

ROLLER BURNISHING

PRODUCT CATALOG



**ALLIED MACHINE
& ENGINEERING**

www.alliedmachine.com

It's so much easier when you make **BETTER CHIPS**

Allied Machine specializes in developing innovative solutions designed to **pulverize** material. Our tools achieve the chip formation and chip evacuation you need to increase your production.



Allied Machine &
Engineering is registered
to ISO 9001:2015 by DQS



Wohlhaupter GmbH is
registered to ISO
9001:2015 by QUACERT



Allied Machine &
Engineering Co. Europe
Ltd. is registered to
ISO 9001:2015 by bsi.



Our Commitment to **YOU**



Manufacturing is the DNA of success everywhere in the world. When you're manufacturing, you're building, creating, and developing something that physically didn't exist before.

At Allied Machine, our core purpose is to provide practical and dependable solutions to improve your manufacturing processes. We know you face challenges and difficulties every day, so we're here to simplify your holmaking processes and improve your production.

However, many factors must be incorporated to truly improve production.

Some of those factors include increasing penetration rates while also improving chip formation and evacuation, reducing scrap rates by producing better parts, reducing setup times, and increasing tool life to get the most from your investment.

Not only does our tooling achieve these results, but our customer service is also an extension of our tooling advantages. Our Application Engineers and Field Sales Engineers are available to assist with any problems you encounter. Don't hesitate to put their skills and knowledge to the test. They won't disappoint.

This is our commitment to manufacturing, and it's our promise to you.



ALLIED MACHINE
& ENGINEERING

SECTION

D00-BRN

S.C.A.M.I.® Roller Burnishers

ROLLER BURNISHING

3.95 mm - 165.90 mm
(0.1555" - 6.5315")



Get the Finish You Need

Allied Machine is proud to offer roller burnishing tools from S.C.A.M.I. These hole finishing tools provide an extremely high-quality surface finish on both through-hole and blind-hole applications. With roller burnishing, you can eliminate the need for slower and more costly finishing processes and secondary operations such as grinding, honing, and lapping.

Not only will the roller burnishing tools create a smooth surface finish, but they will also harden the material and increase the wear resistance of the part. The benefits of this single operation result in the hole quality you should expect from Allied Machine. Large range of shanks for different machine types.

- ▶ Creates fine surface finishes.
- ▶ Eliminates other processes and saves you money.
- ▶ Increases wear and corrosion resistance.

S.C.A.M.I.®

Applicable Industries

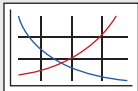
-  Aerospace
-  Agriculture
-  Automotive
-  Defense
-  General Production
-  Heavy Equipment
-  Hydraulics
-  Marine
-  Medical
-  Renewable Energy/ Energy
-  Tool, Mold, and Die

Reference Icons

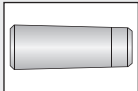
The following icons will appear throughout the catalog to help you navigate between products.



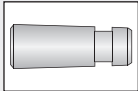
Setup / Assembly Information
Detailed instructions and information regarding the corresponding part(s).



Recommended Cutting Data
Speed and feed recommendations for optimum and safe drilling.



Through-Hole Rolls
Refers to the rolls available for through-hole burnishing tools.



Blind-Hole Rolls
Refers to the rolls available for blind-hole burnishing tools.

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury. When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words:

 WARNING	means that failure to follow the precautions in this message could result in tool failure and serious injury.
NOTICE	means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.
NOTE and IMPORTANT	are also used. These are important that you read and follow but are not safety-related.
Visit www.alliedmachine.com for the most up-to-date information and procedures.	

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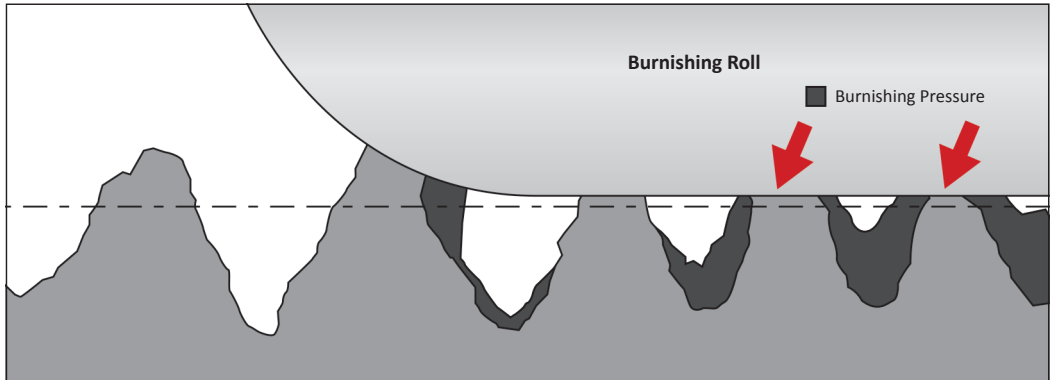
Roller Burnishing Overview

The Principle of Roller Burnishing

Roller burnishing is a cold-working process that produces a fine surface finish. The planetary rotation of the hardened rolls creates pressure over a metal surface. Unlike cold rolling, which produces large sectional changes, roller burnishing involves cold-working on the surface of the workpiece to improve the surface structure.

All machined surfaces consist of a series of peaks and valleys, all having irregular height and spacing. The plastic deformation created by roller burnishing is a displacement of the material in the peaks. When under pressure, the material in the peaks flows into the valleys. During the process, tool marks and irregularities are rolled out, resulting in a mirror-like finish with a tough, work-hardened surface that is also wear and corrosion resistant.

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Advantages of Roller Burnishing: Metallurgical Properties

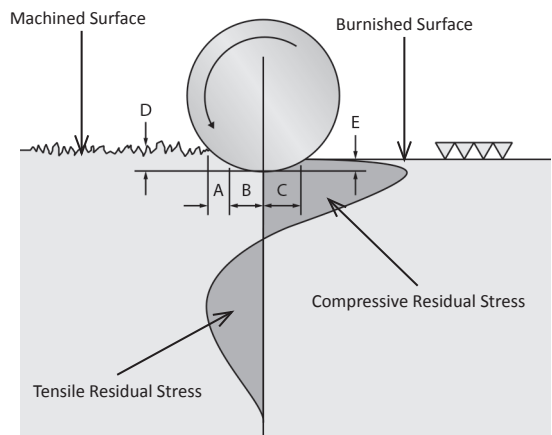
- Grain structure is condensed and refined.
- The compacted surface is **smoother, harder, and more wear resistant** than ground or honed surfaces.
- The process reduces surface porosity and also removes scratches that could hold reactive substances or contaminants. **This increases the corrosion resistance.**
- Depending on the material, the surface hardness can be **increased by as much as 10 points Rockwell C**. This may eliminate the need for heat treatment.
- The plastic deformation induces residual compressive stresses in the surface of the part. This increases the strength properties and fatigue life of the part because any forces on the part must overcome these residual stresses, as well as the tensile strength of the materials, before fatigue conditions occur.

Advantages of Roller Burnishing: Surface Finish

- Creates a high finish to any machinable metal.
- Surfaces that are bored, reamed, or turned to 125 microinches or more can be finished to 4 microinch CLA or less in one pass (at feed rates of 125 to 300 mm/min).
- Roller burnishing replaces grinding, honing, lapping, and other expensive secondary operations.
- Tool marks are rolled out.

The Process

- The first contact with the machined surface occurs in Section A.
- Plastic deformation occurs in Section B as the yield point of the surface is exceeded.
- Section D is the pressurized depth.
- Once the material endures the maximum compressive strain (Section C), it starts relieving elastically (Section E) through the finishing zone.
- This leaves a smooth surface and a compressive residual stress of significant peak value.
- The stresses formed on the material during the compression decrease toward the center. These stresses reach approximately 1 mm below the surface. This increases the surface hardness.



Roller Burnishing Overview

When to Roller Burnish

Conditions for Roller Burnishing

Roller burnishing is a cold-working process used to achieve fine hole finishes. In order to achieve the most optimal results, adhere to the benchmarks below:

- **Finishing:** The ductility and hardness of the workpiece material along with the surface preparation dictates the quality of the burnished finish.
- **Workability:** Any ductile and malleable material up to RC40 can be roller burnished.
- **Worked Surface Properties:** Workpieces with an interrupted surface within 10% of the circumference can be successfully burnished with a standard tool (see Figures 1 and 2).

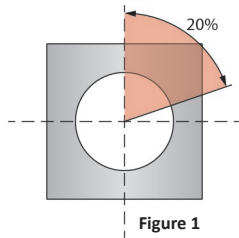


Figure 1

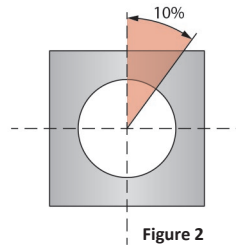


Figure 2

- **Tolerance of the Burnished Piece:** The tolerance range achieved from the burnishing will be equal to that achieved from the premachining since no material will be removed.

The ideal surface for burnishing consists of a succession of peaks. These peaks correspond on regular feed of the preparation tool (see Figure 3). We suggest the ALVAN® expandable reamer for preburnishing because it creates a uniform roughness and a tolerance range of H6 - H7.

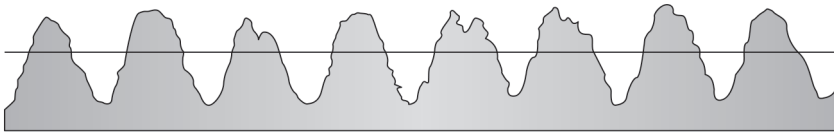


Figure 3

Premachining tapers and surface irregularities caused by cutting tool failure must be noted because these conditions cannot be corrected by the roller burnishing process (see Figures 4 and 5).

