

July  
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# New Lineup Added XEBEC Brush Surface Extra-Large



**New solution for deburring and polishing a large workpiece !!**



XEBEC Brush for Surface now comes in 3 additional sizes

**φ125 · φ165 · φ200 (mm)**

XEBEC Brush Surface Extra-Large enables to

- ★ **reduce the number of passes!**
- ★ **process without lap marks!**

Suitable for deburring and polishing a workpiece with a **width of 100mm or greater**, such as cylinder heads, cylinder blocks, and machinery beds...etc.

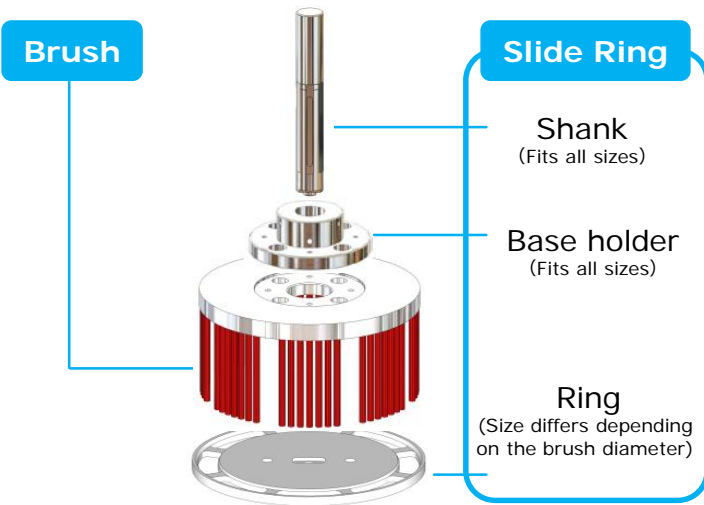
## Lineup

All sizes are available in 3 colors; red, white, and blue.

A brush and a slide ring are sold separately. Assemble the brush and slide ring before use.

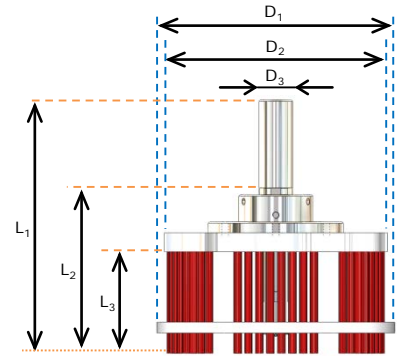
		φ125mm	φ165mm	φ200mm
Brush Color	Red	A11-CB125M	A11-CB165M	A11-CB200M
	White	A21-CB125M	A21-CB165M	A21-CB200M
	Blue	A31-CB125M	A31-CB165M	A31-CB200M
Slide Ring	SR125M	SR165M	SR200M	

# Product Structure



\*A slide ring is made up of a shank, base holder and ring.  
 Assemble the parts prior to use. Each part is available separately.  
 \*Please see the instruction manual or website for assembling method.

# Product Dimensions



Brush Diameter (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)	L <sub>3</sub> (mm)	D <sub>1</sub> (mm)	D <sub>2</sub> (mm)	D <sub>3</sub> (mm)	Weight (g)
Φ125	187	122	75	135	125	25	1920
Φ165				176	165		2320
Φ200				211	200		2750

# Initial Parameters

Brush Diameter (mm)	Depth of Cut (mm)					Rotation Speed (min <sup>-1</sup> )		Feed Rate (mm/min)			Brush Projection (mm)
	Vertical Burr	Horizontal Burr	Cutter mark removal	Polishing	Maximum	Recommended	Maximum	Burr Root Thickness (mm)		Cutter mark removal	Recommended
								0.05	0.1		
φ125	0.5	1.0	0.5~1.0	0.3~0.5	1.5	800	1000	4000	2500	300	15
φ165	0.5	1.0	0.5~1.0	0.3~0.5	1.5	600	750	4000	2500	300	15
φ200	0.5	1.0	0.5~1.0	0.3~0.5	1.5	480	600	4000	2500	300	15

# How to change parameters

## Deburring

### ○If burrs are not completely removed

- Increase the rotation speed S in 25% increments. Be aware of the maximum rotation speed.
- Decrease the feed rate F in 10-20% increments.

### ○Burr is removed

#### \*The edge is too rounded or

#### \*If you want to extend the tool life

- Decrease the rotation speed S in 25% increments.
- Increase the feed rate F in 10-20% increments.

#### \*When uneven wear occurs on the brush

- Double the feed rate F and process the workpiece using the round pass.
- Rotate the brush in a counterclockwise direction for the return pass.

## Cutter mark removal and Polishing

### ○If cutter marks are not removed

- Increase the number of passes.
- Increase the rotation speed S in 25% increments. Be aware of the maximum rotation speed.

### ○Cutter marks are removed

#### \*The edge is too rounded or

#### \*If you want to extend the tool life

- Decrease the rotation speed S in 25% increments.
- Increase the feed rate F in 20-40% increments.

#### \*When uneven wear occurs on the brush

- Double the feed rate F and process the workpiece using the round pass.
- Rotate the brush in a counterclockwise direction for the return pass.

Please feel free to contact us for the details.

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