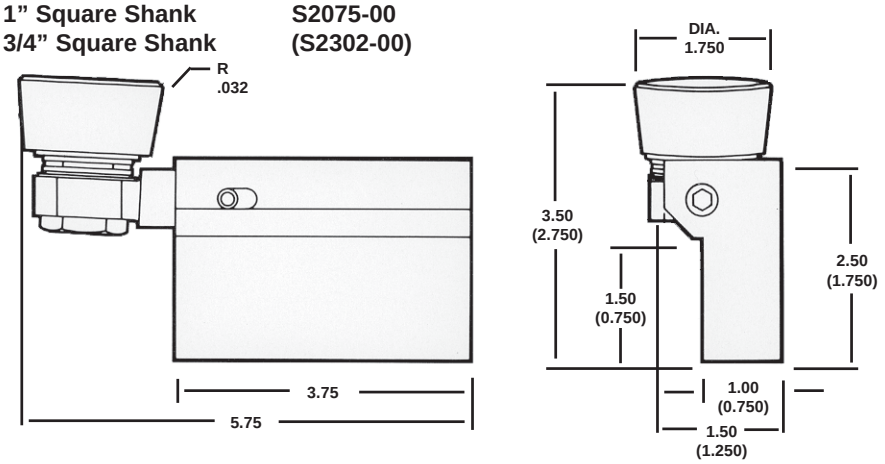
ELLIOTT OUTSIDE SURFACE CARBIDE-ROLL BURNISHING TOOLS

Outside Surface Carbide-Roll Burnishing Tools

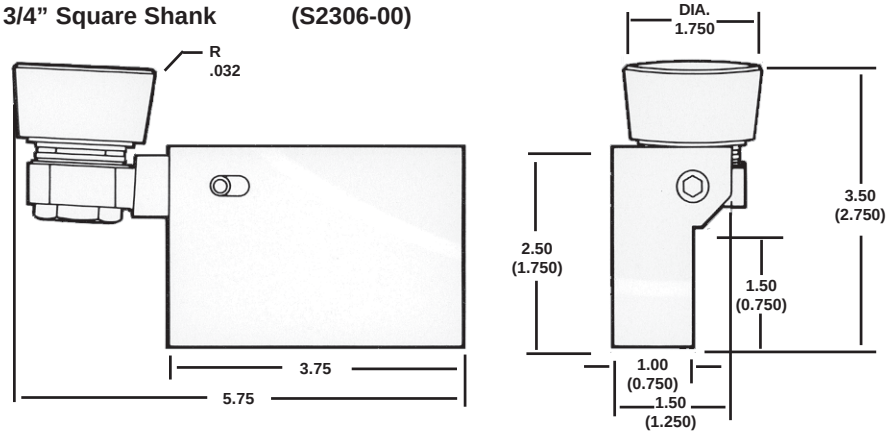
Left Hand

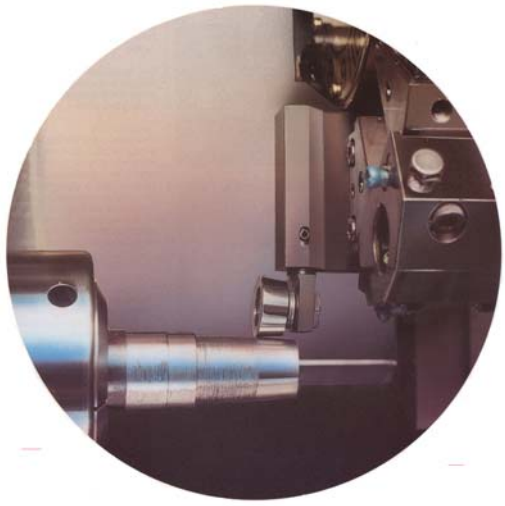
1" Square Shank S2075-00
3/4" Square Shank (S2302-00)



Right Hand

1" Square Shank S2121-00
3/4" Square Shank (S2306-00)





- Reduce machining cost
- Eliminate secondary operations and machines
- Burnish on CNC turning centers and manual lathes
- Produce 4 to 20 microinch (0.1 to 0.5 µm) surface finishes
- Economical tool life with carbide rolls and roll reconditioning program

Burnish multiple surfaces after turning

Tool Number	Shank Size (square)	Left/Right Hand	Roll Radius
S2075-00	1"	LH	0.032" (0.787mm)
S2075-00M	25mm	LH	0.032" (0.787mm)
S2121-00	1"	RH	0.032" (0.787mm)
S2121-00M	25mm	RH	0.032" (0.787mm)
S2548-00	1"	LH	0.062" (1.57mm)
S2548-00M	25mm	LH	0.062" (1.57mm)
S2549-00	1"	RH	0.062" (1.57mm)
S2549-00M	25mm	RH	0.062" (1.57mm)
S2327-00	1"	RH	0.093" (2.36mm)
S2327-00M	25mm	RH	0.093" (2.36mm)
S2233-00	1"	LH	0.093" (2.36mm)
S2233-00M	25mm	LH	0.093" (2.36mm)
5900-100-80477	1"	LH	0.125" (3.175mm)
5900-100-80477M	25mm	LH	0.125" (3.175mm)
5900-100-80558	1"	RH	0.125" (3.175mm)
5900-100-80558M	25mm	RH	0.125" (3.175mm)
S2302-00	3/4"	LH	0.032" (0.787mm)
S2306-00	3/4"	RH	0.032" (0.787mm)
S2427-00	3/4"	LH	0.093" (2.36mm)
S2488-00	3/4"	RH	0.093" (2.36mm)
S2313-00	1-1/4"	LH	0.032" (0.787mm)
S2384-00	1-1/4"	RH	0.032" (0.787mm)

Notes: Other sizes and specials are available on request

The Outside Surface Carbide-Roll Burnishing Tool is mounted in the turret of a CNC turning center or tool post on a manual lathe.

Part surfaces are turned to an 80 to 100 microinch finish using speeds consistent with good machining practices. The carbide burnishing tool then follows the same path at comparable speeds to the turning operation, producing a 5 to 8 microinch finish. This eliminates secondary operations and additional equipment.

The outside surface tool is offered in multiple designs (see chart above). The carbide rolls are available from stock in four radii; .032", .062", .093" and .125".