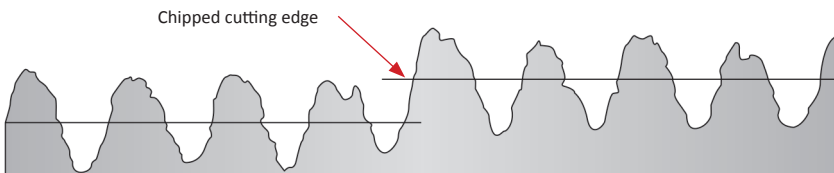


Figure 4

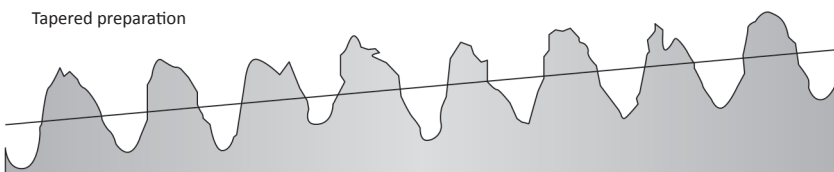


Figure 5



Roller Burnishing Overview

Product Offering

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Through-Hole Style

3.95 mm - 165.90 mm (0.1555" - 6.5315")

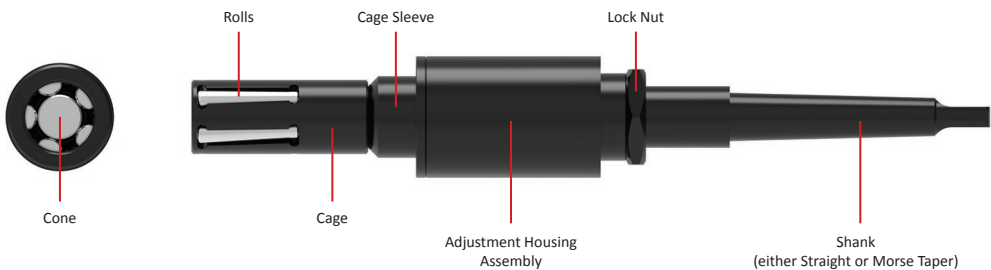


Blind-Hole Style

5.89 mm - 165.90 mm (0.2319" - 6.5315")

Advantages of the Roller Burnishing Tool

- ✓ **Provides accurate size control**
tolerances within 0.013 mm (0.0005") or better (depending on variables such as material).
- ✓ **Produces fine surface finishes**
between 0.03 - 0.4 micromillimeters Ra (1 - 16 microinches Ra).
- ✓ **Increases surface hardness**
by 5 - 10% or more.
- ✓ **Performs a much cleaner operation**
than honing or other abrasive finishing methods.
- ✓ **Provides versatility**
because the operation can be performed on any rotating spindle.
- ✓ **Eliminates the need for slower and costly finishing processes and secondary operations**
such as grinding, honing, lapping, etc.



The Tool Components

All roller burnishing tools (both through hole and blind hole) are composed of the basic burnisher assembly including:

- Cage
- Cone
- Rolls
- Shank (either straight or Morse Taper)



Roller Burnishing Overview

Product Selection Guide

Series	Diameter Range																								Length			
	50.00 mm 1.9685"								100.00 mm 3.9370"								150.00 mm 5.9055"								Short	Standard	Long	Unlimited
H Mini	■																								✓	✓		
H	■																								✓	✓	✓	
I		■																							✓	✓	✓	
K			■																						✓	✓	✓	
L				■																					✓	✓	✓	
F					■																							✓
M						■																						✓
N							■																					✓
O								■																				✓
P									■																			✓
Q										■																		✓
R											■																	✓
S												■																✓
T													■															✓
U														■														✓

NOTE: For H series, through-hole tools start at 3.95 mm (0.1555") and blind-hole tools start at 5.89 mm (0.2319").

When to **ORDER UP**

In some cases, there will be a diameter overlap between a series and the series after it. If the diameter you need falls into this overlap, choose the higher of the two series.

Example:

You need a 24.64 mm diameter tool. This diameter falls into both the K series and the L series.

- K series diameter range = 16.60 mm - 24.74 mm
- L series diameter range = 24.54 mm - 31.16 mm

In this scenario, you would choose the L series tool that covers the 24.64 mm diameter.



Roller Burnishing Overview

Product Nomenclature

Roller Burnisher

D00

RDK	H				2	1	0	00470
Diameter Unit	Series				Shank Type	Length	Cage Style	Diameter*
RDK = Through hole	H	F	P	T	0 = Straight (mini)	0 = Unlimited	0 = Standard	XXXXXX = XX.XXX mm
RSK = Blind hole	I	M	Q	U	1 = Straight	1 = Short	2 = Mini	XXXXXX = X.XXXXX"
	K	N	R		2 = Morse Taper	2 = Standard		
	L	O	S			3 = Long		

*For through holes, use minimum diameter of burnishing range, and for blind holes, use the diameter to burnish.

Cone Reduction Factor (Blind Holes)

When burnishing blind holes, the cone must not extend past the end of the rolls. If it does, the cone will collide with the bottom of the hole. Each burnishing tool has an adjustment range of:

- Approximately 0.5 mm on diameter for tools below 12.7 mm.
- Approximately 1.0 mm on diameter for tools above 12.7 mm.

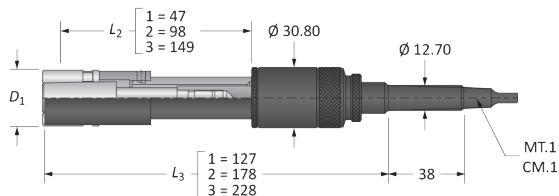
For through-hole burnishing tools, the standard cone value "x" is 1. If the standard cone is used for blind-hole burnishing, the only way it will not extend past the end of the rolls is to reduce the length of the cone. The required length reduction is dependent on the set diameter versus the minimum capable diameter of the tool. The factor of reduction (x) can be calculated using the formulas below and will be a whole integer number ranging from 2 - 8.

The "x" value could result in a decimal figure. If so, round down for answers below 0.80 and round up for answers 0.80 and above.

Diameter (5.89 mm - 12.77 mm)	Diameter (12.64 mm - 127.94 mm)	Diameter (127.90 mm - 165.90 mm)
$x = 1 + \frac{Z - Y}{0.05}$ Z = diameter of the hole Y = minimum diameter setting of tool Example: Z = 11.05 Y = 10.71 mm $x = 1 + \frac{11.05 - 10.71}{0.05} = 7.8$ which is approximated at "x" = 8 Correct Cone: RSTH-038-10025	$x = 1 + \frac{Z - Y}{0.10}$ Z = diameter of the hole Y = minimum diameter setting of tool Example: Z = 17.76 Y = 17.40 mm $x = 1 + \frac{17.76 - 17.40}{0.10} = 4.6$ which is approximated at "x" = 4 Correct Cone: RSTK-034-00044	$xx = 31 + \frac{Z - Y}{0.10}$ Z = diameter of the hole Y = minimum diameter setting of tool Example: Z = 148.20 Y = 147.90 mm $xx = 31 + \frac{148.20 - 147.90}{0.10} = 34$ Correct Cone: RSTT-034-01480

Reference Key

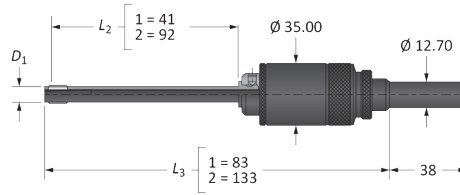
Symbol	Attribute
D_1	Diameter range
L_2	Burnishing length
L_3	Reference length





H Series (mini): 3.95 mm - 4.75 mm (0.1555" - 0.1870")

Through Holes



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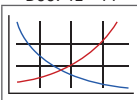
D_1		L	Part No. Straight Shank Assembly	Spare Parts			Qty
Metric (mm)	Imperial (in)			Cage	Cone	Rolls Part No.	
3.95 - 4.15	0.1555 - 0.1634	1	RDKH-012-00395	RDCH-012-10005	RDTH-031-10012	RDY-704-00047	3
		2	RDKH-022-00395	RDCH-012-20005	RDTH-031-20012		
4.16 - 4.35	0.1638 - 0.1713	1	RDKH-012-00416	RDCH-012-10006	RDTH-035-10012	RDY-704-00047	3
		2	RDKH-022-00416	RDCH-012-20006	RDTH-035-20012		
4.36 - 4.55	0.1717 - 0.1791	1	RDKH-012-00436	RDCH-012-10007	RDTH-031-10013	RDY-704-00047	3
		2	RDKH-022-00436	RDCH-012-20007	RDTH-031-20013		
4.56 - 4.75	0.1795 - 0.1870	1	RDKH-012-00456	RDCH-012-10008	RDTH-035-10013	RDY-704-00047	3
		2	RDKH-022-00456	RDCH-012-20008	RDTH-035-20013		

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

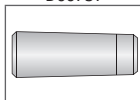
D00: 39 - 40



D00: 41 - 44



D00: 37

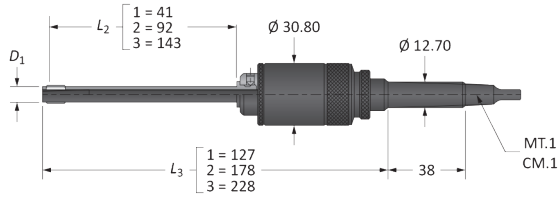


Key on D00: 2

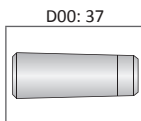
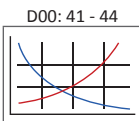
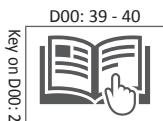
**H Series: 4.70 mm - 12.77 mm (0.1850" - 0.5028")**

