

ECD electro chemical deburring

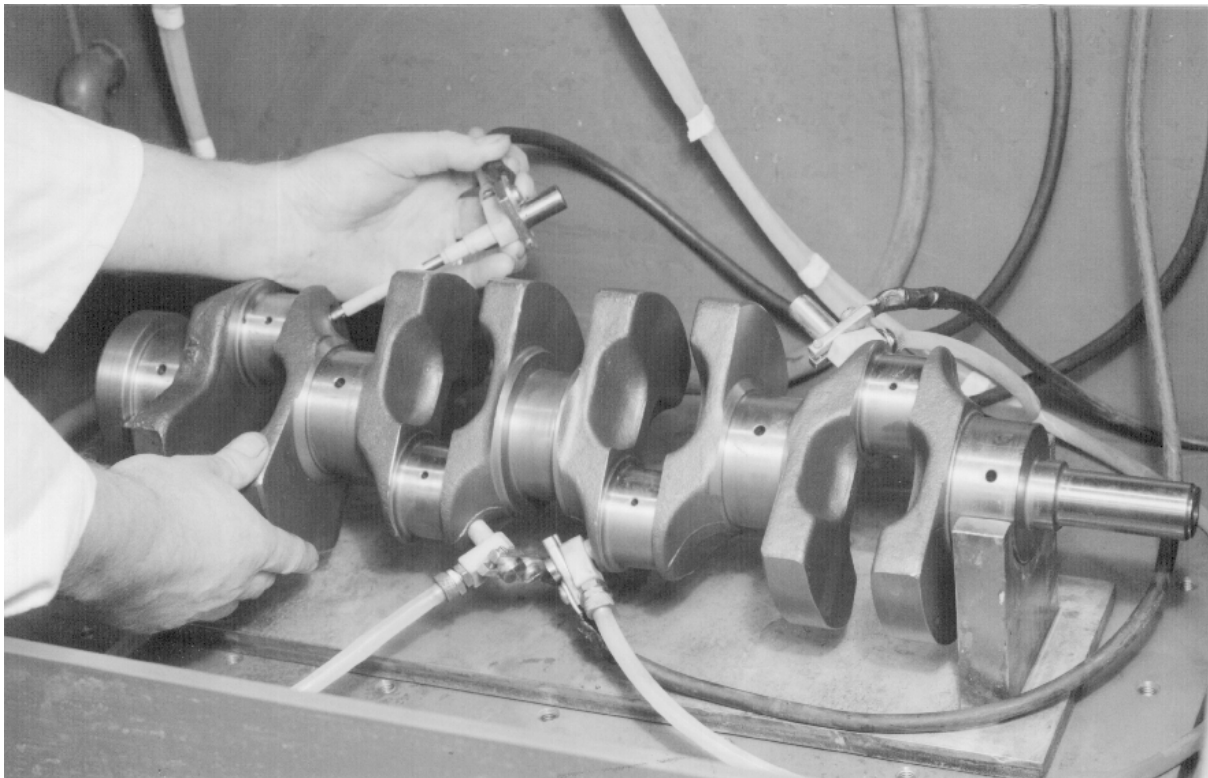
application bulletin

Engineers over the years have been confronted by the problem of the efficient removal of burrs and sharp edges from various facets on components, and with the rapid increase in automatic machining cycles, some components are absorbing more time on burr removal than the machining content. Deburring has been described as the corrective treatment of components having had burrs created by other machining processes.

Today, the majority of deburring is still performed by means of hand tools, although the introduction of machine methods such as rotating and vibratory barrels are bringing consistency to the product.

Electro Chemical Deburring is one of the most efficient methods being utilized today, especially on internal features where hand methods are extremely difficult and arduous and barrelling techniques do not work.

Electro Chemical Deburring uses high pressure salt solution and direct current power to electrochemically dissolve burrs next to a shaped tool. It is ideally suited to both batch and flow production, where set time cycles are essential. The typical time cycles for deburring are between 5 seconds and 30 seconds.



The picture shows the tooling for electro chemically deburring the intersecting drilled oil ways in the crankshaft to give a smooth burr-free finish in all holes in 30 seconds machining time. The crankshaft manufacturer is using the sub-contract facility at **ANOTRONIC** whilst awaiting the installation of an **ANOTRONIC** electro chemical deburring machine at their own premises.

ANOTRONIC LTD.

Unit 3, Hollingdon Depot, Stewkley Road, Soulbury,
Nr. Leighton Buzzard, Beds., LU7 0DF. England.

Telephone +44 (01525) 270261 Fax +44 (01525) 270235

E-Mail sales@anotronic.com Internet <http://www.anotronic.com>

