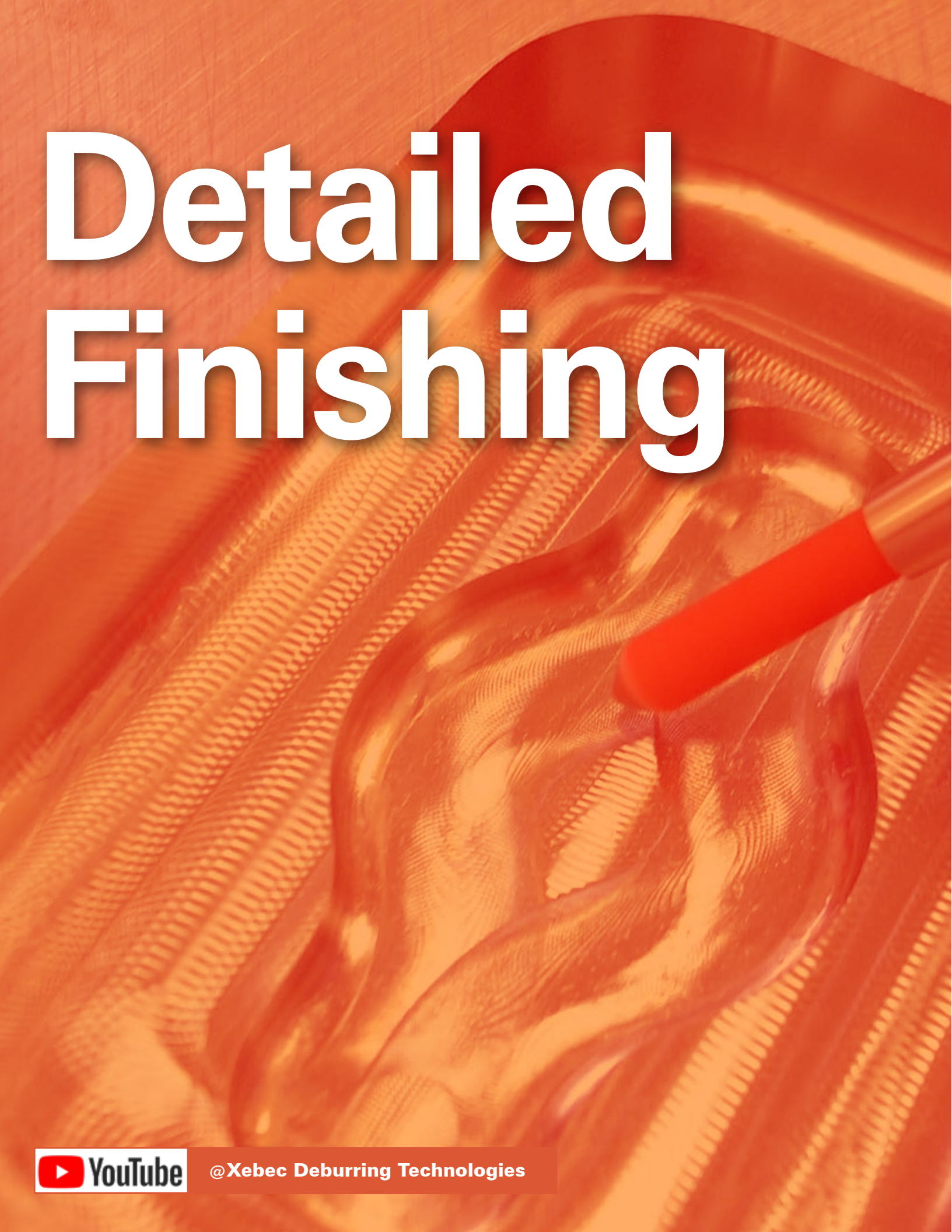


Straight Shank

EDP	Part No.	D1 Shank Diameter		D2 Shaft Diameter		D3 Cutter Diameter		L1 Overall Length		L3 Shaft Length		Blades
		MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
51007	XC-18-B	1.1	0.043	1.1	0.043	1.8	0.071	50	1.969	48.2	1.898	2
51017	XC-23-B	1.4	0.056	1.4	0.056	2.3	0.091	60	2.362	57.7	2.272	2
51008	XC-28-B	1.7	0.067	1.7	0.067	2.8	0.110	70	2.756	67.2	2.646	2
51018	XC-33-B	2	0.079	2	0.079	3.3	0.130	80	3.149	76.7	3.020	2
51009	XC-38-B	2.4	0.094	2.4	0.094	3.8	0.150	85	3.346	84.62	3.331	2
51010	XC-48-B	3	0.118	3	0.118	4.8	0.189	105	4.134	100.2	3.945	2
51011	XC-58-B	3.5	0.138	3.5	0.118	5.8	0.228	120	4.724	114.2	4.496	2
51019	XC-78-B	4.7	0.185	4.7	0.185	7.8	0.307	150	5.906	142.2	5.599	3
51020	XC-98-B	5.9	0.232	5.9	0.232	9.8	0.354	180	7.087	170.2	6.701	3



Detailed Finishing



YouTube @Xebec Deburring Technologies

Xebec™ Micro Motor

Portable, battery-powered rotary tool

EDP	Item	Part No.
52000	Xebec Micro Motor	M2P33ST

Handpiece

Speed: 0-30,000

Maximum Torque: 3.5 Ncm

Weight: 0.3 lbs

Control Unit

Battery: Rechargeable Li-Ion

Operating time: approx. 5 hrs

Charge time: 3 hrs

Dimensions: 2.6” x 5” x 1.2”

Weight: 0.6 lbs

Easy To Use

Small-size, lightweight, and mobile system for quick manual deburring/polishing solutions.

