

XEBEC Cutting Fiber processing condition

For $\Phi 6$ Brush [A11-CB06M(Red), A21-CB06M(White), A31-CB06M(Blue)]

Deburring performance (grinding force) of XEBEC Cutting Fiber is adjustable by changing processing parameters.

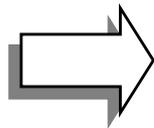
※Deburring performance (Grinding force) varies depending on brush colors : A31(blue)>21(white)>A11(red)>A13(pink). (Ref: Brush Selection Image down right)

Please follow the initial condition below for the first trial.

【Initial condition】

Revolutions	8000min ⁻¹
Cutting depth	See below
Feed speed	2400mm/min
Brush projection	5mm
With coolant	

Please confirm the finishing of the edge (deburring result)



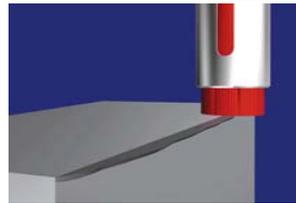
【Retry condition and procedure】

Remained burr	Retry by increasing the revolutions up to 10000min⁻¹	
	Still burrs remained with the new parameter above, please find the most appropriate parameters by following procedures. ※Procedures are different depending on vertical/horizontal(left images A,B) burrs	
	A: Vertical burr	•Do not change revolutions(already MAX value) but increase cutting depth to 1mm. •Then slower feed speed.(ex.400mm/min at a time)
	B: Horizontal burr	Do not change revolutions and cutting depth(both already MAX value) but slower feed speed. (ex.400mm/min at a time)
Edge rounded	Retry by decreasing the revolutions down to 5000min⁻¹	
	Still edge rounded with the new parameter above, please find the most appropriate parameters by following procedures. ※Same procedures for both vertical/horizontal(Left images A,B)	
	•Reduce revolutions.(This brush can deburr even at low revolutions) •Then reduce cutting depth •Still edge rounded, then increase Feed speed. (ex. 400mm/min at a time)	

A: For vertical burrs
Cutting depth : 0.5mm



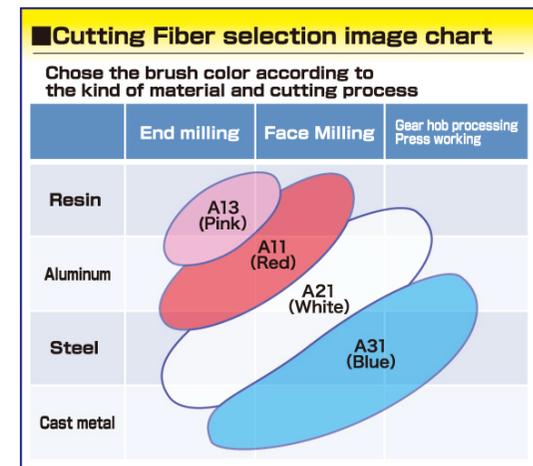
B: For horizontal burrs
Cutting depth : 1.0mm



■ Regarding feed speed

Feed speed can be adjusted depending on the required cycle time.
Feed speed affects the surface finishing (surface smoothness).
Less feed speed, smoother surface can be attained.

To increase grinding force	①Increase Revolutions
	②Increase Cutting depth
	③Reduce Feed speed
To decrease grinding force	①Reduce Revolutions
	②Reduce Cutting depth
	③Increase Feed speed



If you have any deburring or surface finishing problems, please feel free to contact us.
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