Through Holes

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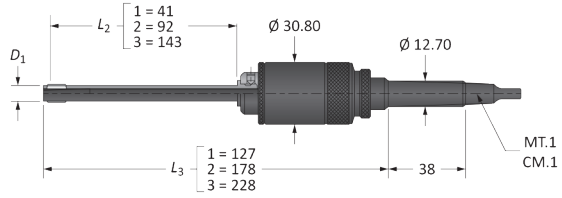
D_1		Part No.		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)	L	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	
4.70 - 4.90	0.1850 - 0.1929	1	RDKH-210-00470	RDKH-110-00470	RDCH-011-10012	RDTH-031-10012	RDYR-704-00062
		2	RDKH-220-00470	RDKH-120-00470	RDCH-011-20012	RDTH-031-20012	
		3	RDKH-230-00470	RDKH-130-00470	RDCH-011-30012	RDTH-031-30012	
4.87 - 5.17	0.1917 - 0.2035	1	RDKH-210-00487	RDKH-110-00487	RDCH-011-10011	RSTH-033-10012	RDYR-704-00062
		2	RDKH-220-00487	RDKH-120-00487	RDCH-011-20011	RSTH-033-20012	
		3	RDKH-230-00487	RDKH-130-00487	RDCH-011-30011	RSTH-033-30012	
5.07 - 5.59	0.1996 - 0.2200	1	RDKH-210-00507	RDKH-110-00507	RDCH-011-10013	RDTH-031-10013	RDYR-704-00062
		2	RDKH-220-00507	RDKH-120-00507	RDCH-011-20013	RDTH-031-20013	
		3	RDKH-230-00507	RDKH-130-00507	RDCH-011-30013	RDTH-031-30013	
5.49 - 5.99	0.2161 - 0.2358	1	RDKH-210-00549	RDKH-110-00549	RDCH-011-10014	RDTH-031-10013	RDYR-704-00070
		2	RDKH-220-00549	RDKH-120-00549	RDCH-011-20014	RDTH-031-20013	
		3	RDKH-230-00549	RDKH-130-00549	RDCH-011-30014	RDTH-031-30013	
5.89 - 6.41	0.2319 - 0.2524	1	RDKH-210-00589	RDKH-110-00589	RDCH-011-10015	RDTH-031-10015	RDYR-704-00070
		2	RDKH-220-00589	RDKH-120-00589	RDCH-011-20015	RDTH-031-20015	
		3	RDKH-230-00589	RDKH-130-00589	RDCH-011-30015	RDTH-031-30015	
6.31 - 6.81	0.2484 - 0.2681	1	RDKH-210-00631	RDKH-110-00631	RDCH-011-10016	RDTH-031-10015	RDYR-704-00078
		2	RDKH-220-00631	RDKH-120-00631	RDCH-011-20016	RDTH-031-20015	
		3	RDKH-230-00631	RDKH-130-00631	RDCH-011-30016	RDTH-031-30015	
6.71 - 7.21	0.2642 - 0.2839	1	RDKH-210-00671	RDKH-110-00671	RDCH-011-10017	RDTH-031-10017	RDYR-704-00078
		2	RDKH-220-00671	RDKH-120-00671	RDCH-011-20017	RDTH-031-20017	
		3	RDKH-230-00671	RDKH-130-00671	RDCH-011-30017	RDTH-031-30017	
7.12 - 7.62	0.2803 - 0.3000	1	RDKH-210-00712	RDKH-110-00712	RDCH-011-10018	RDTH-031-10017	RDYR-704-00086
		2	RDKH-220-00712	RDKH-120-00712	RDCH-011-20018	RDTH-031-20017	
		3	RDKH-230-00712	RDKH-130-00712	RDCH-011-30018	RDTH-031-30017	
7.48 - 7.98	0.2945 - 0.3142	1	RDKH-210-00748	RDKH-110-00748	RDCH-011-10019	RDTH-031-10019	RDYR-704-00086
		2	RDKH-220-00748	RDKH-120-00748	RDCH-011-20019	RDTH-031-20019	
		3	RDKH-230-00748	RDKH-130-00748	RDCH-011-30019	RDTH-031-30019	
7.88 - 8.38	0.3102 - 0.3299	1	RDKH-210-00788	RDKH-110-00788	RDCH-011-10020	RDTH-031-10019	RDYR-704-00093
		2	RDKH-220-00788	RDKH-120-00788	RDCH-011-20020	RDTH-031-20019	
		3	RDKH-230-00788	RDKH-130-00788	RDCH-011-30020	RDTH-031-30019	
8.28 - 8.79	0.3260 - 0.3461	1	RDKH-210-00828	RDKH-110-00828	RDCH-011-10021	RDTH-031-10021	RDYR-704-00093
		2	RDKH-220-00828	RDKH-120-00828	RDCH-011-20021	RDTH-031-20021	
		3	RDKH-230-00828	RDKH-130-00828	RDCH-011-30021	RDTH-031-30021	

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



H Series: 4.70 mm - 12.77 mm (0.1850" - 0.5028")

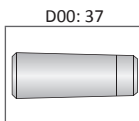
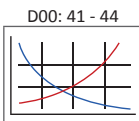
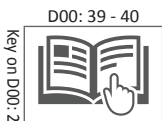
Through Holes



D00

D_1		L	Part No.		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)		Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone		
8.66 - 9.16	0.3410 - 0.3606	1	RDKH-210-00866	RDKH-110-00866	RDCH-011-10022	RDTH-031-10019	RDY-704-00109	5
		2	RDKH-220-00866	RDKH-120-00866	RDCH-011-20022	RDTH-031-20019		
		3	RDKH-230-00866	RDKH-130-00866	RDCH-011-30022	RDTH-031-30019		
9.06 - 9.57	0.3567 - 0.3768	1	RDKH-210-00906	RDKH-110-00906	RDCH-011-10023	RDTH-031-10021	RDY-704-00109	5
		2	RDKH-220-00906	RDKH-120-00906	RDCH-011-20023	RDTH-031-20021		
		3	RDKH-230-00906	RDKH-130-00906	RDCH-011-30023	RDTH-031-30021		
9.48 - 9.99	0.3732 - 0.3933	1	RDKH-210-00948	RDKH-110-00948	RDCH-011-10024	RDTH-031-10024	RDY-704-00109	5
		2	RDKH-220-00948	RDKH-120-00948	RDCH-011-20024	RDTH-031-20024		
		3	RDKH-230-00948	RDKH-130-00948	RDCH-011-30024	RDTH-031-30024		
9.91 - 10.42	0.3902 - 0.4102	1	RDKH-210-00991	RDKH-110-00991	RDCH-011-10025	RDTH-031-10025	RDY-704-00109	5
		2	RDKH-220-00991	RDKH-120-00991	RDCH-011-20025	RDTH-031-20025		
		3	RDKH-230-00991	RDKH-130-00991	RDCH-011-30025	RDTH-031-30025		
10.29 - 10.80	0.4051 - 0.4252	1	RDKH-210-01029	RDKH-110-01029	RDCH-011-10026	RDTH-031-10024	RDY-704-00125	5
		2	RDKH-220-01029	RDKH-120-01029	RDCH-011-20026	RDTH-031-20024		
		3	RDKH-230-01029	RDKH-130-01029	RDCH-011-30026	RDTH-031-30024		
10.71 - 11.21	0.4217 - 0.4413	1	RDKH-210-01071	RDKH-110-01071	RDCH-011-10027	RDTH-031-10025	RDY-704-00125	5
		2	RDKH-220-01071	RDKH-120-01071	RDCH-011-20027	RDTH-031-20025		
		3	RDKH-230-01071	RDKH-130-01071	RDCH-011-30027	RDTH-031-30025		
11.11 - 11.61	0.4374 - 0.4571	1	RDKH-210-01111	RDKH-110-01111	RDCH-011-10028	RDTH-031-10028	RDY-704-00125	5
		2	RDKH-220-01111	RDKH-120-01111	RDCH-011-20028	RDTH-031-20028		
		3	RDKH-230-01111	RDKH-130-01111	RDCH-011-30028	RDTH-031-30028		
11.46 - 11.96	0.4512 - 0.4709	1	RDKH-210-01146	RDKH-110-01146	RDCH-011-10029	RDTH-031-10024	RDY-704-00148	5
		2	RDKH-220-01146	RDKH-120-01146	RDCH-011-20029	RDTH-031-20024		
		3	RDKH-230-01146	RDKH-130-01146	RDCH-011-30029	RDTH-031-30024		
11.89 - 12.39	0.4681 - 0.4878	1	RDKH-210-01189	RDKH-110-01189	RDCH-011-10030	RDTH-031-10025	RDY-704-00148	5
		2	RDKH-220-01189	RDKH-120-01189	RDCH-011-20030	RDTH-031-20025		
		3	RDKH-230-01189	RDKH-130-01189	RDCH-011-30030	RDTH-031-30025		
12.27 - 12.77	0.4831 - 0.5028	1	RDKH-210-01227	RDKH-110-01227	RDCH-011-10031	RDTH-031-10028	RDY-704-00148	5
		2	RDKH-220-01227	RDKH-120-01227	RDCH-011-20031	RDTH-031-20028		
		3	RDKH-230-01227	RDKH-130-01227	RDCH-011-30031	RDTH-031-30028		

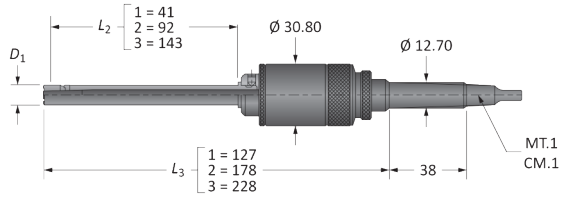
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



**H Series: 4.70 mm - 12.77 mm (0.1850" - 0.5028")**

Blind Holes

D00

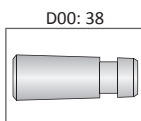
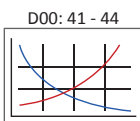
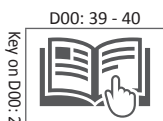


D_1		L	Part No.*		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)		Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**		
5.89 - 6.41	0.2319 - 0.2524	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10015	RSTH-03x-10012	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20015	RSTH-03x-20012		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30015	RSTH-03x-30012		
6.31 - 6.81	0.2484 - 0.2681	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10016	RSTH-03x-10013	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20016	RSTH-03x-20013		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30016	RSTH-03x-30013		
6.71 - 7.21	0.2642 - 0.2839	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10017	RSTH-03x-10015	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20017	RSTH-03x-20015		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30017	RSTH-03x-30015		
7.12 - 7.62	0.2803 - 0.3000	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10018	RSTH-03x-10017	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20018	RSTH-03x-20017		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30018	RSTH-03x-30017		
7.48 - 7.98	0.2945 - 0.3142	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10019	RSTH-03x-10019	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20019	RSTH-03x-20019		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30019	RSTH-03x-30019		
7.88 - 8.38	0.3102 - 0.3299	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10020	RSTH-03x-10021	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20020	RSTH-03x-20021		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30020	RSTH-03x-30021		
8.28 - 8.79	0.3260 - 0.3461	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10021	RSTH-03x-10024	RSRY-708-00086	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20021	RSTH-03x-20024		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30021	RSTH-03x-30024		
8.66 - 9.16	0.3410 - 0.3606	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10022	RSTH-03x-10015	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20022	RSTH-03x-20015		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30022	RSTH-03x-30015		
9.06 - 9.57	0.3567 - 0.3768	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10023	RSTH-03x-10017	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20023	RSTH-03x-20017		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30023	RSTH-03x-30017		

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. short series roller burnisher Ø 10.25 mm with MT.1 shank: RSKH-210-01025).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page **D00: 7** for the correct identification of the "x" value.