Best solution for users who use XEBEC hand solutions, but require the productivity of machine tools on the shopfloor.

Digital RPM display supports safe use of XEBEC tools.

Stronger torque allows Xebec tools to cut freely under load.

Use with these XEBEC™ 3mm Shank Tools

XEBEC BRUSH™
End Type

XEBEC STONE™
Meister Rods

XEBEC STONE™
Flexible Shaft

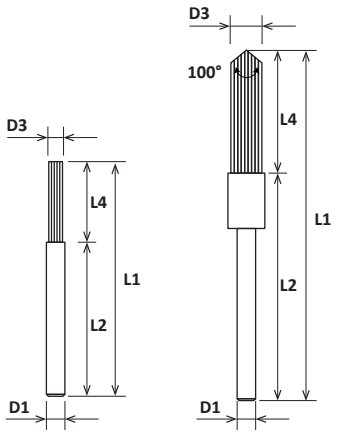
XEBEC STONE™
Mounted Point

New 2.3 mm Collet Sleeve now available EDP: 10032**.**
Allows the use of 2.3mm diameter shank tools in the Xebec™ Micro Motor.

XEBEC BRUSH™

End Type Brush

Ideal for cutter-mark removal, polishing and finishing of parts with narrow features.



Brush Size (D3)		Aggressiveness: Less ← → More				D1 Shank Diameter		L1 Overall Length		L2 Shank Length		L4 Brush Length		Max RPM
MM	INCHES	Pink	Red	White	Blue	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
1mm	0.039	30050 A13-EB01S	30054 A11-EB01S	-	-	3	0.118	52	2.047	37	1.457	15	0.591	15,000
1.5mm	0.059	30051 A13-EB015S	30055 A11-EB015S	-	-									
2mm	0.079	30052 A13-EB02S	30056 A11-EB02S	-	-									
2.5mm	0.098	30053 A13-EB025S	30057 A11-EB025S	-	-									
3mm	0.118	30014 A13-EB03M	-	-	-	3	0.118	67	2.638	28	1.102	30	1.181	6,000
5mm	0.19	-	60001 A11-EB06M	60002 A21-EB06M	60012 A32-EB06M	3	0.118	58	2.28	28	1.10	20	0.79	15,000

*60001, 60002, 60012 have a 100 degree angled tip

Brush Color	Pink	Red	White	Blue
Aggressiveness	Least ←			→ Most
Target Material	Resin	General steel	Stainless steel	
	Copper/Brass		Heat-resistant steel	
	Aluminum		Cast-iron	
				Hardest materials
Burr Thickness	Micro fine burrs	Burr root thickness up to 0.004”		
				Up to 0.008”
Target Finish	4 Ra or better		Up to 4 Ra	

XEBEC STONE™

Stone Mounted Point

Ideal for use with pneumatic tools at high rotational speed.
Cutting edges exposed across the entire surface.

Stone Color	**Gray**
Grit	#220

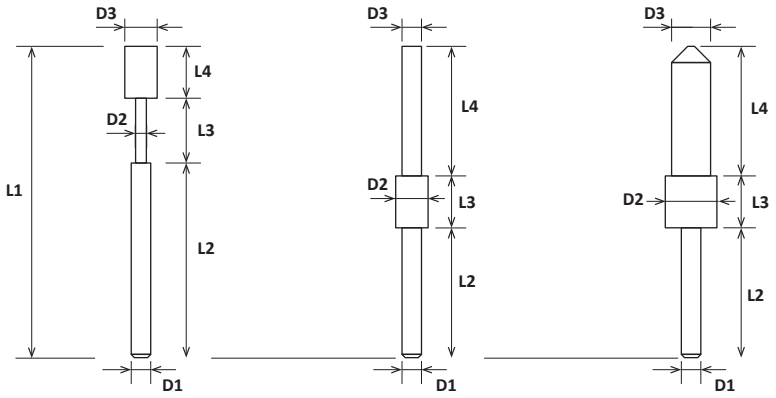
60003

60004

60005

Head	EDP	Part No.	D1 Shank Diameter		D2 Neck Diameter		D3 Stone Diameter		L1 Overall Length		L2 Shank Length		L3 Neck Length		L4 Stone Length		Max RPM
			MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	
Cylinder Shaft	**60003**	AX-PM-5RF	3	0.118	1.5	0.059	5	0.197	48	1.890	30	1.181	10	0.394	8	0.315	30,000
Solid Cylinder	**60004**	AX-PM-3R	3	0.118	5	0.197	3	0.118	48	1.890	20	0.787	8	0.315	20	0.787	60,000
Pointed tip	**60005**	AX-PM-6T	3	0.118	8	0.315	6	0.236	48	1.890	20	0.787	8	0.315	20	0.787	60,000

*60005 has 100 degree angled tip



XEBEC STONE™

Meister Finish

Additional sizes available. Please allow 2-3 week delivery on all Meister Finish products.

