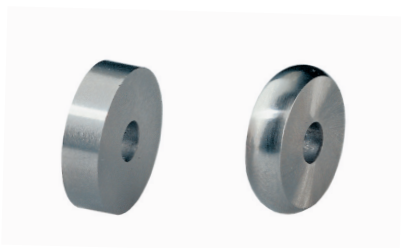


BURNISHING ROLLS



zeus® Burnishing rolls can be applied in a standard zeus® form knurling tool. If required, a customer specific bearing system can be developed and produced. These tool systems are suitable for processing cylindrical work pieces, bores, plane sides, conical work pieces and also convex and concave outlines.

■ RANGE OF APPLICATION:

zeus® Burnishing rolls are mainly used for roller-burnishing or supporting round material during machining on a lathe.

■ CHARACTERISTICS:

Material: 1.3343 HSS
Hardness: 61-63 HRC

■ ADVANTAGES:

- Burnished work pieces show less friction and increased corrosion resistance
- Subsequent-treatments like grinding, honing or lapping can be easily replaced through roller-burnishing processes
- When used as a supportive roll, the bearing axis and clamping devices are less stressed, and the pressure on the work piece is minimized

■ RESULT:

- Improved surface quality
- Increased size accuracy
- Strain hardening of the surface

TYPE RRA - CYLINDRICAL

Type	Dimension			Quality		
	Ø mm	Width mm	Bore mm	No. 04 turned & polished, Rz 4 µm	No. 05 ground, Rz 2-3 µm	No. 06 ground & polished, Rz 1 µm
RRA	10	4	4	✓	✓	✓
	15	4	4	✓	✓	✓
	20	8	6	✓	✓	✓
	25	8	6	✓	✓	✓

TYP RRE - KONVEX

Type	Dimension			R	Quality		
	Ø mm	Width mm	Bore mm		No. 04 turned & polished, Rz 4 µm	No. 05 ground, Rz 2-3 µm	No. 06 ground & polished, Rz 1 µm
RRE	10	4	4	2	✓	✓	✓
	15	4	4	4	✓	✓	✓
	20	8	6	6	✓	✓	✓
	25	8	6	6	✓	✓	✓