

Type BY: Inner Diameter Upper/Lower Edges

This sheet is used to confirm the dimensions of deburring areas and to confirm whether or not point group data (Name : XEBEC Path for Back Burr Cutter) can be generated. If a path can be generated then the path order code and optimal cutter diameter will be notified to a customer.

### 1. Deburring Location

This is sheet is for edges on an orthogonal crosshole, being processed with a 3-axis simultaneous combined lathe (XZY-axis). Make sure that the sheet type matches burr locations.

[Restrictions for generating a path]

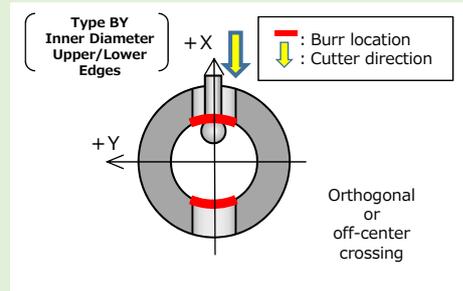
**Orthogonal Crosshole** Supports secondary hole diameter of  $\Phi 1\text{mm}$  or more  
The primary hole diameter to the secondary hole diameter can be up to 1:1

**Off-center Crosshole** Supports secondary hole diameter of  $\Phi 1\text{mm}$  or more  
Supports an amount of shift that does not cause the primary hole to be broken.

- \* It is not applicable if either the primary or secondary hole is a female screw or the material surface.
- \* There is a possibility that a path data cannot be generated for certain hole combinations.

[Caution]

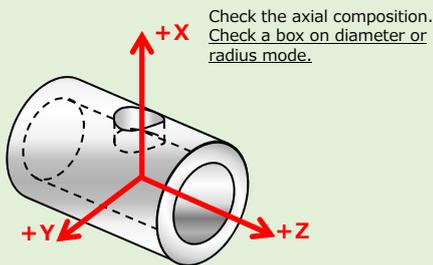
Make sure to enter accurate values. The XEBEC Path for Back Burr Cutter is generated based on these values and if erroneous values are entered, an incorrect path will be generated which will cause a workpiece, cutter or machine to break. XEBEC Technology is not responsible for any damage caused in such a case.



▼ Enter the dimensions in the boxes below.

- \* Fill in all spaces. For "0", enter "0".
- \* Enter up to the 3rd decimal.

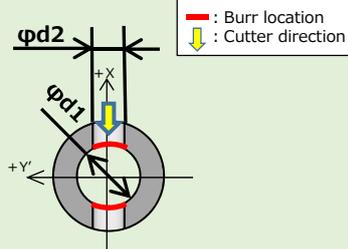
### 2. Axial Composition



Point group data is generated at XZY-axis.

> Controlling Mode  Diameter mode  
\* Check the box  Radius mode

### 3. Hole Diameters

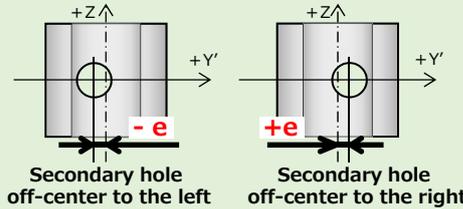


Enter an aimed value.

> Primary hole ( $\phi d1$ )  .  mm  
> Secondary hole ( $\phi d2$ )  .  mm

### 4. Secondary Hole Position

Check the position of the primary hole at YZ-planar. Enter the position of the secondary hole in regards to the primary hole. Be careful of the +/- direction.



If the secondary hole is:  
on-center to the primary hole:  $e=0\text{mm}$   
off-center to the left of the primary hole:  $e=-\square\text{mm}$   
off-center to the right of the primary hole:  $e=+\square\text{mm}$

> Amount of shift e  +  -  .  mm  
\* Check the box on + or -

### Customer Information and Confirmation of Path Use Conditions

Please check the boxes. An order cannot be placed unless the following boxes are filled out.