Stick Type

Tip cutting ceramic fiber stone

Dimension (mm) T	W	L	Red #1200	White #1000	Blue #800	Black #600	Orange #400	Light Brown #300	Dark Brown #220	Violet #120
0.5	4	100	**70043**	**70049**	**70017**	**70061**	**70067**	**70073**	**70010**	-
	6	100	**70045**	**70052**	**70057**	**70063**	**70069**	**70080**	**70085**	-
	10	100	**70047**	**70054**	**70059**	**70065**	**70071**	**70082**	**70087**	-
0.8	4	100	**70091**	**70096**	**70077**	**70105**	**70620**	**70076**	**70014**	-
1	1	100	**70127**	**70135**	**70141**	**70148**	**70155**	**70337**	**70167**	-
	2	100	**70128**	**70012**	**70142**	**70621**	**70019**	**70161**	**70050**	**70173**
	4	100	**70001**	**70002**	**70003**	**70004**	**70005**	**70006**	**70007**	**70008**
	6	100	**70025**	**70026**	**70027**	**70028**	**70029**	**70030**	**70031**	**70032**
	10	100	**70133**	**70018**	**70078**	**70153**	**70016**	**70013**	**70075**	**70178**
2	4	100	**70235**	**70242**	**70249**	**70256**	**70263**	**70270**	**70277**	**70283**
	6	100	**70237**	**70244**	**70251**	**70258**	**70265**	**70272**	**70279**	**70285**
3	4	100	**70289**	**70295**	**70301**	**70307**	**70313**	**70319**	**70325**	**70331**
	6	100	**70291**	**70297**	**70303**	**70309**	**70315**	**70321**	**70327**	**70333**

Heat Resistant

Stick will not soften, heat-resistant to 392 °F

Ultrasonic

Stick Type

Dimension (mm) T	W	L	Red #1200	Blue #800	Dark Brown #220	Violet #120
1	4	100	**70683**	**70705**	**70706**	**70690**
	6	100	**70684**	**70686**	**70688**	**70691**
	10	100	**70685**	**70687**	**70689**	**70692**
2	4	100	**70693**	**70696**	**70699**	**70702**
	6	100	**70694**	**70697**	**70700**	**70703**
	10	100	**70695**	**70698**	**70701**	**70704**

Diamond

Contains diamond abrasive fiber for materials harder than 57 HRc

For polishing and EDM scale removal

Ultrasonic

Stick Type

Dimension (mm) T	W	L	Black #200	Blue-Green #400	Gray #800
1	4	100	**70900**	**70901**	**70902**
	6	100	**70903**	**70905**	**70907**
	10	100	**70904**	**70906**	**70908**

Rod Type

Dimension (mm) D	L	Blue-Green #400
3	50	**70909**
	100	**70910**

Stick Holder

For manual use

EDP	Part	STICK WIDTH	
		MM	INCH
70962	SSH-4	4	0.157
70963	SSH-6	6	0.236
70964	SSH-10	10	0.393

Rod Holder

For manual use

EDP	Part	ROD DIAMETER	
		MM	INCH
70967	SNH-20	2-2.34	0.07-0.09
70968	SNH-30	3	0.118

Rod Type

Ceramic fiber cutting edges are exposed over the entire surface

Dimensions (mm)		Red #1200	White #1000	Blue #800	Black #600	Orange #400	Light Brown #300	Gray #220
D	L							
1	50	**70626**	**70628**	**70630**	**70632**	**70634**	**70636**	**70638**
	100	**70627**	**70629**	**70631**	**70633**	**70635**	**70637**	**70639**
1.5	50	**70614**	**70640**	**70642**	**70615**	**70644**	**70646**	**70648**
	100	**70625**	**70641**	**70643**	**70624**	**70645**	**70647**	**70649**
2	50	**70650**	**70652**	**70654**	**70656**	**70658**	**70660**	**70662**
	100	**70651**	**70653**	**70655**	**70657**	**70659**	**70661**	**70663**
2.34	50	**70616**	**70672**	**70617**	**70675**	**70677**	**70618**	**70619**
	100	**70671**	**70673**	**70674**	**70676**	**70678**	**70679**	**70680**
3	50	**70600**	**70601**	**70602**	**70603**	**70604**	**70605**	**70606**
	100	**70613**	**70612**	**70611**	**70610**	**70609**	**70607**	**70608**
	150	**70664**	**70665**	**70666**	**70667**	**70668**	**70669**	**70670**

Use 3mm Diameter Rods in Xebec Micro Motor

Pencil

EDP	Part	Color, Grit	T		W		L		Pencil Holder	Qty. Per Pack
			MM	IN	MM	IN	MM	IN		
70950	A-R-0505S	Red #1200	0.5	.019	0.5	.019	50	1.969	**70960**	3 stones
70952	A-B-0505S	Blue #800								
70951	A-R-0909S	Red #1200	0.9	.036	0.9	.036	50	1.969	**70961**	
70953	A-B-0909S	Blue #800								

