

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 (XZC-axis).** Make sure that the sheet type matches burr locations. **Polar coordinate interpolation** required for the type AC.

[Restrictions for generating a path]

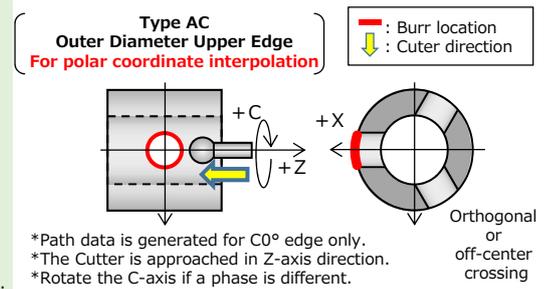
Orthogonal Crosshole Supports secondary hole diameter of $\Phi 1\text{mm}$ or more
The primary hole diameter to the secondary hole diameter can be up to 1:1

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. 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.

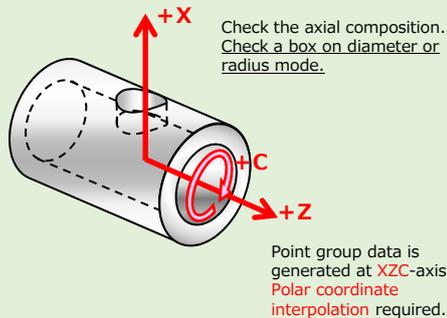


- *Path data is generated for $C0^\circ$ edge only.
- *The Cutter is approached in Z-axis direction.
- *Rotate the C-axis if a phase is different.

▼ Enter the dimensions in the boxes below.

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

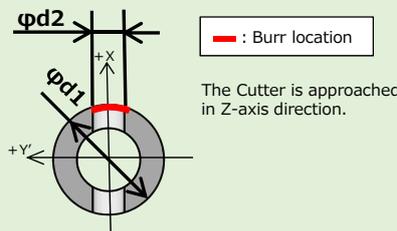
2. Axial Composition



Point group data is generated at XZC-axis. **Polar coordinate interpolation** required.

> **Controlling Mode** Diameter mode
* Check a box Radius mode

3. Hole Diameters



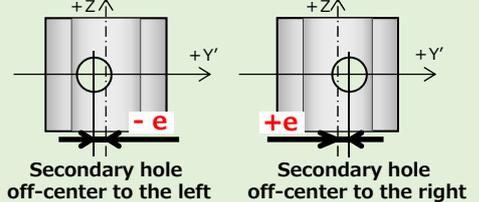
Enter an aimed value.

> 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 a box on + or - - mm

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 _____

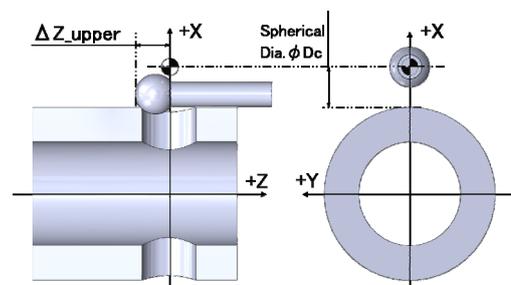
Country: _____ Phone _____ E-mail _____ (FAX) _____

▼ 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.	
ΔZ_{Upper} (mm)	
XEBEC Back Burr Cutter Diameter	Product Code
ϕ	
Reason for disapproval (*Only if path generation is disapproved)	



*Due to a tool direction, there is a possibility that fine secondary burrs generated.

[Caution]

- The tool interference in vertical direction was not examined. Check the Cutter length and ΔZ (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.
- ΔZ (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".

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 (XZC-axis). Make sure that the sheet type matches burr locations. Polar coordinate interpolation required for the type AC.

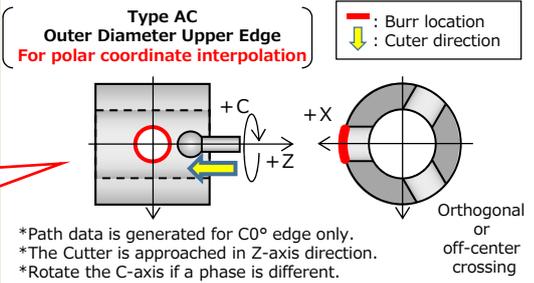
[Restrictions for generating a path]

- Orthogonal Crosshole** Support The p
- Off-center Crosshole** Support Support
- * It is not applicable.
- * There is a possibility

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

[Caution]

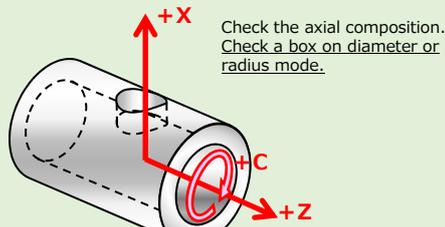
Make sure to enter accurate values. The XEBEC Path for Back Burr Cutter is generated based on these values. If erroneous values are entered, an incorrect path will be generated which will cause a workpiece, cutter or machine to break. XEBEC Technology is not responsible for any damage caused in such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

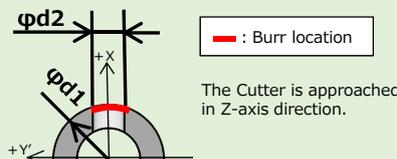


Check 1 box

Point group data is generated at XZC-axis. Polar coordinate interpolation required.