- I agree to not use any tools besides the XEBEC Back Burr Cutter when using the XEBEC Path.
- I agree that XEBEC Technology has granted the authority to use the XEBEC Path for Back Burr Cutter and that I will not hand over or distribute this data outside the company.

Company name \_\_\_\_\_ Dept. \_\_\_\_\_ Name \_\_\_\_\_

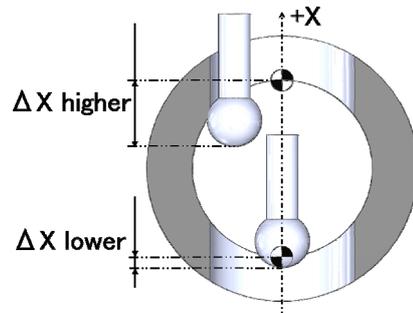
Country: \_\_\_\_\_ Phone \_\_\_\_\_ E-mail \_\_\_\_\_ (FAX) \_\_\_\_\_

▼ Only for XEBEC Technology. ▼

### Order Code Contact Sheet

XEBEC Technology will inform the order code for the XEBEC Path and tool diameter of the XEBEC Back Burr Cutter based on the workpiece dimensions filled in the Order Code Request Sheet. Please order with the following order code after confirming the path use conditions and tool interference.

XEBEC Path Order Code No.	
$\Delta X_{\text{Upper}}$ (mm)	
$\Delta X_{\text{Lower}}$ (mm)	
XEBEC Back Burr Cutter Diameter	Product Code
$\phi$	
Reason for disapproval (*Only if path generation is disapproved)	



[Caution]

- The tool interference in vertical direction was not examined. Check the Cutter length and  $\Delta Z$  (maximum amount of descent), and make sure to confirm there is no tool interference from the processing environment (jig, holder, workpiece, etc.) Then select the appropriate Cutter from the catalog.
- Only the optimal tool diameter was selected according to the workpiece dimensions filled in the Order Code Request Sheet.
- $\Delta Z$  (maximum amount of descent) is the furthest the tool will fall from the starting point until the deburring operation is complete.

No. of sheets: /

- \* Enter the number of sheets if more than one sheet will be submitted. (e.g.) If three sheets will be submitted, mark the first as "1/3", the second "2/3" and the third "3/3".

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This sheet is used to confirm the dimensions of deburring areas and to confirm whether or not point group data (Name : XEBEC Path for Back Burr Cutter) can be generated. If a path can be generated then the path order code and optimal cutter diameter will be notified to a customer.

### 1. Deburring Location

This is sheet is for edges on an orthogonal crosshole, being processed with a 3-axis simultaneous combined lathe (XZY-axis). Make sure that the sheet type matches burr locations.

#### [Restrictions for generating a path]

**Orthogonal Crosshole** Supports secondary hole diameter of  $\Phi 1\text{mm}$  or more  
The primary hole diameter to the secondary hole diameter can be up to 1:1

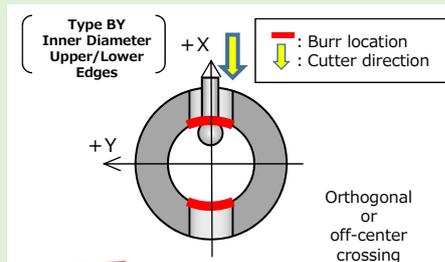
**Off-center Crosshole** Supports secondary hole diameter of  $\Phi 1\text{mm}$  or more  
Supports an amount of shift that does not cause the primary hole to be broken.

\* It is not applicable if either the primary hole diameter is 0 or the secondary hole diameter is 0.  
\* There is a possibility that a path cannot be generated.

#### [Caution]

Make sure to enter accurate values. If erroneous values are entered, an incorrect path will be generated, causing a break. XEBEC Technology is not responsible for such damage.