Pencil Holder

0.5 mm Holder
70960
PCL05

0.9 mm Holder
70961
PCL09

XEBEC STONE™

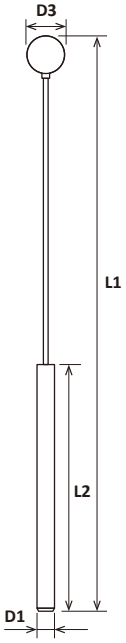
Flexible Shaft Stone

Soft contact abrasive ceramic fiber stone. Cutting edges exposed across the entire surface.
For deburring crossholes and detailed finishing of parts

Ball Type

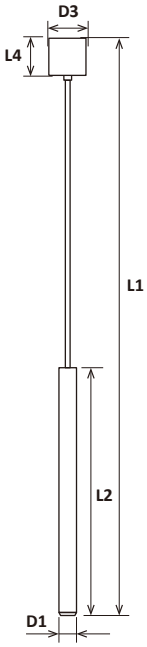
Ball Size (D3)		L1 Overall Length		D1 Shank Diameter		L2 Shank Length		Aggressiveness Less ← → More			Max RPM
MM	INCHES	MM	INCHES	MM	INCHES			Blue - #800	Orange - #400	Gray - #220	
3mm	0.118	71.5	2.815	3	0.118	30	1.181	10001 CH-PB-3B	10008 CH-PO-3B	10015 CH-PM-3B	15,000
4mm	0.157	73	2.874					10002 CH-PB-4B	10009 CH-PO-4B	10016 CH-PM-4B	13,000
5mm	0.197	72	2.835					10003 CH-PB-5B	10010 CH-PO-5B	10017 CH-PM-5B	12,000
6mm	0.236	75	2.953					10004 CH-PB-6B	10011 CH-PO-6B	10018 CH-PM-6B	10,000
10mm	0.393	72.5	2.854					-	-	10027 CH-PM-10B	7,000
3mm	0.118	152.5	6.004					-	-	10080 CH-PM-3B-L	1,000
4mm	0.157	151.5	5.965	2.3	0.091	-	-	-	-	10081 CH-PM-4B-L	3,000
5mm	0.197	153	6.024					-	-	10082 CH-PM-5B-L	3,000
6mm	0.236	152	5.984					-	-	10083 CH-PM-6B-L	3,000

10mm Ball Available Upon Request



Cylinder Type

Cylinder Size (D3 x L4)		L1 Overall Length		D1 Shank Diameter		L2 Shank Length		Aggressiveness Less ← → More			Max RPM
MM	INCHES	MM	INCHES	MM	INCHES	MM	INCHES	Blue - #800	Orange - #400	Gray - #220	
3 x 3	0.118 x 0.118	71.5	2.815	3	0.118	30	1.181	10005 CH-PB-3R	10012 CH-PO-3R	10019 CH-PM-3R	15,000
4 x 4	0.157 x 0.157	72	2.835					10006 CH-PB-4R	10013 CH-PO-4R	10020 CH-PM-4R	13,000
5 x 5	0.197 x 0.197	72.5	2.854					10007 CH-PB-5R	10014 CH-PO-5R	10021 CH-PM-5R	12,000
5 x 10	0.197 x 0.393	75	2.953					-	-	10022 CH-PM-5R-C01	12,000



Disc Type

Disc Stone Size (D3 x L4)		L1 Overall Length		D1 Shank Diameter		Stone Disc Type	Requires Shaft (Sold separately)	Collet Sleeve (Optional) For tools with 2.3mm shaft	Max RPM
MM	INCHES	MM	INCHES	MM	INCHES	Gray - #220	Shaft	Allows use in rotary tools	
14 x 2	0.551 x 0.079	78	3.071	2.3	0.091	10030 CH-PM-14D	10031 CH-D-SH	10032 RMP3024X	5,000

NEW! A trial set is available that includes a Disc Type Stone and a Shaft - EDP: 10033 (CHPM14D-SET)
New 2.3 mm Collet Sleeve now available EDP: 10032**.** Allows the use of 2.3mm diameter shank tools in the Xebec Micro Motor.

Operating Parameters

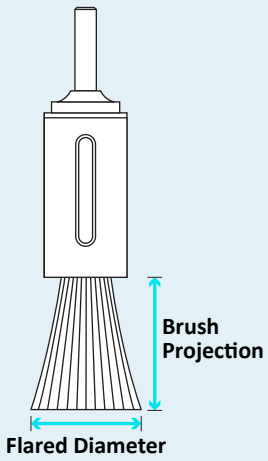
Instruction manuals for all products are available on our website at:
deburringtechnologies.com/specs

Xebec™ tools must be used properly for best performance. Follow all recommended operating parameters and do not exceed maximums. Failure to do so may result in damage or injury.

Instruction Manuals

For additional help with applications and operating parameters, call our tech support line at 1-800-434-9775 or visit us online.