- > Controlling Mode Diameter mode Radius mode
- * Check a box

3. Hole Diameters



Enter up to the 3rd decimal

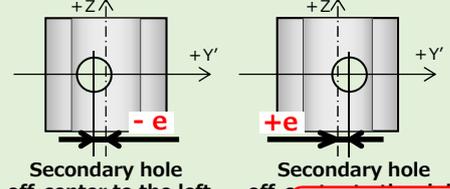
Enter an aimed value.

> Primary hole (φd1) mm

> Secondary hole (φd2) 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.



Check + or -

Enter "0" for "0"

If the on-d... off-d... off-center to the right... primary hole... mm

> Amount of shift e + - mm

* Check a box on + or -

Customer Information of 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 Company Name Dept. Dept Name Name

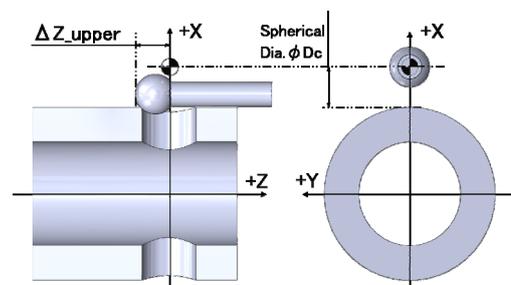
Country: Country Name Phone TEL E-mail E-mail (FAX)

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
ΔZ_Upper (mm)	
XEBEC Back Burr Cutter Diameter	Product Code
φ 5.8	XC-58-B
Reason for disapproval (*Only if path generation is disapproved)	



*Due to a tool direction, there is a possibility that fine secondary burrs generated.

[Caution]

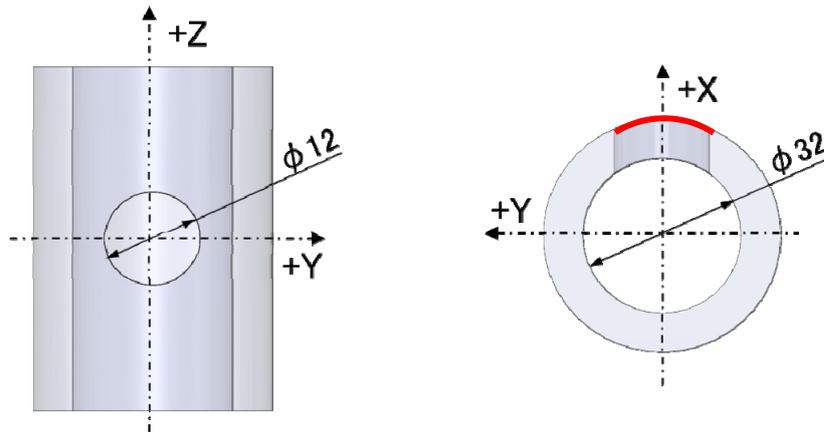
- The tool interference in vertical direction from the processing end.
 - Only the optimal tool diameter was used.
 - ΔZ (maximum amount of descent) is the starting point until the deburring operation is complete.
- If submitting multiple sheets, enter the sheet number. e.g. 1/3, 2/3, 3/3. and make sure to confirm there is no tool

No. of sheets: 1 / 3

*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".

Description Example: Type AC

Example 1



2. Axial Composition

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

Point group data is generated at XZC-axis. Polar coordinate interpolation required.

> Controlling Mode Diameter mode Radius mode
*Check a box

3. Hole Diameters

— : Burr location

The Cutter is approached in Z-axis direction.

Enter an aimed value.

> Primary hole (φd1) mm

> Secondary hole (φd2) mm

4. Secondary Hole Position

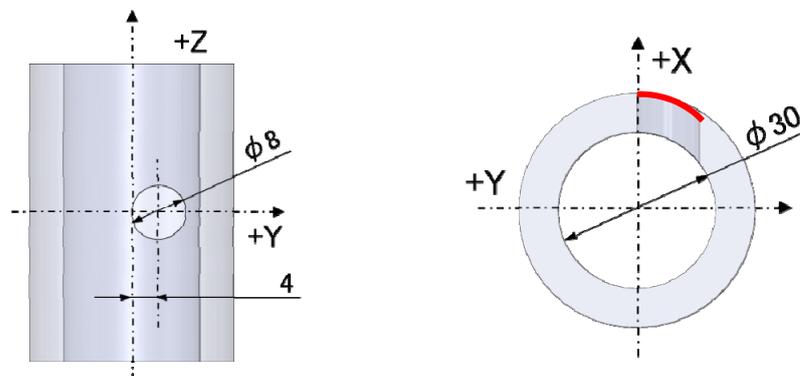
Check the position of the primary hole at YZ-planar. Enter the position of the secondary hole in regards to the primary hole. Be careful of the +/- direction.

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=0mm
off-center to the left of the primary hole: e=-□mm
off-center to the right of the primary hole: e=+□mm

> Amount of shift e + - mm
*Check a 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 XZC-axis. Polar coordinate interpolation required.

> Controlling Mode Diameter mode Radius mode
*Check a box

3. Hole Diameters

— : Burr location

The Cutter is approached in Z-axis direction.

Enter an aimed value.

> Primary hole (φd1) mm

> Secondary hole (φd2) 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=0mm
off-center to the left of the primary hole: e=-□mm
off-center to the right of the primary hole: e=+□mm

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