



Successful Applications

MAJOR MARKETS SERVED

Firearms

EXAMPLE: SURFACE FINISHING - MILL

Trigger Assembly

Deburring of edge radiuses and finishing of edges,
Fine surface finishing of detailed parts

Material	Stainless Steel
Process Details	Detailed Surface Finishing

XEBEC product used: A11-CB06M

Rotation Speed: 8100 RPM, Depth of Cut: 0.015 in, Feed: 40 IPM



EXAMPLE: BACK BURR CUTTER & PATH OPERATION - MILL

Lower Receiver

Deburring and chamfering of multiple holes
In a single pass

Material	Aluminum
Process Details	Hole Deburring & Back Burr Operation

XEBEC product used: XC-28-A

Rotation Speed: 12500 RPM, Feed: 45 IPM



EXAMPLE: DETAILED FINISHING - HAND TOOL

Handgun Frame

Fine surface finishing and polishing of milled surfaces;
Deburring and polishing of edges

Material	Stainless Steel
Process Details	Edge Deburring & Detailed Surface Finishing

XEBEC product used: A31-EB06M

Rotation Speed: 8000 RPM, Handheld Rotary Tool



FOR MATERIALS
Up to
65 Rc

**Aluminum
Alloy Steels
Titanium**

FINE FINISHING
Up to
3.937 Ra

**Improve Surface
Finish and Reduce
Cycle Time**

Xebec Brush™ Surface

- Simultaneously deburr and finish edges
- Continuous cutting edge for consistent grinding



Brush				Aggressiveness				Required sleeve for brush EDP (see below)	Max RPM
				Less	<	<	<		
Diameter		Length		Pink	Red	White	Blue		
mm	inches	mm	inches						
6	0.236	30	1.181	A13-CB06M 30015	A11-CB06M 30006	A21-CB06M 30012	A32-CB06M 30045	40006	10,000
15	0.591	50	1.969	A13-CB15M 30013	A11-CB15M 30005	A21-CB15M 30011	A32-CB15M 30044	40005 or 40007*	6,000
25	0.984	75	2.953		A11-CB25M 30004	A21-CB25M 30010	A32-CB25M 30043	40004	5,000
40	1.575	75	2.953		A11-CB40M 30003	A21-CB40M 30009	A32-CB40M 30042	40003	3,000

*15mm Sleeve available in Aluminum or Plastic

Xebec Brush™ End Type

- Xebec Brush adapts to irregular/ curved parts
- Tools are suitable for parts with narrow features and corners that cannot be reached with conventional tools



Brush Dimensions				Shank Dimensions				Overall Length		Aggressiveness				Max RPM		
Diameter		Length		Diameter		Length				Less	<	<	<		<	>
mm	in	mm	in	mm	in	mm	in	mm	in	Pink	Red	White	Blue			
1	0.04	15	0.59	3	0.12	37	1.46	52	2.05	A13-EB01S 30050	A11-EB01S 30054	-	-			
1.5	0.06									A13-EB015S 30051	A11-EB015S 30055	-	-			
2	0.08									A13-EB02S 30052	A11-EB02S 30056	-	-			
2.5	0.10									A13-EB025S 30053	A11-EB025S 30057	-	-			
3	0.12	30	1.18	3	0.12	37	1.46	67	2.63	A13-EB03M 30014	-	-	-			
5	0.19	20	0.79	3	0.12	28	1.10	58	2.28	-	A11-EB06M 60001	A21-EB06M 60002	A31-EB06M 60006			

*60001, 60002, 60006 Tip has 100 degree included angle

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