XEBEC BRUSH™ SURFACE
Special Application for Crosshole Deburring of Large Diameters

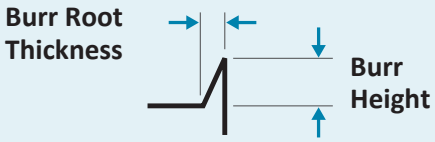


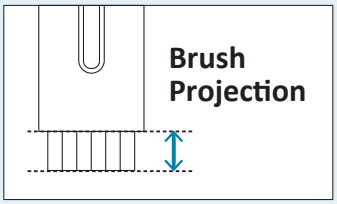
Brush Size	EDP	RPM	Brush Projection 1.181"	1.574"	1.771"	1.968"	2.362"	2.755"
			Flared Diameter					
15 mm	30005 A11-CB15M	6000 rpm	1.023"	1.771"	2.165"	2.362"	-	-
		5000 rpm	0.984"	1.417"	1.574"	1.968"	-	-
		4000 rpm	0.826"	1.062"	1.062"	1.062"	-	-
	30011 A21-CB15M	6000 rpm	0.984"	1.417"	1.811"	2.283"	-	-
		5000 rpm	0.866"	1.062"	1.062"	1.417"	-	-
		4000 rpm	0.826"	0.866"	0.866"	0.905"	-	-
25 mm	30004 A11-CB25M	5000 rpm	1.574"	2.519"	3.346"	4.173"	-	-
		4000 rpm	1.456"	1.771"	2.874"	3.385"	4.724"	-
		3000 rpm	1.377"	1.692"	2.204"	2.992"	4.094"	4.724"
	30010 A21-CB25M	5000 rpm	1.377"	1.771"	2.755"	2.755"	4.015"	-
		4000 rpm	1.299"	1.653"	2.244"	2.244"	2.992"	3.661"
		3000 rpm	1.259"	1.456"	1.811"	1.811"	2.362"	2.559"
40 mm	30003 A11-CB40M	4000 rpm	-	-	3.700"	4.330"	-	-
		3000 rpm	1.968"	2.401"	2.874"	3.346"	4.842"	-
		2000 rpm	1.811"	2.165"	2.283"	2.559"	3.425"	4.330"
		1000 rpm	1.771"	1.850"	1.929"	1.968"	2.047"	2.086"
	30009 A21-CB40M	4000 rpm	-	-	2.755"	3.267"	-	-
		3000 rpm	1.850"	2.125"	2.440"	2.716"	3.543"	4.527"
		2000 rpm	1.771"	1.929"	2.165"	2.244"	2.559"	2.834"
		1000 rpm	1.692"	1.732"	1.732"	1.732"	1.771"	1.811"

Operating Conditions

Target Burr Size

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

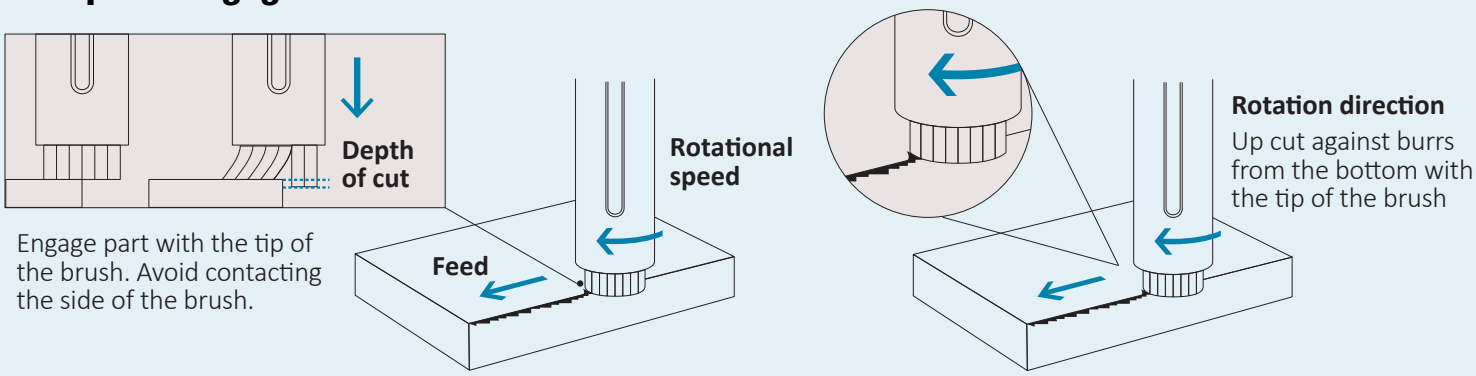




Brush Size Diameter	6 mm	15 mm	25 mm	40 mm	60 mm	100 mm
Brush Projection All Grades (in)	0.3125-0.375"	0.375-0.5625"	0.5-0.625"	0.5-0.625"	0.5-0.75"	0.5-0.75"

Brush projection below 0.2” increases grinding power and may affect finish

Workpiece Engagement



Engage part with the tip of the brush. Avoid contacting the side of the brush.