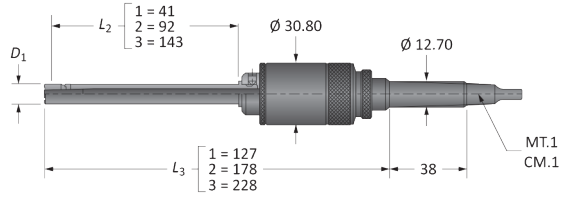
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





H Series: 4.70 mm - 12.77 mm (0.1850" - 0.5028")

Blind Holes



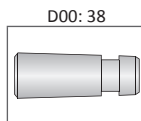
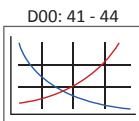
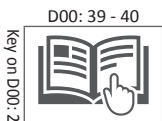
D00

D_1		L	Part No.*		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)		Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**		
9.48 - 9.99	0.3732 - 0.3933	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10024	RSTH-03x-10019	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20024	RSTH-03x-20019		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30024	RSTH-03x-30019		
9.91 - 10.42	0.3902 - 0.4102	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10025	RSTH-03x-10021	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20025	RSTH-03x-20021		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30025	RSTH-03x-30021		
10.29 - 10.80	0.4051 - 0.4252	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10026	RSTH-03x-10024	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20026	RSTH-03x-20024		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30026	RSTH-03x-30024		
10.71 - 11.21	0.4217 - 0.4413	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10027	RSTH-03x-10025	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20027	RSTH-03x-20025		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30027	RSTH-03x-30025		
11.11 - 11.61	0.4374 - 0.4571	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10028	RSTH-03x-10028	RSRY-708-00125	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20028	RSTH-03x-20028		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30028	RSTH-03x-30028		
11.46 - 11.96	0.4512 - 0.4709	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10029	RSTH-03x-10021	RSRY-708-00156	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20029	RSTH-03x-20021		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30029	RSTH-03x-30021		
11.89 - 12.39	0.4681 - 0.4878	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10030	RSTH-03x-10024	RSRY-708-00156	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20030	RSTH-03x-20024		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30030	RSTH-03x-30024		
12.27 - 12.77	0.4831 - 0.5028	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10031	RSTH-03x-10025	RSRY-708-00156	3
		2	RSKH-220-xxxxx	RSKH-120-xxxxx	RSCH-015-20031	RSTH-03x-20025		
		3	RSKH-230-xxxxx	RSKH-130-xxxxx	RSCH-015-30031	RSTH-03x-30025		

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. short series roller burnisher Ø 10.25 mm with MT.1 shank: RSKH-210-01025).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page **D00: 7** for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

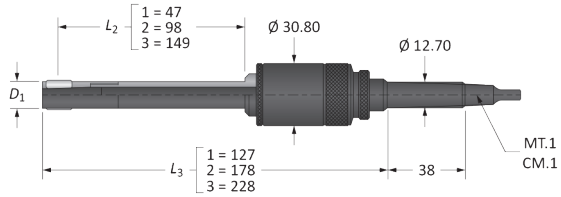


Key on D00: 2

**I Series: 12.64 mm - 16.85 mm (0.4976" - 0.6634")**

Through Holes

D00



D ₁		Part No.			Spare Parts			
Metric (mm)	Imperial (in)	L	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
12.64 - 13.50	0.4976 - 0.5315	1	RDKI-210-01264	RDKI-110-01264	RDCI-400-00500	RDTI-031-10032	RDRY-704-00156	5
		2	RDKI-220-01264	RDKI-120-01264	RDCI-400-00500	RDTI-031-20032		
		3	RDKI-230-01264	RDKI-130-01264	RDCI-400-00500	RDTI-031-30032		
13.45 - 14.45	0.5295 - 0.5689	1	RDKI-210-01345	RDKI-110-01345	RDCI-400-00531	RDTI-031-10034	RDRY-704-00156	5
		2	RDKI-220-01345	RDKI-120-01345	RDCI-400-00531	RDTI-031-20034		
		3	RDKI-230-01345	RDKI-130-01345	RDCI-400-00531	RDTI-031-30034		
14.25 - 15.25	0.5610 - 0.6004	1	RDKI-210-01425	RDKI-110-01425	RDCI-400-00562	RDTI-031-10034	RDRY-704-00172	5
		2	RDKI-220-01425	RDKI-120-01425	RDCI-400-00562	RDTI-031-20034		
		3	RDKI-230-01425	RDKI-130-01425	RDCI-400-00562	RDTI-031-30034		
15.05 - 16.05	0.5925 - 0.6319	1	RDKI-210-01505	RDKI-110-01505	RDCI-400-00593	RDTI-031-10038	RDRY-704-00172	5
		2	RDKI-220-01505	RDKI-120-01505	RDCI-400-00593	RDTI-031-20038		
		3	RDKI-230-01505	RDKI-130-01505	RDCI-400-00593	RDTI-031-30038		
15.85 - 16.85	0.6240 - 0.6634	1	RDKI-210-01585	RDKI-110-01585	RDCI-400-00625	RDTI-031-10038	RDRY-701-00187	5
		2	RDKI-220-01585	RDKI-120-01585	RDCI-400-00625	RDTI-031-20038		
		3	RDKI-230-01585	RDKI-130-01585	RDCI-400-00625	RDTI-031-30038		

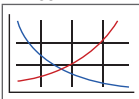
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

D00: 39 - 40

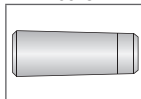


Key on D00: 2

D00: 41 - 44



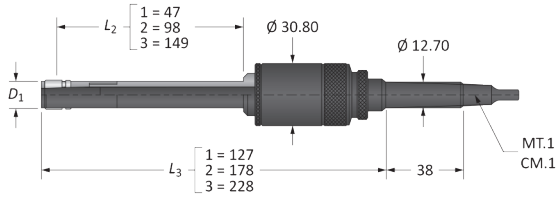
D00: 37





I Series: 12.64 mm - 16.85 mm (0.4976" - 0.6634")

Blind Holes



D00

D_1		L	Part No.*		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)		Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**		
12.64 - 13.50	0.4976 - 0.5315	1	RSKI-210-xxxxx	RSKI-110-xxxxx	RSCI-400-00500	RSTI-03x-10032	RSRY-708-00156	5
		2	RSKI-220-xxxxx	RSKI-120-xxxxx	RSCI-400-00500	RSTI-03x-20032		
		3	RSKI-230-xxxxx	RSKI-130-xxxxx	RSCI-400-00500	RSTI-03x-30032		
13.45 - 14.45	0.5295 - 0.5689	1	RSKI-210-xxxxx	RSKI-110-xxxxx	RSCI-400-00531	RSTI-03x-10034	RSRY-708-00156	5
		2	RSKI-220-xxxxx	RSKI-120-xxxxx	RSCI-400-00531	RSTI-03x-20034		
		3	RSKI-230-xxxxx	RSKI-130-xxxxx	RSCI-400-00531	RSTI-03x-30034		
14.25 - 15.25	0.5610 - 0.6004	1	RSKI-210-xxxxx	RSKI-110-xxxxx	RSCI-400-00562	RSTI-03x-10034	RSRY-708-00172	5
		2	RSKI-220-xxxxx	RSKI-120-xxxxx	RSCI-400-00562	RSTI-03x-20034		
		3	RSKI-230-xxxxx	RSKI-130-xxxxx	RSCI-400-00562	RSTI-03x-30034		
15.05 - 16.05	0.5925 - 0.6319	1	RSKI-210-xxxxx	RSKI-110-xxxxx	RSCI-400-00593	RSTI-03x-10038	RSRY-708-00172	5
		2	RSKI-220-xxxxx	RSKI-120-xxxxx	RSCI-400-00593	RSTI-03x-20038		
		3	RSKI-230-xxxxx	RSKI-130-xxxxx	RSCI-400-00593	RSTI-03x-30038		
15.85 - 16.85	0.6240 - 0.6634	1	RSKI-210-xxxxx	RSKI-110-xxxxx	RSCI-400-00625	RSTI-03x-10038	RSRY-708-00187	5
		2	RSKI-220-xxxxx	RSKI-120-xxxxx	RSCI-400-00625	RSTI-03x-20038		
		3	RSKI-230-xxxxx	RSKI-130-xxxxx	RSCI-400-00625	RSTI-03x-30038		

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. long series roller burnisher Ø 14.00 mm with MT.1 shank: RSKI-230-01400).

