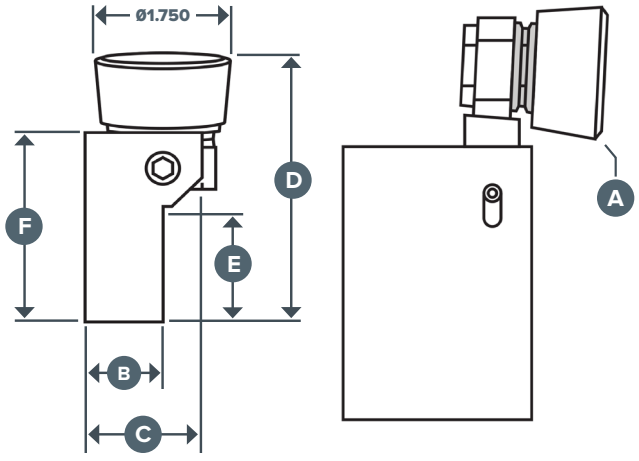
OD CARBIDE ROLL BURNISHING TOOLS

CRB

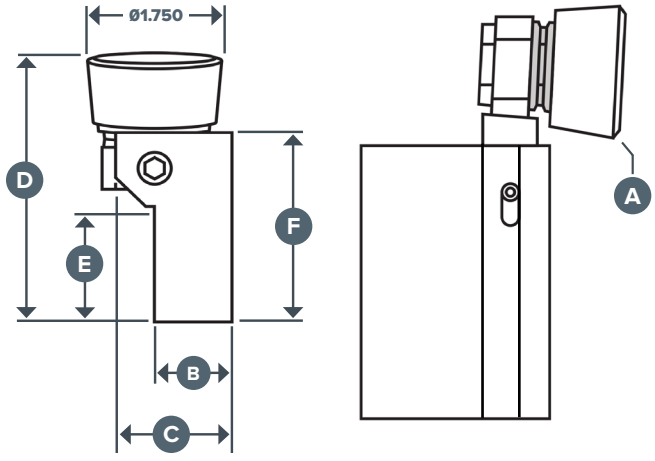
Replace secondary operations while obtaining superior surface finish.

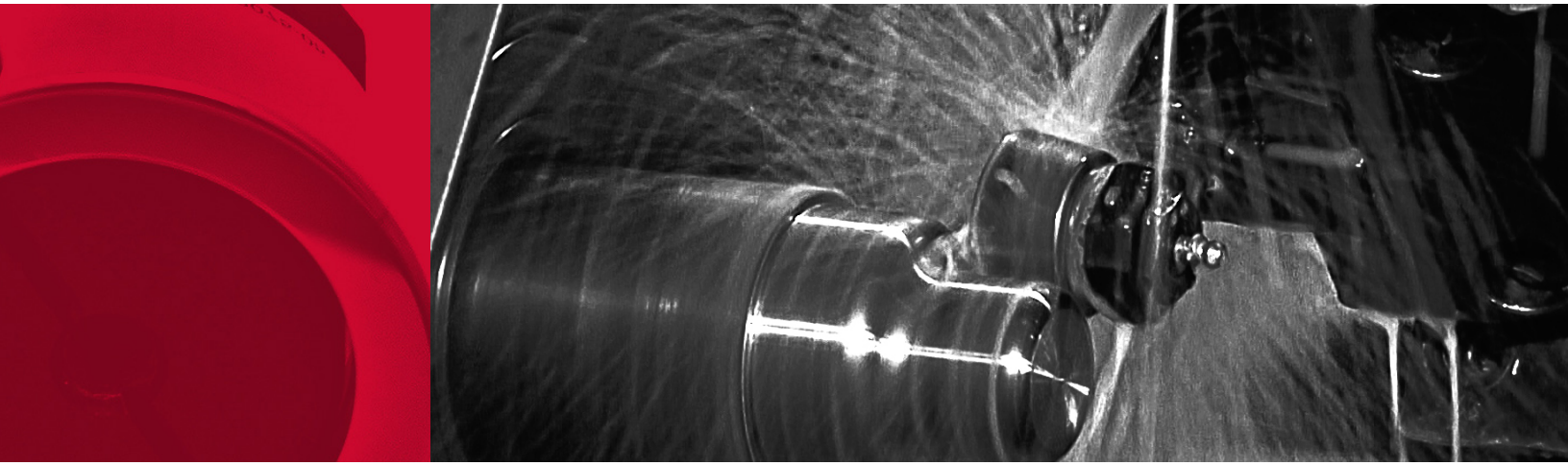
THE VERSATILITY OF THESE TOOLS ALLOWS THE BURNISHING OF EXTERNAL DIAMETERS, TAPERS, RADII, AND FACE AS WELL AS LARGE INTERNAL BORES.