Depth of Cut
All Brush Grades
(Inches)

Polishing	Vertical Burr	Horizontal Burr	Heavy Burr
0.012”	**0.020”**	**0.040”**	**0.060”**

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 A13 Pink, A21 White, A11 Red, A32 Blue with the same parameters

Use of Coolant/Oil will optimize results

- **It will Extend Tool Life**
- **Improves Surface Finish**

XEBEC BRUSH™ SURFACE

Starting Operating Parameters for Automated Machining

		Brush Size (Diameter)		6 mm	15 mm	25 mm	40 mm	60 mm	100 mm	Feed Rate	
		Initial Brush Projection		0.3125-0.375"	0.375-0.5625"	0.5-0.625"	0.5-0.625"	0.5-0.75"	0.5-0.75"		
		Maximum RPM		10,000	6,000	5,000	3,000	2,000	1,000	Finishing	Deburring
Material	**SFPM**	**1st Choice**	**2nd Choice**	**RPM**	**RPM**	**RPM**	**RPM**	**RPM**	**RPM**	**IPM**	**IPM**
Low Carbon Steel	600	○ White	● Blue	9,707	3,883	2,330	1,456	971	582	47	94
Medium Carbon Steel	550	○ White	● Blue	8,898	3,559	2,136	1,335	890	534	40	80
High Carbon Steel	500	○ White	● Blue	8,089	3,236	1,941	1,213	809	485	34	67
Cast Steel	450	● Blue	○ White	7,280	2,912	1,747	1,092	728	437	27	54
300 Series Stainless	525	○ White	● Red	8,494	3,397	2,038	1,274	849	510	47	94
400 Series Stainless	575	○ White	● Red	9,303	3,721	2,233	1,395	930	558	47	94
Grey Cast Iron	400	● Blue	○ White	6,471	2,589	1,553	971	647	388	54	107
Ductile Cast Iron	350	● Blue	○ White	5,662	2,265	1,359	849	566	340	47	94
Alloy Cast Iron	300	● Blue	○ White	4,854	1,941	1,165	728	485	291	40	80
Aluminum Cast Alloys	700	● Red	○ White	10,000	4,530	2,718	1,699	1,132	679	80	161
Aluminum Diecast Alloys	800	● Red	○ White	10,000	5,177	3,106	1,941	1,294	777	74	147
Aluminum Wrought Alloys	900	● Red	○ White	10,000	5,824	3,495	2,184	1,456	874	67	134
Zinc Diecastings	800	● Red	○ White	10,000	5,177	3,106	1,941	1,294	777	67	134
Copper	600	● Red	○ White	9,707	3,883	2,330	1,456	971	582	60	121
Brass, Free Machining	600	● Red	○ White	9,707	3,883	2,330	1,456	971	582	74	148
Cast Bronze	500	● Red	○ White	8,089	3,236	1,941	1,213	809	485	47	94
Nickel Alloys	200	● Blue	○ White	3,236	1,294	777	485	324	194	40	80
Titanium Alloys	200	● Blue	○ White	3,236	1,294	777	485	324	194	40	80
Plastic, Thermosetting	500	○ Pink	● Red	8,089	3,236	1,941	1,213	809	485	80	161
Plastic, Thermoplastic	800	○ Pink	● Red	10,000	5,177	3,106	1,941	1,294	777	80	161

Adjustments for Improved Results

If burrs or cutter marks remain

1 Increase Rotational Speed
In increments of 25%, Do not exceed Maximum RPM

2 Increase the Number of Passes
Each pass will improve finish by approximately one half

3 Decrease Feed Rate
In increments of 10 to 20%

4 Use more aggressive Color of Brush
(Pink=Least Aggressive, Blue=Most Aggressive)

Increase Grinding Power

Feed Rate	Rotational Speed	Depth of Cut
⌄	⌃	⌃

Decrease Grinding Power

Feed Rate	Rotational Speed	Depth of Cut
⌃	⌄	⌄

XEBEC® Success Stories

Cost Savings

XEBEC® | DEBURRING TECHNOLOGIES

How Automated Deburring Saved One Customer Over $275,000 per year

Moving from Manual Deburring Process to Automated Process with Xebec Brush™ Surface.

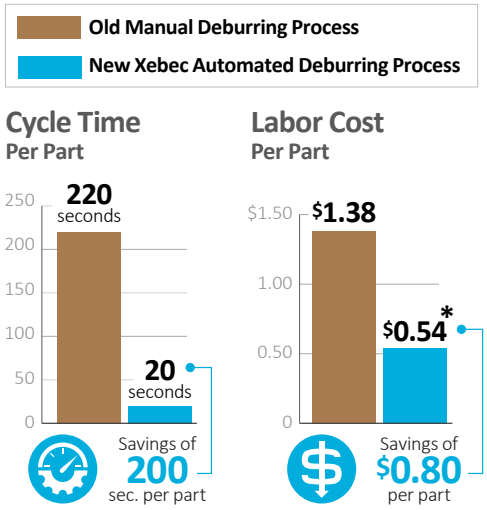
At Xebec, we continue to help people with deburring problems become heroes in their own company. Check out these amazing cost savings examples from the firearms industry.

Our customer was manually deburring the two parts shown in the calculations below. By switching to an automated process, utilizing a ceramic Xebec surface brush, they are looking at an estimated savings of over $275k per year.

Labor Cost

Manual	Machine
$22/hr	$80/hr

At first glance, manual deburring appears to cost less.