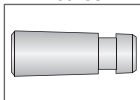
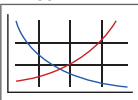
** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page **D00: 7** for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

D00: 39 - 40

D00: 41 - 44

D00: 38

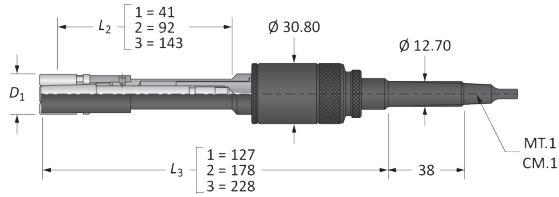


Key on D00: 2

**K Series: 16.60 mm - 24.74 mm (0.6535" - 0.9740")**

Through Holes

D00



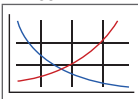
D_1		Part No.		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)	L	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	
16.60 - 17.61	0.6535 - 0.6933	1	RDKK-210-01660	RDKK-110-01660	RDCK-011-00042	RDTK-031-00042	RDYR-701-00187
		2	RDKK-220-01660	RDKK-120-01660	RDCK-011-00042	RDTK-031-00042	
		3	RDKK-230-01660	RDKK-130-01660	RDCK-011-00042	RDTK-031-00042	
17.40 - 18.39	0.6850 - 0.7240	1	RDKK-210-01740	RDKK-110-01740	RDCK-011-00044	RDTK-031-00044	RDYR-701-00187
		2	RDKK-220-01740	RDKK-120-01740	RDCK-011-00044	RDTK-031-00044	
		3	RDKK-230-01740	RDKK-130-01740	RDCK-011-00044	RDTK-031-00044	
18.19 - 19.18	0.7161 - 0.7551	1	RDKK-210-01819	RDKK-110-01819	RDCK-011-00046	RDTK-031-00042	RDYR-701-00218
		2	RDKK-220-01819	RDKK-120-01819	RDCK-011-00046	RDTK-031-00042	
		3	RDKK-230-01819	RDKK-130-01819	RDCK-011-00046	RDTK-031-00042	
18.96 - 19.99	0.7465 - 0.7870	1	RDKK-210-01896	RDKK-110-01896	RDCK-011-00048	RDTK-031-00044	RDYR-701-00218
		2	RDKK-220-01896	RDKK-120-01896	RDCK-011-00048	RDTK-031-00044	
		3	RDKK-230-01896	RDKK-130-01896	RDCK-011-00048	RDTK-031-00044	
19.74 - 20.77	0.7772 - 0.8177	1	RDKK-210-01974	RDKK-110-01974	RDCK-011-00050	RDTK-031-00050	RDYR-701-00218
		2	RDKK-220-01974	RDKK-120-01974	RDCK-011-00050	RDTK-031-00050	
		3	RDKK-230-01974	RDKK-130-01974	RDCK-011-00050	RDTK-031-00050	
20.52 - 21.57	0.8079 - 0.8492	1	RDKK-210-02052	RDKK-110-02052	RDCK-011-00052	RDTK-031-00052	RDYR-701-00218
		2	RDKK-220-02052	RDKK-120-02052	RDCK-011-00052	RDTK-031-00052	
		3	RDKK-230-02052	RDKK-130-02052	RDCK-011-00052	RDTK-031-00052	
21.31 - 22.35	0.8390 - 0.8799	1	RDKK-210-02131	RDKK-110-02131	RDCK-011-00054	RDTK-031-00054	RDYR-701-00218
		2	RDKK-220-02131	RDKK-120-02131	RDCK-011-00054	RDTK-031-00054	
		3	RDKK-230-02131	RDKK-130-02131	RDCK-011-00054	RDTK-031-00054	
22.13 - 23.16	0.8713 - 0.9118	1	RDKK-210-02213	RDKK-110-02213	RDCK-011-00056	RDTK-031-00050	RDYR-701-00265
		2	RDKK-220-02213	RDKK-120-02213	RDCK-011-00056	RDTK-031-00050	
		3	RDKK-230-02213	RDKK-130-02213	RDCK-011-00056	RDTK-031-00050	
22.91 - 23.96	0.9020 - 0.9433	1	RDKK-210-02291	RDKK-110-02291	RDCK-011-00058	RDTK-031-00052	RDYR-701-00265
		2	RDKK-220-02291	RDKK-120-02291	RDCK-011-00058	RDTK-031-00052	
		3	RDKK-230-02291	RDKK-130-02291	RDCK-011-00058	RDTK-031-00052	
23.70 - 24.74	0.9331 - 0.9740	1	RDKK-210-02370	RDKK-110-02370	RDCK-011-00060	RDTK-031-00054	RDYR-701-00265
		2	RDKK-220-02370	RDKK-120-02370	RDCK-011-00060	RDTK-031-00054	
		3	RDKK-230-02370	RDKK-130-02370	RDCK-011-00060	RDTK-031-00054	

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

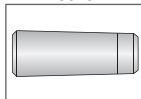
D00: 39 - 40



D00: 41 - 44



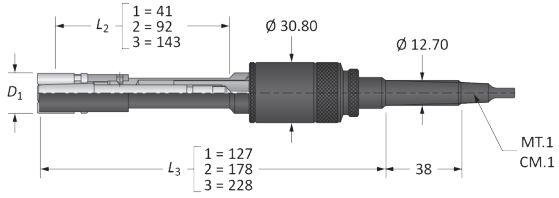
D00: 37





K Series: 16.60 mm - 24.74 mm (0.6535" - 0.9740")

Blind Holes



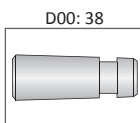
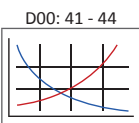
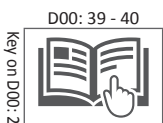
D00

D ₁		Part No.*			Spare Parts			
Metric (mm)	Imperial (in)	L	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
16.60 - 17.61	0.6535 - 0.6933	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00042	RSTK-03x-00042	RSRY-708-00187	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00042	RSTK-03x-00042		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00042	RSTK-03x-00042		
17.40 - 18.39	0.6850 - 0.7240	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00044	RSTK-03x-00044	RSRY-708-00187	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00044	RSTK-03x-00044		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00044	RSTK-03x-00044		
18.19 - 19.18	0.7161 - 0.7551	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00046	RSTK-03x-00042	RSRY-708-00218	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00046	RSTK-03x-00042		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00046	RSTK-03x-00042		
18.96 - 19.99	0.7465 - 0.7870	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00048	RSTK-03x-00044	RSRY-708-00218	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00048	RSTK-03x-00044		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00048	RSTK-03x-00044		
19.74 - 20.77	0.7772 - 0.8177	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00050	RSTK-03x-00050	RSRY-708-00218	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00050	RSTK-03x-00050		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00050	RSTK-03x-00050		
20.52 - 21.57	0.8079 - 0.8492	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00052	RSTK-03x-00052	RSRY-708-00218	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00052	RSTK-03x-00052		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00052	RSTK-03x-00052		
21.31 - 22.35	0.8390 - 0.8799	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00054	RSTK-03x-00054	RSRY-708-00218	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00054	RSTK-03x-00054		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00054	RSTK-03x-00054		
22.13 - 23.16	0.8713 - 0.9118	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00056	RSTK-03x-00050	RSRY-708-00265	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00056	RSTK-03x-00050		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00056	RSTK-03x-00050		
22.91 - 23.96	0.9020 - 0.9433	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00058	RSTK-03x-00052	RSRY-708-00265	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00058	RSTK-03x-00052		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00058	RSTK-03x-00052		
23.70 - 24.74	0.9331 - 0.9740	1	RSKK-210-xxxxx	RSKK-110-xxxxx	RSCK-015-00060	RSTK-03x-00054	RSRY-708-00265	5
		2	RSKK-220-xxxxx	RSKK-120-xxxxx	RSCK-015-00060	RSTK-03x-00054		
		3	RSKK-230-xxxxx	RSKK-130-xxxxx	RSCK-015-00060	RSTK-03x-00054		

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. standard series roller burnisher Ø 20.00 mm with MT.1 shank: RSCK-120-02000).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