LEFT HAND TOOL



RIGHT HAND TOOL





The outside diameter burnishing tool is used on turning machines to create extremely fine finishes in most ferrous and non-ferrous materials.

Tool Number	Left/ Right Hand	A		B	C	D	E	F
		Roll Radius (in)	Roll Radius (mm)	Shank Size	Shank Size	OAH*	CH**	Block Height
S2302-00	LH	0.032″	0.787mm	0.750″	1.250	3.250	1.250	2.250
S2306-00	RH	0.032″	0.787mm	0.750″	1.250	3.250	1.250	2.250
S2427-00	LH	0.093″	2.36mm	0.750″	1.250	3.500	1.250	2.250
S2488-00	RH	0.093″	2.36mm	0.750″	1.250	3.250	1.250	2.250
S2075-00	LH	0.032″	0.787mm	1.000″	1.500	3.500	1.500	2.500
S2121-00	RH	0.032″	0.787mm	1.000″	1.500	3.500	1.500	2.500
S2548-00	LH	0.062″	1.57mm	1.000″	1.500	3.500	1.500	2.500
S2549-00	RH	0.062″	1.57mm	1.000″	1.500	3.500	1.500	2.500
S2233-00	LH	0.093″	2.36mm	1.000″	1.500	3.500	1.500	2.500
S2327-00	RH	0.093″	2.36mm	1.000″	1.500	3.500	1.500	2.500
5900-100-80477	LH	0.125″	3.175mm	1.000″	1.500	3.250	1.500	2.500
5900-100-80558	RH	0.125″	3.175mm	1.000″	1.500	3.250	1.500	2.500
S2313-00	LH	0.032″	0.787mm	1.250″	1.750	3.500	1.500	2.500
S2384-00	RH	0.032″	0.787mm	1.250″	1.750	3.500	1.500	2.500
S2075-00M	LH	0.032″	0.787mm	25mm	1.485	3.500	1.500	2.500
S2121-00M	RH	0.032″	0.787mm	25mm	1.485	3.500	1.500	2.500
S2548-00M	LH	0.062″	1.57mm	25mm	1.485	3.500	1.500	2.500
S2549-00M	RH	0.062″	1.57mm	25mm	1.485	3.500	1.500	2.500
S2233-00M	LH	0.093″	2.36mm	25mm	1.485	3.500	1.500	2.500
S2327-00M	RH	0.093″	2.36mm	25mm	1.485	3.500	1.500	2.500
5900-100-80477M	LH	0.125″	3.175mm	25mm	1.485	3.250	1.500	2.500
5900-100-80558M	RH	0.125″	3.175mm	25mm	1.485	3.250	1.500	2.500

*Overall height
**Clamping height

OPERATING PROCEDURE

The OD carbide roll burnishing tool can be used to burnish OD's, flat face surfaces, and shallow ID parts (Up to 1.000″ deep).

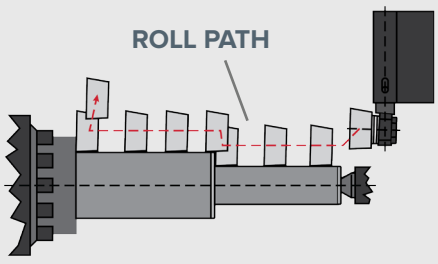
Part Preparations:
100/120 RMS

Feed Rate:
0.004/0.008

Speed:
400-800 SFM (Max 1200)

Coolant Required:
water soluble or oil.

Ensure bearings are sufficiently greased at all times.



OD BURNISHING

APPLICATION

A **consistent**, **repeatable** process...

THE JOB

Part Material:
4140 Steel

Diameter: 2.000″

Length: 2.500″

Stock Allowance:
0.0005/0.0010″
(12-15 microns)

Pre Burnish Surface Finish: 80µR_a

THE SOLUTION

Tool Used:
S2075-00

Speed:
750 SFM

Feed:
0.004″ IPR
(slower on radii)

THE RESULTS

Post Burnish Surface Finish:
7µR_a

Cycle Time:
26.18SEC.

that **eliminates** costly **secondary operations**.