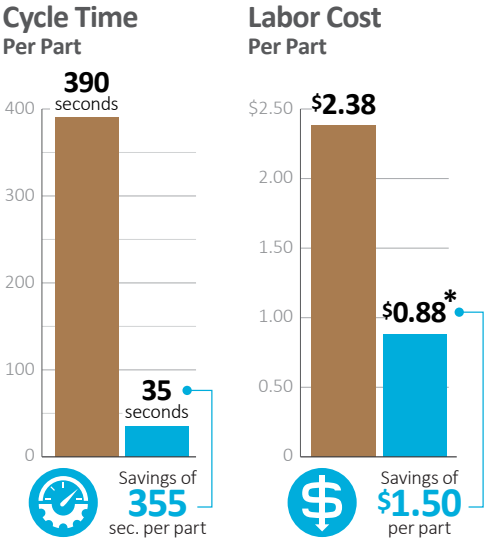


EXAMPLE 1:

Estimated annual cost savings of $96,058

- Original manual deburring process had a cycle time of 220 seconds per part. With labor burden rates at $22 per hour, that equates to $1.34 in labor cost per part.
- New Xebec automated process has a cycle time of 20 seconds per part. With machine costs at $80 per hour, that equates to just $0.44 cost per piece. Add in the cost of the ceramic brush $0.10 per piece ($149.27 / 1500 pieces) and you have a total cost per piece of just $0.54.
- Manual deburring $1.34 per part – Xebec deburring $0.54 per part = $0.80 savings per part
- Customer is making 10,000 of these parts per month (120k per year).
- 120,000 pieces multiplied by $0.80 per piece cost savings = $96,058

***Cost includes all tool expenses.**
Xebec 15mm Surface Brush: $149.27 each
Total Brush cost for 120,000 parts: $11,941.60 or $0.10/part



In addition to cost savings, part quality and consistency are greatly improved with the Xebec Brush.

EXAMPLE 2:

Estimated annual cost savings of $180,000

- Original manual deburring process had a cycle time of 390 seconds per part. With labor burden rates at $22 per hour, that equates to $2.38 in labor cost per part.
- New Xebec automated process has a cycle time of 35 seconds per part. With machine costs at $80 per hour, that equates to just $0.78 cost per piece. Add in the cost of the ceramic brush $0.10 per piece ($149.27 / 1500 pieces) and you have a total cost per piece of just $0.88.
- Manual deburring $2.38 per part – Xebec deburring $0.88 per part = $1.50 savings per part
- Customer is making 10,000 of these parts per month (120k per year).
- 120,000 pieces multiplied by $1.50 per piece cost savings = $180,000

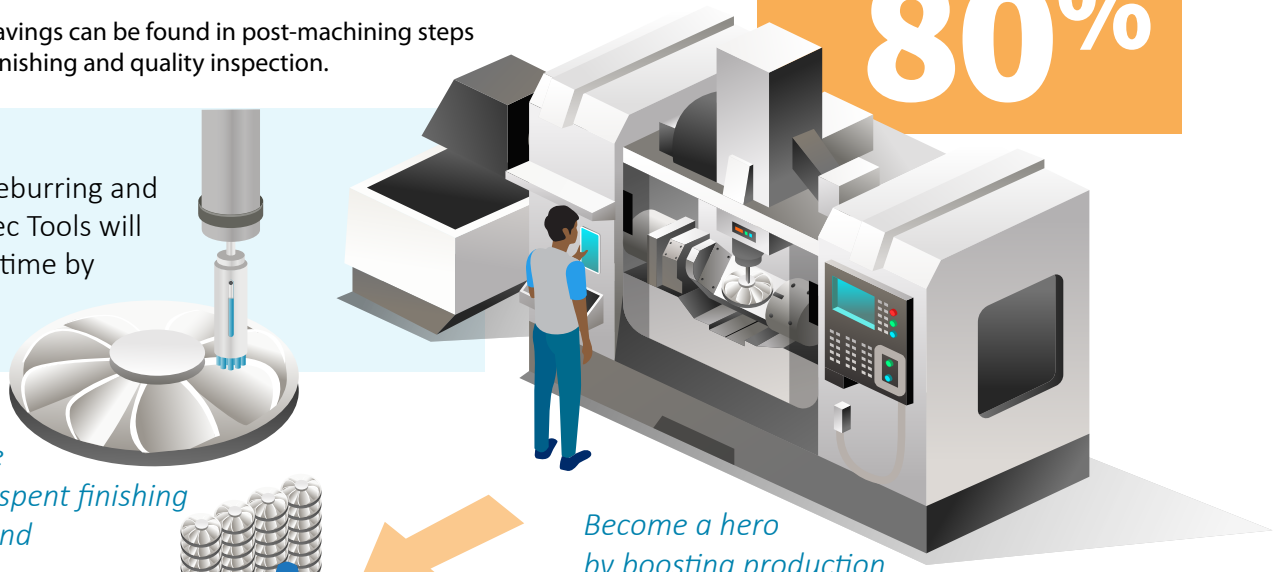
Xebec cost savings initiatives also assist with resource management. This initiative alone created a platform to reduce a group equivalent of six full time employees. Not only does this offer cost savings, but also gives the company an opportunity to redeploy those valuable employees elsewhere - to fill critical roles.

