

<b>Part</b>	Rocker Arm
<b>Material</b>	SCr420
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A11-CB40M
<b>Parameters</b>	Rotation Speed: 3000min <sup>-1</sup> Depth of Cut: 0.020in Feed: 80 IPM



<b>Part</b>	Exhaust Manifold
<b>Material</b>	AC4C
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A21-CB60M
<b>Parameters</b>	Rotation Speed: 1000min <sup>-1</sup> Depth of Cut: 0.020in Feed: 120 IPM

<b>Part</b>	Injector Body
<b>Material</b>	SCM
<b>Details</b>	Deburring of grinded surface
<b>Tool Used</b>	Xebec Brush™ Surface A11-CB15M
<b>Parameters</b>	Rotation Speed: 1800min <sup>-1</sup> Depth of Cut: 0.017in Feed: —



<b>Part</b>	Cam Cap
<b>Material</b>	ADC12
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A11-CB40M
<b>Parameters</b>	Rotation Speed: 1941min <sup>-1</sup> Depth of Cut: 0.020in Feed: 147 IPM



<b>Part</b>	Connecting Rod
<b>Material</b>	S45C
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A32-CB60M
<b>Parameters</b>	Rotation Speed: 1300min <sup>-1</sup> Depth of Cut: 0.016in Feed: 54 IPM

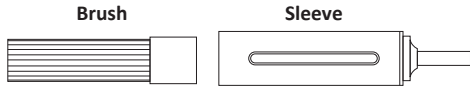
<b>Part</b>	Crank Shaft
<b>Material</b>	S48C
<b>Details</b>	Crosshole deburring
<b>Tool Used</b>	Xebec Stone™ Flexible Shaft CH-PM-5R-C01
<b>Parameters</b>	Rotation Speed: 1350min <sup>-1</sup> Depth of Cut: 0.020in Feed: —

<b>Part</b>	Housing
<b>Material</b>	Sintered metal
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A11-CB40M
<b>Parameters</b>	Rotation Speed: 500min <sup>-1</sup> Depth of Cut: 0.020in Feed: 80 IPM

<b>Part</b>	Cylinder Head
<b>Material</b>	ADC12
<b>Details</b>	Deburring of milled surface
<b>Tool Used</b>	Xebec Brush™ Surface A11-CB100M
<b>Parameters</b>	Rotation Speed: 900min <sup>-1</sup> Depth of Cut: 0.030in Feed: 160 IPM

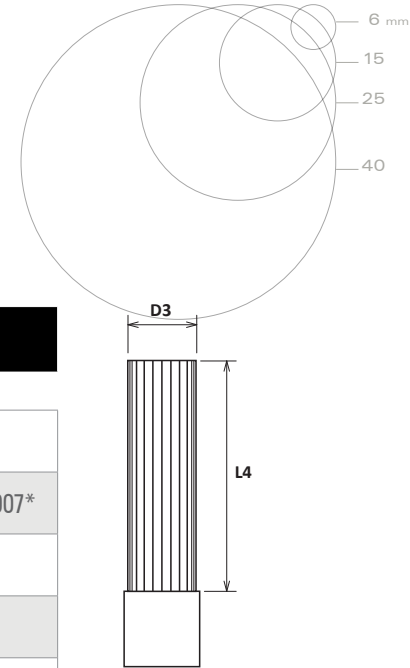
## XEPEC BRUSH™ SURFACE Surface Brush

Ideal for simultaneous deburring and edge finishing, cutter mark removal and surface polishing



**Brush** Requires Brush Sleeve to Operate

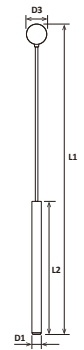
Brush Size (D3)		Aggressiveness				L4 Brush Length		Max RPM	Required Sleeve
MM	INCHES	Less ←			→ More	MM	INCHES		
		Pink	Red	White	Blue				
6mm	0.236	<b>30015</b> A13-CB06M	<b>30006</b> A11-CB06M	<b>30012</b> A21-CB06M	<b>30045</b> A32-CB06M	30	1.181	10,000	40006
15mm	0.591	<b>30013</b> A13-CB15M	<b>30005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



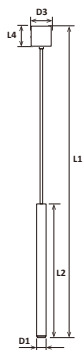
## XEPEC STONE™ Flexible Shaft Stone

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

Ball Size (D3)	L1 Overall Length		D1 Shank Diameter		L2 Shank Length		Aggressiveness			Max RPM	
	MM	INCHES	MM	INCHES	MM	INCHES	Less ←		→ More		
							Blue - #800	Orange - #400	Gray - #220		
3mm	0.118	71.5	2.815	3	0.118	30	1.181	<b>10001</b> CH-PB-3B	<b>10008</b> CH-PO-3B	<b>10015</b> CH-PM-3B	15,000
4mm	0.157	151.5	5.965	3	0.118	30	1.181	<b>10002</b> CH-PB-4B	<b>10009</b> CH-PO-4B	<b>10016</b> CH-PM-4B	13,000
5mm	0.197	72	2.835	3	0.118	30	1.181	<b>10003</b> CH-PB-5B	<b>10010</b> CH-PO-5B	<b>10017</b> CH-PM-5B	12,000
6mm	0.236	152	5.984	2.3	0.091	148	5.827	<b>10004</b> CH-PB-6B	<b>10011</b> CH-PO-6B	<b>10018</b> CH-PM-6B	10,000



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



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