Double check the deburring location and the sheet type.  
There are 4 kinds of sheet (AY, BY, AC and BC)

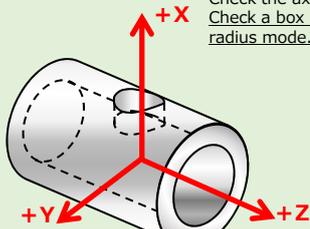


### ▼ Enter the dimensions in the boxes below.

\*Fill in all spaces. For "0", enter "0".  
\*Enter up to the 3rd decimal.

### 2. Axial Composition

Check the axial composition. Check a box on diameter or radius mode.

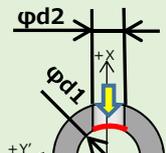


Check 1 box

> Controlling Mode  Diameter mode  
\*Check the box  Radius mode

### 3. Hole Diameters

Check the hole diameters. Enter up to the 3rd decimal. Enter an aimed value.



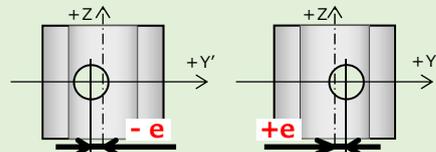
Enter up to the 3rd decimal

> Primary hole ( $\phi d1$ )  mm

> Secondary hole ( $\phi d2$ )  mm

### 4. Secondary Hole Position

Check the position of the primary hole at YZ-planar. Enter the position of the secondary hole in regards to the primary hole. Be careful of the +/- direction.



Secondary hole off-center to the left

Secondary hole off-center to the right

Check + or -

Enter "0" for "0"

> Amount of shift e  +  mm  
\*Check a box on + or -  -  mm

### Customer Information and Path Use Conditions

Check the boxes

Please check the boxes. An order cannot be placed unless the following boxes are filled out.

- I agree to not use any tools besides the XEBEC Back Burr Cutter when using the XEBEC Path.
- I agree that XEBEC Technology has granted the authority to use the XEBEC Path for Back Burr Cutter and that I will not hand over or distribute this data outside the company.

Company name  Dept.  Name

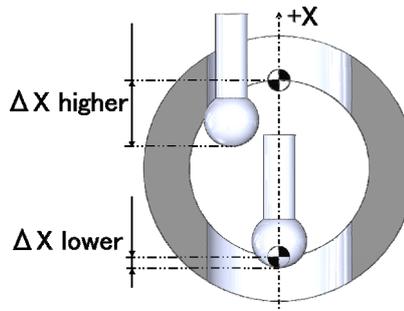
Country:  Phone  E-mail  (FAX)

▼ Only for XEBEC Technology. ▼

### Order Code Contact Sheet

XEBEC Technology will inform the order code for the XEBEC Path and tool diameter of the XEBEC Back Burr Cutter based on the workpiece dimensions filled in the Order Code Request Sheet. Please order with the following order code after confirming the path use conditions and tool interference.

XEBEC Path Order Code No.	PGC007-01-58
$\Delta X_{\text{Upper}}$ (mm)	
$\Delta X_{\text{Lower}}$ (mm)	
XEBEC Back Burr Cutter Diameter	Product Code
$\phi$ 5.8	XC-58-B
Reason for disapproval (*Only if path generation is disapproved)	



#### [Caution]

- The tool interference in vertical direction is not checked. Please confirm there is no tool interference from the processing environment.
- Only the optimal tool diameter was used.
- $\Delta Z$  (maximum amount of descent) is the maximum amount of descent.

If submitting multiple sheets, enter the sheet number. e.g. 1/3, 2/3, 3/3.