In addition to cost savings, our ceramic fibers are second to none and ensure a consistent and greatly improved finish to their product. We are very proud of our product and our company and would love to help you be a hero in your company as well as we continue to help the resurgence of American manufacturing, by redefining perfection.

Impact of Xebec Tools on Total Production Time

Cut total production time by up to 80%

Often, the largest time savings can be found in post-machining steps like manual deburring, finishing and quality inspection.



Cycle Time

Adding a step for deburring and finishing using Xebec Tools will only increase cycle time by **as little as 1%**

Reduce or eliminate hours or even days spent finishing and polishing by hand

Become a hero by boosting production while saving on labor hours

Manual Deburring

By deburring and finishing on the machine, time spent finishing and polishing by hand can be reduced by **up to 90%**

Quality Inspection

Improved quality and consistency can reduce the time spent on QA by **up to 50%**

Use the money saved on labor to invest in more machines and upskilling the team you have

Pro Tips to Help Control Burr Size and Minimize Formation

These 6 techniques can be used to create smaller and fewer burrs during processing.

1 Replace worn tools

Regular maintenance of your cutting tools will reduce burr formation. Sharp tools with less wear and a clean cutting edge will produce fewer and smaller burrs during processing. Make sure to replace old and worn cutting tools and create a regular schedule for tool maintenance.

2 Change the tool

The style of a tool can affect the generation of burrs depending on the material you're working on. For example, a flat drill may form smaller burrs than a conventional drill.

3 Change the angle

Altering the edge shape on a part can help you minimize burr formation. Acute-angled edges tend to turn out larger burrs, where obtuse-angled edges make it easier to control burrs. For example, you might try corner rounding, edge breaking or chamfering to reduce burr size.

4 Change the rotational direction

Changing the rotational direction can make a big impact on minimizing burr formation. Consider the optimum direction prior to machining your part.

5 Change feed rate or depth of cut

Typically, increasing the feed rate increases the burr size. Using a reduced feed rate when drilling reduces the burr size, creating secondary burrs that are easier to remove. Reducing the depth of cut when milling also reduces burr size. Finding the right balance will reduce overall production time.

6 Change the order of operation

It's easier to remove vertical burrs. Adjust the orientation of the burr by end-milling first and face milling second. Similarly, when deburring parts with cross holes, it will be easier to remove the burrs inside the larger hole.

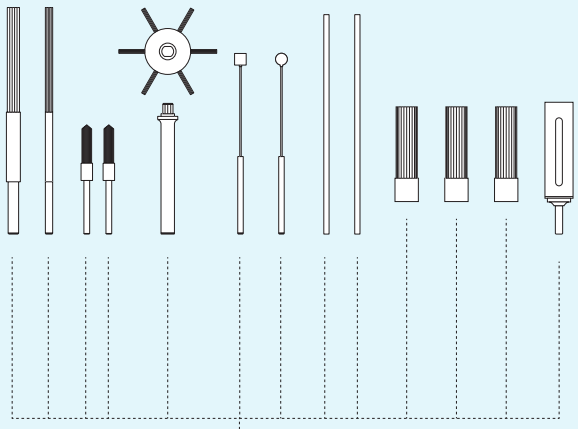
Learn more by visiting our Learning Center online at: **deburringtechnologies.com/blog**

sales@deburringtechnologies.com
1-800-306-5901
fax: (937)-482-4011

XEBEC® | DEBURRING TECHNOLOGIES

Now Available XEBEC™ Kits

Big savings on a selection of popular products. Kits come packed and labeled in a durable hardshell case with protective foam insert.



14-pc Basic Kit
#82001
Included EDP's will vary by availability

Kit includes:

- Wheel Brush (1)
- Wheel Brush Shaft (1)
- 15mm Brush Sleeve (1)
- 15mm Surface Brush (3)
- Stone Flexible Shaft (2)
- Meister Finish Stick (2)
- End-Type Brush (2)
- Crosshole Brush (2)

Case Dimensions: LENGTH: 12 in x WIDTH: 8 in x HEIGHT: 3 in

19-pc Premium Kit
#82000
Included EDP's will vary by availability

Kit includes all items from Basic Kit shown above PLUS:

- Floating Holder (1)
- Floating Holder Bushing (2)

TEST TOOL POLICY Due to the unique design of Xebec products, we have achieved optimal success when Deburring Technologies technical personnel assist in the selection of proper tool and operating parameters. Provided our representative has reviewed an application and provided processing recommendations, we are pleased to provide reasonable quantities of test product with a "Guaranteed Trial" purchase order. Such product will be invoiced and is payable per our normal NET – 30 DAY terms. Should the product not perform as promised, simply contact us for a return authorization within forty five (45) days of purchase with a written report of how the product failed to meet the promised performance. Once we have received and inspected the product, we will issue full credit for the returned product. All returns for other than guaranteed trial performance must be received within thirty (30) days from date of purchase and be received in new condition in the original packaging. Once we have received and inspected the product, we will issue full credit for the returned product.

SAFETY WARNING Cutting fiber brushes and stones are cutting tools and are often rotated at high speeds with a power tool or in a machine tool. They should never be operated at higher than the maximum speeds listed. When using these tools, safety glasses and gloves should be worn. Breathing the dust created by using these products for prolonged periods of time should be avoided.

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