

Deburring

Reference sheet

engraflexx EC



Detail view: flange deburred with *engraflexx*



Workpiece

Description: Flap housing
Material: Stainless steel casting (1.4308)
Workpiece hardness: -

Machine data

Machine type: Machining center
Brand/make: STAMA MC326 / Twin

Deburring data

Feed speed: 1500 mm/min
Spindle revolution: 4000 r.p.m.
Contact pressure – cutter: 3
Spindle deflection: 2 mm
Milling cutter – type: SK-6/10-60
Flute width: 0.5 mm
Deburring duration: approx. 5 sec.

Production volume per year	5000	
Deburring by hand		
Deburring time per part (min)	1	
hourly rate (EUR/h)	90	
Non-productive time (e.g. parts handling) before and after deburring in (min)	0.15	
Deburring cost per part (EUR)	1.73	
Deburring with Engraflexx		
Investment cost tool (EUR)	4500	
Deburring time per part (min)	0.05	
hourly rate (EUR/h)	130	
Non-productive time (e.g. parts handling) before and after deburring in (min)	0.05	
Deburring cost per part (EUR)	0.22	
Payback calculation		
Cost saving per piece (without consider investment cost), EUR	1.51	-87.44%
Cost saving per year (without consider investment cost), EUR	7541.67	
Payback in Jahre *	0.60	
* Assumption: Only this workpiece is produced and the tool is not used for other workpieces. Otherwise, the payback period is even shorter.		