

OD CARBIDE ROLL BURNISHING TOOLS

CRB

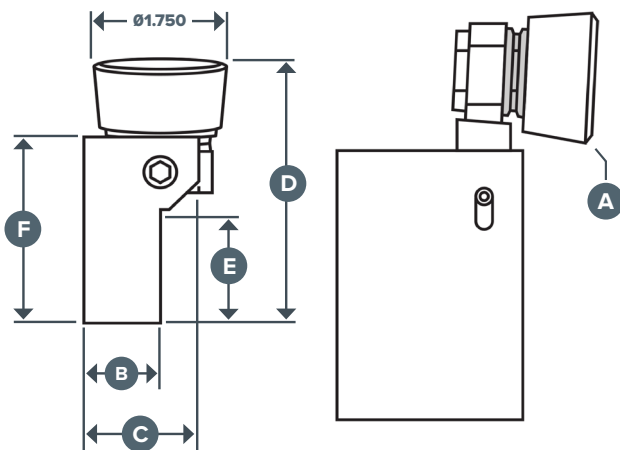
OD BURNISHING

Replace secondary operations while obtaining superior surface finish.

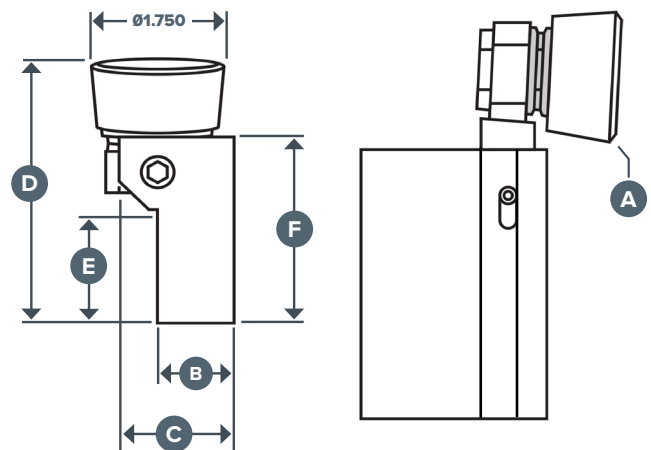


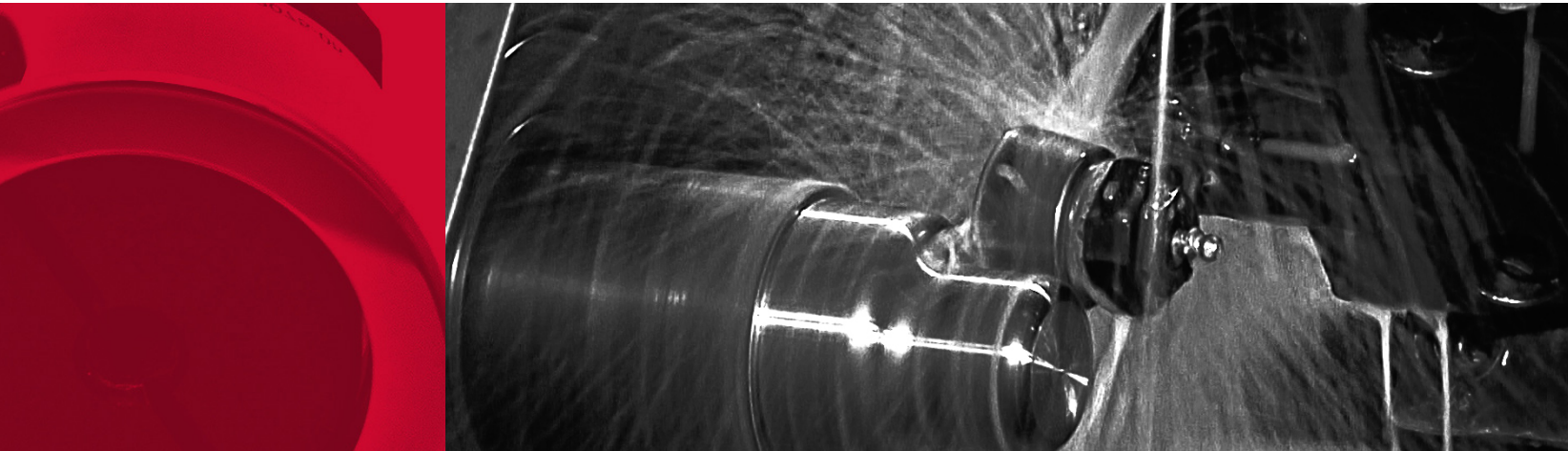
THE VERSATILITY OF THESE TOOLS ALLOWS THE BURNISHING OF EXTERNAL DIAMETERS, TAPERS, RADII, AND FACES - AS WELL AS LARGE INTERNAL BORES.

RIGHT HAND TOOL



LEFT 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"
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*Overall height

**Clamping height

OPERATING PROCEDURE

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

Part Preparations:

100/120 RMS

Feed Rate:

0.004"/0.008"

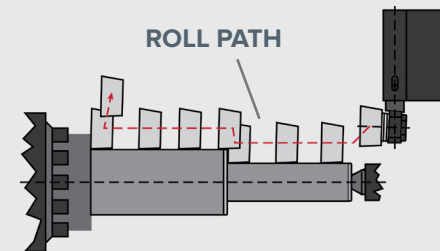
Speed:

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"

**Pre Burnish Surface
Finish:** 80 μ R_a

THE SOLUTION

Tool Used:
S2075-00

Speed:
750 SFM

Feed:
0.004" IPR
(slower on radii)

THE RESULTS



**Post Burnish
Surface Finish:**

7 μ R_a



Cycle Time:

26.18SEC.



that
eliminates
costly
secondary
operations.