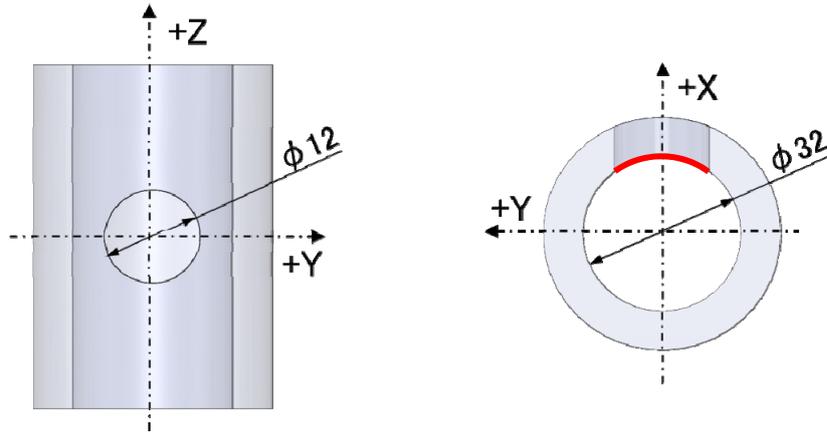
No. of sheets:

\*Enter the number of sheets if more than one sheet will be submitted. (e.g.) If three sheets will be submitted, mark the first as "1/3", the second "2/3" and the third "3/3".

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# Description Example: Type BY

## Example 1



### 2. Axial Composition

Check the axial composition.  
Check a box on diameter or radius mode.

Point group data is generated at XZY-axis.

> Controlling Mode  Diameter mode  
\*Check the box  Radius mode

### 3. Hole Diameters

— : Burr location  
↓ : Cutter direction

Enter an aimed value.

> Primary hole ( $\phi d1$ )   mm

> Secondary hole ( $\phi d2$ )   mm

### 4. Secondary Hole Position

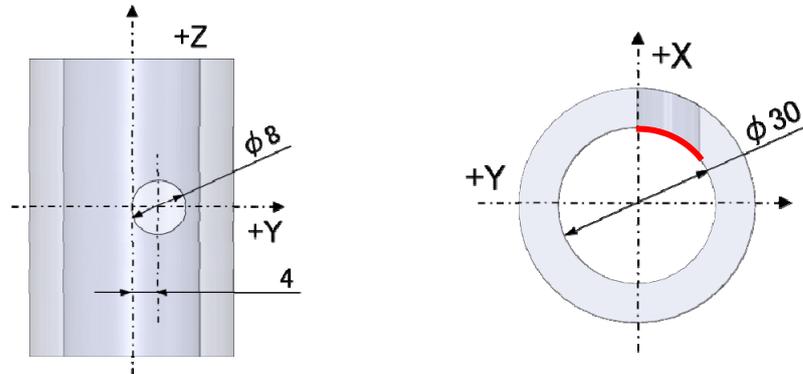
Check the position of the primary hole at YZ-planar.  
Enter the position of the secondary hole in regards to the primary hole. Be careful of the +/- direction.

Secondary hole off-center to the left      Secondary hole off-center to the right

If the secondary hole is:  
on-center to the primary hole:  $e=0\text{mm}$   
off-center to the left of the primary hole:  $e=-\square\text{mm}$   
off-center to the right of the primary hole:  $e=+\square\text{mm}$

> Amount of shift  $e$   +   mm  
\*Check the box on + or -  -

## Example 2



### 2. Axial Composition

Check the axial composition.  
Check a box on diameter or radius mode.

Point group data is generated at XZY-axis.

> Controlling Mode  Diameter mode  
\*Check the box  Radius mode

### 3. Hole Diameters

— : Burr location  
↓ : Cutter direction

Enter an aimed value.

> Primary hole ( $\phi d1$ )   mm

> Secondary hole ( $\phi d2$ )   mm

### 4. Secondary Hole Position

Check the position of the primary hole at YZ-planar.  
Enter the position of the secondary hole in regards to the primary hole. Be careful of the +/- direction.

Secondary hole off-center to the left      Secondary hole off-center to the right

If the secondary hole is:  
on-center to the primary hole:  $e=0\text{mm}$   
off-center to the left of the primary hole:  $e=-\square\text{mm}$   
off-center to the right of the primary hole:  $e=+\square\text{mm}$

> Amount of shift  $e$   +   mm  
\*Check the box on + or -  -