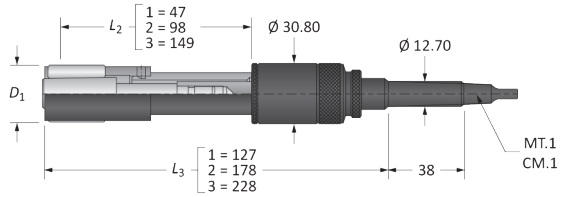


Key on D00: 2

**L Series: 24.54 mm - 31.16 mm (0.9661" - 1.2268")**

Through Holes

D00



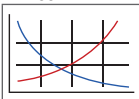
D_1		L	Part No.		Spare Parts		Rolls Part No.	Qty
Metric (mm)	Imperial (in)		Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone		
24.54 - 25.59	0.9661 - 1.0075	1	RDKL-210-02454	RDKL-110-02454	RDCL-011-00062	RDTL-031-00062	RDRY-701-00265	5
		2	RDKL-220-02454	RDKL-120-02454	RDCL-011-00062	RDTL-031-00062		
		3	RDKL-230-02454	RDKL-130-02454	RDCL-011-00062	RDTL-031-00062		
25.38 - 26.42	0.9992 - 1.0402	1	RDKL-210-02538	RDKL-110-02538	RDCL-011-00064	RDTL-031-00064	RDRY-701-00265	7
		2	RDKL-220-02538	RDKL-120-02538	RDCL-011-00064	RDTL-031-00064		
		3	RDKL-230-02538	RDKL-130-02538	RDCL-011-00064	RDTL-031-00064		
26.16 - 27.20	1.0299 - 1.0709	1	RDKL-210-02616	RDKL-110-02616	RDCL-011-00066	RDTL-031-00066	RDRY-701-00265	7
		2	RDKL-220-02616	RDKL-120-02616	RDCL-011-00066	RDTL-031-00066		
		3	RDKL-230-02616	RDKL-130-02616	RDCL-011-00066	RDTL-031-00066		
26.95 - 28.00	1.0610 - 1.1024	1	RDKL-210-02695	RDKL-110-02695	RDCL-011-00068	RDTL-031-00068	RDRY-701-00265	7
		2	RDKL-220-02695	RDKL-120-02695	RDCL-011-00068	RDTL-031-00068		
		3	RDKL-230-02695	RDKL-130-02695	RDCL-011-00068	RDTL-031-00068		
27.73 - 28.77	1.0917 - 1.1327	1	RDKL-210-02773	RDKL-110-02773	RDCL-011-00070	RDTL-031-00070	RDRY-701-00265	7
		2	RDKL-220-02773	RDKL-120-02773	RDCL-011-00070	RDTL-031-00070		
		3	RDKL-230-02773	RDKL-130-02773	RDCL-011-00070	RDTL-031-00070		
28.55 - 29.59	1.1240 - 1.1650	1	RDKL-210-02855	RDKL-110-02855	RDCL-011-00072	RDTL-031-00066	RDRY-701-00312	7
		2	RDKL-220-02855	RDKL-120-02855	RDCL-011-00072	RDTL-031-00066		
		3	RDKL-230-02855	RDKL-130-02855	RDCL-011-00072	RDTL-031-00066		
29.34 - 30.39	1.1551 - 1.1965	1	RDKL-210-02934	RDKL-110-02934	RDCL-011-00074	RDTL-031-00068	RDRY-701-00312	7
		2	RDKL-220-02934	RDKL-120-02934	RDCL-011-00074	RDTL-031-00068		
		3	RDKL-230-02934	RDKL-130-02934	RDCL-011-00074	RDTL-031-00068		
30.12 - 31.16	1.1858 - 1.2268	1	RDKL-210-03012	RDKL-110-03012	RDCL-011-00076	RDTL-031-00070	RDRY-701-00312	7
		2	RDKL-220-03012	RDKL-120-03012	RDCL-011-00076	RDTL-031-00070		
		3	RDKL-230-03012	RDKL-130-03012	RDCL-011-00076	RDTL-031-00070		

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

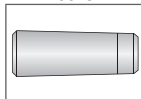
D00: 39 - 40



D00: 41 - 44



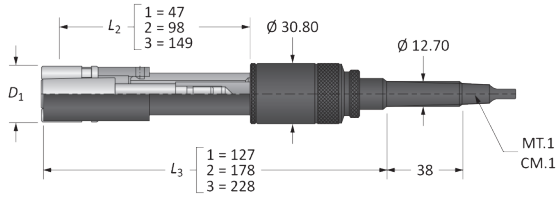
D00: 37





L Series: 24.54 mm - 31.16 mm (0.9661" - 1.2268")

Blind Holes



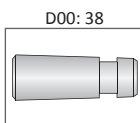
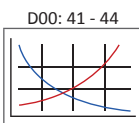
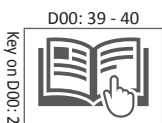
D00

D ₁		Part No.*			Spare Parts			
Metric (mm)	Imperial (in)	L	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
24.54 - 25.59	0.9661 - 1.0075	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00062	RSTL-03x-00062	RSRY-708-00265	5
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00062	RSTL-03x-00062		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00062	RSTL-03x-00062		
25.38 - 26.42	0.9992 - 1.0402	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00064	RSTL-03x-00064	RSRY-708-00265	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00064	RSTL-03x-00064		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00064	RSTL-03x-00064		
26.16 - 27.20	1.0299 - 1.0709	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00066	RSTL-03x-00066	RSRY-708-00265	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00066	RSTL-03x-00066		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00066	RSTL-03x-00066		
26.95 - 28.00	1.0610 - 1.1024	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00068	RSTL-03x-00068	RSRY-708-00265	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00068	RSTL-03x-00068		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00068	RSTL-03x-00068		
27.73 - 28.77	1.0917 - 1.1327	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00070	RSTL-03x-00070	RSRY-708-00265	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00070	RSTL-03x-00070		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00070	RSTL-03x-00070		
28.55 - 29.59	1.1240 - 1.1650	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00072	RSTL-03x-00066	RSRY-708-00312	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00072	RSTL-03x-00066		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00072	RSTL-03x-00066		
29.34 - 30.39	1.1551 - 1.1965	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00074	RSTL-03x-00068	RSRY-708-00312	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00074	RSTL-03x-00068		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00074	RSTL-03x-00068		
30.12 - 31.16	1.1858 - 1.2268	1	RSKL-210-xxxxx	RSKL-110-xxxxx	RSCL-015-00076	RSTL-03x-00070	RSRY-708-00312	7
		2	RSKL-220-xxxxx	RSKL-120-xxxxx	RSCL-015-00076	RSTL-03x-00070		
		3	RSKL-230-xxxxx	RSKL-130-xxxxx	RSCL-015-00076	RSTL-03x-00070		

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. short series roller burnisher $\varnothing 27.50$ mm with MT.1 shank: RSKL-210-02750).

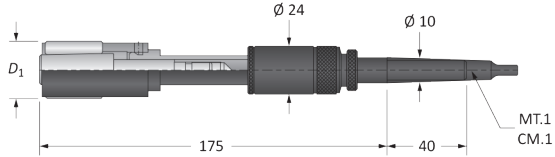
** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

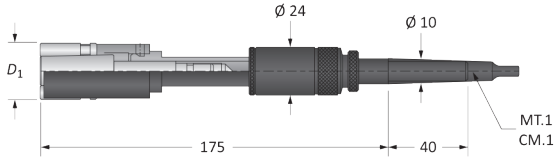


**F Series: 24.54 mm - 31.16 mm (0.9661" - 1.2268")**

D00

**Through Holes**

D ₁		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
24.54 - 25.59	0.9661 - 1.0075	RDKF-200-02454	RDKF-100-02454	RDCL-011-00062	RDTF-031-00062	RDRY-701-00265	5
25.38 - 26.42	0.9992 - 1.0402	RDKF-200-02538	RDKF-100-02538	RDCL-011-00064	RDTF-031-00064	RDRY-701-00265	7
26.16 - 27.20	1.0299 - 1.0709	RDKF-200-02616	RDKF-100-02616	RDCL-011-00066	RDTF-031-00066	RDRY-701-00265	7
26.95 - 28.00	1.0610 - 1.1024	RDKF-200-02695	RDKF-100-02695	RDCL-011-00068	RDTF-031-00068	RDRY-701-00265	7
27.73 - 28.77	1.0917 - 1.1327	RDKF-200-02773	RDKF-100-02773	RDCL-011-00070	RDTF-031-00070	RDRY-701-00265	7
28.55 - 29.59	1.1240 - 1.1650	RDKF-200-02855	RDKF-100-02855	RDCL-011-00072	RDTF-031-00066	RDRY-701-00312	7
29.34 - 30.39	1.1551 - 1.1965	RDKF-200-02934	RDKF-100-02934	RDCL-011-00074	RDTF-031-00068	RDRY-701-00312	7
30.12 - 31.16	1.1858 - 1.2268	RDKF-200-03012	RDKF-100-03012	RDCL-011-00076	RDTF-031-00070	RDRY-701-00312	7

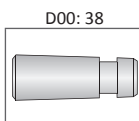
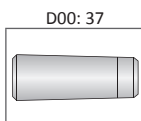
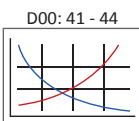
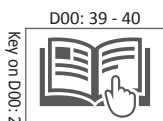
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.**Blind Holes**

D ₁		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
24.54 - 25.59	0.9661 - 1.0075	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00062	RSTF-03x-00062	RSRY-708-00265	5
25.38 - 26.42	0.9992 - 1.0402	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00064	RSTF-03x-00064	RSRY-708-00265	5
26.16 - 27.20	1.0299 - 1.0709	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00066	RSTF-03x-00066	RSRY-708-00265	5
26.95 - 28.00	1.0610 - 1.1024	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00068	RSTF-03x-00068	RSRY-708-00265	5
27.73 - 28.77	1.0917 - 1.1327	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00070	RSTF-03x-00070	RSRY-708-00265	5
28.55 - 29.59	1.1240 - 1.1650	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00072	RSTF-03x-00066	RSRY-708-00312	5
29.34 - 30.39	1.1551 - 1.1965	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00074	RSTF-03x-00068	RSRY-708-00312	5
30.12 - 31.16	1.1858 - 1.2268	RSKF-200-xxxxx	RSKF-100-xxxxx	RSCL-015-00076	RSTF-03x-00070	RSRY-708-00312	5

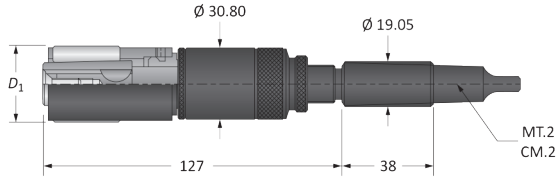
* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher Ø 27.00 mm with

MT.1 shank: RSKF-200-02700).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

M Series: 30.85 mm - 35.86 mm (1.2146" - 1.4118")

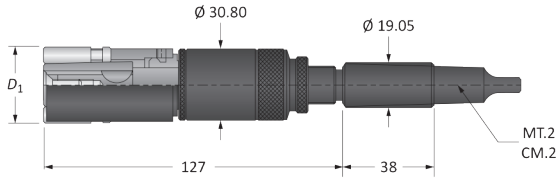


D00

Through Holes

D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
30.85 - 31.90	1.2146 - 1.2559	RDKM-200-03085	RDKM-100-03085	RDCM-011-00078	RDTM-031-00078	RDRY-701-00265	7
31.67 - 32.71	1.2469 - 1.2878	RDKM-200-03167	RDKM-100-03167	RDCM-011-00080	RDTM-031-00080	RDRY-701-00265	7
32.44 - 33.47	1.2772 - 1.3177	RDKM-200-03244	RDKM-100-03244	RDCM-011-00082	RDTM-031-00082	RDRY-701-00265	7
33.24 - 34.29	1.3087 - 1.3500	RDKM-200-03324	RDKM-100-03324	RDCM-011-00084	RDTM-031-00078	RDRY-701-00312	7
34.05 - 35.09	1.3406 - 1.3815	RDKM-200-03405	RDKM-100-03405	RDCM-011-00086	RDTM-031-00080	RDRY-701-00312	7
34.83 - 35.86	1.3713 - 1.4118	RDKM-200-03483	RDKM-100-03483	RDCM-011-00088	RDTM-031-00082	RDRY-701-00312	7

