



## SETTING AND OPERATING INSTRUCTIONS

### Monaghan OD style 5451 roller burnishing tool

#### Setting the Burnishing Tool

Loosen the set screw (3). While holding the shank, turn the micrometer nut (2) counter clockwise to decrease the diameter or clockwise to increase the diameter. Adjust the diameter of the tool so that the rolls clear the surface to be burnished. Decrease the diameter of the tool while sliding the tool onto the workpiece. When the rolls come into contact with the surface, remove the workpiece and adjust the tool for the stock allowance left on the workpiece. Recommended stock allowance is .0004" to .0008" on the diameter. Use the graduated marks (each mark represents .0001") on the micrometer nut to make this adjustment. Then, re-tighten the set screw. Be sure that the retaining collar (4) does NOT move during the adjustment process. The mandrel sleeve (1) should ONLY move by adjusting the micrometer nut, not the retaining collar. The final setting can then be determined by burnishing a workpiece and measuring the size and surface finish. Do not burnish the test piece more than twice due to work-hardening of the material. This may cause flaking and incorrect tool setting. Loosen the set screw again to make any further adjustments. When the exact stock allowance has been determined, tighten set screw.