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



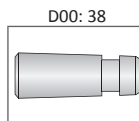
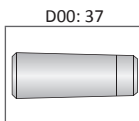
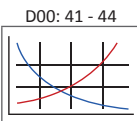
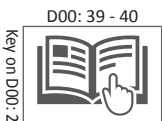
Blind Holes

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
30.85 - 31.90	1.2146 - 1.2559	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00078	RSTM-03x-00078	RSRY-708-00265	5
31.67 - 32.71	1.2469 - 1.2878	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00080	RSTM-03x-00080	RSRY-708-00265	5
32.44 - 33.47	1.2772 - 1.3177	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00082	RSTM-03x-00082	RSRY-708-00265	5
33.24 - 34.29	1.3087 - 1.3500	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00084	RSTM-03x-00078	RSRY-708-00312	5
34.05 - 35.09	1.3406 - 1.3815	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00086	RSTM-03x-00080	RSRY-708-00312	5
34.83 - 35.86	1.3713 - 1.4118	RSKM-200-xxxxx	RSKM-100-xxxxx	RSCM-015-00088	RSTM-03x-00082	RSRY-708-00312	5

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 35.00 mm with MT.2 shank: RSKM-200-03500).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

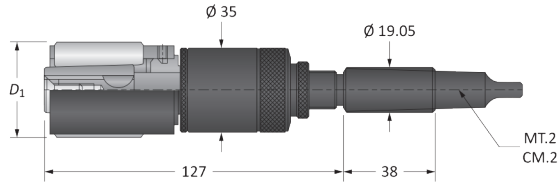


Key on D00: 2

**N Series: 35.61 mm - 46.97 mm (1.4020" - 1.8492")**

Through Holes

D00



D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
35.61 - 36.66	1.4020 - 1.4433	RDKN-200-03561	RDKN-100-03561	RDCN-011-00090	RDTN-031-00090	RDRY-701-00312	7
36.40 - 37.44	1.4331 - 1.4740	RDKN-200-03640	RDKN-100-03640	RDCN-011-00092	RDTN-031-00092	RDRY-701-00312	7
37.18 - 38.23	1.4638 - 1.5051	RDKN-200-03718	RDKN-100-03718	RDCN-011-00094	RDTN-031-00094	RDRY-701-00312	7
38.00 - 39.04	1.4961 - 1.5370	RDKN-200-03800	RDKN-100-03800	RDCN-011-00096	RDTN-031-00096	RDRY-701-00312	7
38.79 - 39.82	1.5272 - 1.5677	RDKN-200-03879	RDKN-100-03879	RDCN-011-00098	RDTM-031-00080	RDRY-701-00406	7
39.57 - 40.62	1.5579 - 1.5992	RDKN-200-03957	RDKN-100-03957	RDCN-011-00100	RDTM-031-00082	RDRY-701-00406	7
40.36 - 41.40	1.5890 - 1.6299	RDKN-200-04036	RDKN-100-04036	RDCN-011-00102	RDTN-031-00090	RDRY-701-00406	7
41.18 - 42.21	1.6213 - 1.6618	RDKN-200-04118	RDKN-100-04118	RDCN-011-00104	RDTN-031-00092	RDRY-701-00406	7
41.96 - 43.01	1.6520 - 1.6933	RDKN-200-04196	RDKN-100-04196	RDCN-011-00106	RDTN-031-00094	RDRY-701-00406	7
42.75 - 43.79	1.6831 - 1.7240	RDKN-200-04275	RDKN-100-04275	RDCN-011-00108	RDTM-031-00082	RDRY-701-00468	7
43.53 - 44.58	1.7138 - 1.7551	RDKN-200-04353	RDKN-100-04353	RDCN-011-00110	RDTN-031-00090	RDRY-701-00468	7
44.35 - 45.39	1.7461 - 1.7870	RDKN-200-04435	RDKN-100-04435	RDCN-011-00112	RDTN-031-00092	RDRY-701-00468	7
45.14 - 46.17	1.7772 - 1.8177	RDKN-200-04514	RDKN-100-04514	RDCN-011-00114	RDTN-031-00094	RDRY-701-00468	7
45.92 - 46.97	1.8079 - 1.8492	RDKN-200-04592	RDKN-100-04592	RDCN-011-00116	RDTN-031-00096	RDRY-701-00468	7

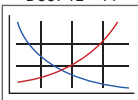
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

D00: 39 - 40

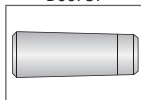


Key on D00: 2

D00: 41 - 44



D00: 37

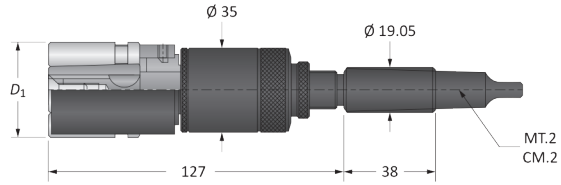




N Series: 35.61 mm - 46.97 mm (1.4020" - 1.8492")

Blind Holes

D00

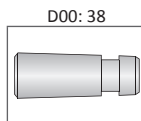
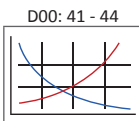
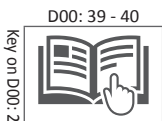


D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
35.61 - 36.66	1.4020 - 1.4433	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00090	RSTN-03x-00090	RSRY-708-00312	5
36.40 - 37.44	1.4331 - 1.4740	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00092	RSTN-03x-00092	RSRY-708-00312	5
37.18 - 38.23	1.4638 - 1.5051	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00094	RSTN-03x-00094	RSRY-708-00312	5
38.00 - 39.04	1.4961 - 1.5370	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00096	RSTN-03x-00096	RSRY-708-00312	5
38.79 - 39.82	1.5272 - 1.5677	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00098	RSTM-03x-00080	RSRY-708-00406	5
39.57 - 40.62	1.5579 - 1.5992	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00100	RSTM-03x-00082	RSRY-708-00406	5
40.36 - 41.40	1.5890 - 1.6299	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00102	RSTN-03x-00090	RSRY-708-00406	5
41.18 - 42.21	1.6213 - 1.6618	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00104	RSTN-03x-00092	RSRY-708-00406	5
41.96 - 43.01	1.6520 - 1.6933	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00106	RSTN-03x-00094	RSRY-708-00406	5
42.75 - 43.79	1.6831 - 1.7240	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00108	RSTM-03x-00082	RSRY-708-00468	5
43.53 - 44.58	1.7138 - 1.7551	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00110	RSTN-03x-00090	RSRY-708-00468	5
44.35 - 45.39	1.7461 - 1.7870	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00112	RSTN-03x-00092	RSRY-708-00468	5
45.14 - 46.17	1.7772 - 1.8177	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00114	RSTN-03x-00094	RSRY-708-00468	5
45.92 - 46.97	1.8079 - 1.8492	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00116	RSTN-03x-00096	RSRY-708-00468	5

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 40.00 mm with straight shank: RSKN-100-04000).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

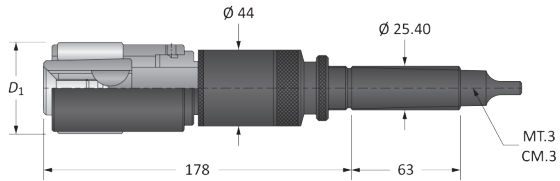
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



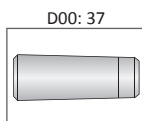
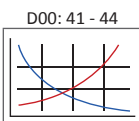
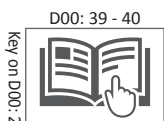
**O Series: 46.71 mm - 56.49 mm (1.8390" - 2.2240")**

Through Holes

D00



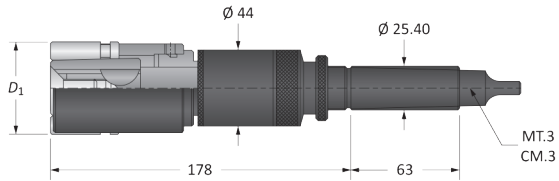
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
46.71 - 47.75	1.8390 - 1.8799	RDKO-200-04671	RDKO-100-04671	RDCO-011-00118	RDTO-031-00118	RDRY-701-00312	9
47.53 - 48.56	1.8713 - 1.9118	RDKO-200-04753	RDKO-100-04753	RDCO-011-00120	RDTO-031-00120	RDRY-701-00312	9
48.31 - 49.36	1.9020 - 1.9433	RDKO-200-04831	RDKO-100-04831	RDCO-011-00122	RDTO-031-00122	RDRY-701-00312	9
49.10 - 50.14	1.9331 - 1.9740	RDKO-200-04910	RDKO-100-04910	RDCO-011-00124	RDTO-031-00124	RDRY-701-00312	9
49.88 - 50.93	1.9638 - 2.0051	RDKO-200-04988	RDKO-100-04988	RDCO-011-00126	RDTO-031-00126	RDRY-701-00312	9
50.70 - 51.74	1.9961 - 2.0370	RDKO-200-05070	RDKO-100-05070	RDCO-011-00128	RDTO-031-00128	RDRY-701-00312	9
51.49 - 52.53	2.0272 - 2.0681	RDKO-200-05149	RDKO-100-05149	RDCO-011-00130	RDTO-031-00118	RDRY-701-00406	9
52.27 - 53.32	2.0579 - 2.0992	RDKO-200-05227	RDKO-100-05227	RDCO-011-00132	RDTO-031-00120	RDRY-701-00406	9
53.06 - 54.10	2.0890 - 2.1299	RDKO-200-05306	RDKO-100-05306	RDCO-011-00134	RDTO-031-00122	RDRY-701-00406	9
53.87 - 54.91	2.1209 - 2.1618	RDKO-200-05387	RDKO-100-05387	RDCO-011-00136	RDTO-031-00124	RDRY-701-00406	9
54.66 - 55.71	2.1520 - 2.1933	RDKO-200-05466	RDKO-100-05466	RDCO-011-00138	RDTO-031-00126	RDRY-701-00406	9
55.45 - 56.49	2.1831 - 2.2240	RDKO-200-05545	RDKO-100-05545	RDCO-011-00140	RDTO-031-00128	RDRY-701-00406	9

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



O Series: 46.71 mm - 56.49 mm (1.8390" - 2.2240")

Blind Holes



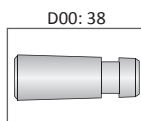
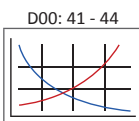
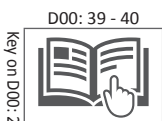
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
46.71 - 47.75	1.8390 - 1.8799	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00118	RSTO-03x-00118	RSRY-708-00312	7
47.53 - 48.56	1.8713 - 1.9118	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00120	RSTO-03x-00120	RSRY-708-00312	7
48.31 - 49.36	1.9020 - 1.9433	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00122	RSTO-03x-00122	RSRY-708-00312	7
49.10 - 50.14	1.9331 - 1.9740	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00124	RSTO-03x-00124	RSRY-708-00312	7
49.88 - 50.93	1.9638 - 2.0051	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00126	RSTO-03x-00126	RSRY-708-00312	7
50.70 - 51.74	1.9961 - 2.0370	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00128	RSTO-03x-00128	RSRY-708-00312	7
51.49 - 52.53	2.0272 - 2.0681	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00130	RSTO-03x-00118	RSRY-708-00406	7
52.27 - 53.32	2.0579 - 2.0992	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00132	RSTO-03x-00120	RSRY-708-00406	7
53.06 - 54.10	2.0890 - 2.1299	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00134	RSTO-03x-00122	RSRY-708-00406	7
53.87 - 54.91	2.1209 - 2.1618	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00136	RSTO-03x-00124	RSRY-708-00406	7
54.66 - 55.71	2.1520 - 2.1933	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00138	RSTO-03x-00126	RSRY-708-00406	7
55.45 - 56.49	2.1831 - 2.2240	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00140	RSTO-03x-00128	RSRY-708-00406	7

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher Ø 50.25 mm with MT.3 shank: RSKO-200-05025).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

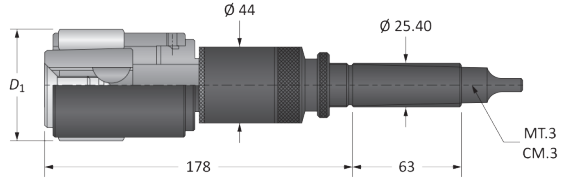
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



**P Series: 56.23 mm - 69.19 mm (2.2138" - 2.7240")**

Through Holes

D00



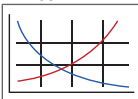
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
56.23 - 57.28	2.2138 - 2.2551	RDKP-200-05623	RDKP-100-05623	RDCP-011-00142	RDTP-031-00142	RDRY-701-00406	9
57.05 - 58.09	2.2461 - 2.2870	RDKP-200-05705	RDKP-100-05705	RDCP-011-00144	RDTP-031-00144	RDRY-701-00406	9
57.84 - 58.87	2.2772 - 2.3177	RDKP-200-05784	RDKP-100-05784	RDCP-011-00146	RDTP-031-00146	RDRY-701-00406	9
58.62 - 59.67	2.3079 - 2.3492	RDKP-200-05862	RDKP-100-05862	RDCP-011-00148	RDTP-031-00148	RDRY-701-00406	9
59.41 - 60.45	2.3390 - 2.3799	RDKP-200-05941	RDKP-100-05941	RDCP-011-00150	RDTP-031-00142	RDRY-701-00468	9
60.23 - 61.26	2.3713 - 2.4118	RDKP-200-06023	RDKP-100-06023	RDCP-011-00152	RDTP-031-00144	RDRY-701-00468	9
61.01 - 62.06	2.4020 - 2.4433	RDKP-200-06101	RDKP-100-06101	RDCP-011-00154	RDTP-031-00146	RDRY-701-00468	9
61.80 - 62.84	2.4330 - 2.4740	RDKP-200-06180	RDKP-100-06180	RDCP-011-00156	RDTP-031-00148	RDRY-701-00468	9
62.58 - 63.63	2.4638 - 2.5051	RDKP-200-06258	RDKP-100-06258	RDCP-011-00158	RDTP-031-00158	RDRY-701-00468	9
63.40 - 64.44	2.4961 - 2.5370	RDKP-200-06340	RDKP-100-06340	RDCP-011-00160	RDTP-031-00160	RDRY-701-00468	9
64.19 - 65.22	2.5272 - 2.5677	RDKP-200-06419	RDKP-100-06419	RDCP-011-00162	RDTP-031-00162	RDRY-701-00468	9
64.97 - 66.02	2.5579 - 2.5992	RDKP-200-06497	RDKP-100-06497	RDCP-011-00164	RDTP-031-00164	RDRY-701-00468	9
65.76 - 66.80	2.5890 - 2.6299	RDKP-200-06576	RDKP-100-06576	RDCP-011-00166	RDTP-031-00158	RDRY-701-00531	9
66.58 - 67.61	2.6213 - 2.6618	RDKP-200-06658	RDKP-100-06658	RDCP-011-00168	RDTP-031-00160	RDRY-701-00531	9
67.36 - 68.41	2.6520 - 2.6933	RDKP-200-06736	RDKP-100-06736	RDCP-011-00170	RDTP-031-00162	RDRY-701-00531	9
68.15 - 69.19	2.6830 - 2.7240	RDKP-200-06815	RDKP-100-06815	RDCP-011-00172	RDTP-031-00164	RDRY-701-00531	9

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

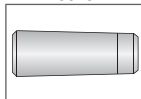
D00: 39 - 40



D00: 41 - 44



D00: 37

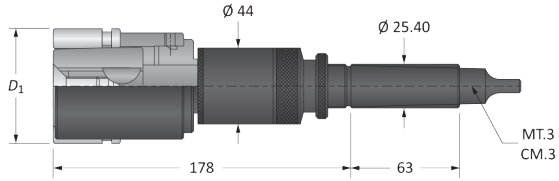




P Series: 56.23 mm - 69.19 mm (2.2138" - 2.7240")

Blind Holes

D00

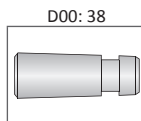
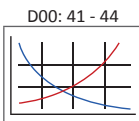
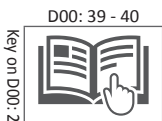


D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
56.23 - 57.28	2.2138 - 2.2551	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00142	RSTP-03x-00142	RSRY-708-00406	7
57.05 - 58.09	2.2461 - 2.2870	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00144	RSTP-03x-00144	RSRY-708-00406	7
57.84 - 58.87	2.2772 - 2.3177	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00146	RSTP-03x-00146	RSRY-708-00406	7
58.62 - 59.67	2.3079 - 2.3492	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00148	RSTP-03x-00148	RSRY-708-00406	7
59.41 - 60.45	2.3390 - 2.3799	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00150	RSTP-03x-00142	RSRY-708-00468	7
60.23 - 61.26	2.3713 - 2.4118	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00152	RSTP-03x-00144	RSRY-708-00468	7
61.01 - 62.06	2.4020 - 2.4433	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00154	RSTP-03x-00146	RSRY-708-00468	7
61.80 - 62.84	2.4330 - 2.4740	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00156	RSTP-03x-00148	RSRY-708-00468	7
62.58 - 63.63	2.4638 - 2.5051	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00158	RSTP-03x-00158	RSRY-708-00468	7
63.40 - 64.44	2.4961 - 2.5370	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00160	RSTP-03x-00160	RSRY-708-00468	7
64.19 - 65.22	2.5272 - 2.5677	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00162	RSTP-03x-00162	RSRY-708-00468	7
64.97 - 66.02	2.5579 - 2.5992	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00164	RSTP-03x-00164	RSRY-708-00468	7
65.76 - 66.80	2.5890 - 2.6299	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00166	RSTP-03x-00158	RSRY-708-00531	7
66.58 - 67.61	2.6213 - 2.6618	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00168	RSTP-03x-00160	RSRY-708-00531	7
67.36 - 68.41	2.6520 - 2.6933	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00170	RSTP-03x-00162	RSRY-708-00531	7
68.15 - 69.19	2.6830 - 2.7240	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00172	RSTP-03x-00164	RSRY-708-00531	7

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher Ø 60.05 mm with straight shank: RSKP-100-06005).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

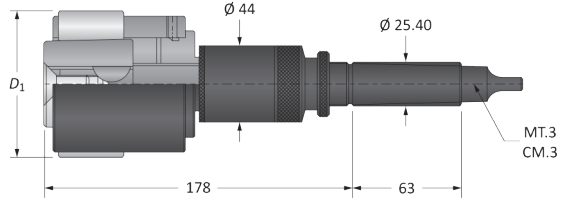
NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



**Q Series: 68.93 mm - 85.07 mm (2.7138" - 3.3492")**

Through Holes

D00



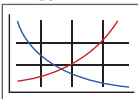
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
68.93 - 69.98	2.7138 - 2.7551	RDQ-200-06893	RDQ-100-06893	RDCQ-011-00174	RDTQ-031-00174	RDRY-701-00531	9
69.75 - 70.79	2.7461 - 2.7870	RDQ-200-06975	RDQ-100-06975	RDCQ-011-00176	RDTQ-031-00176	RDRY-701-00531	9
70.54 - 71.57	2.7772 - 2.8177	RDQ-200-07054	RDQ-100-07054	RDCQ-011-00178	RDTQ-031-00178	RDRY-701-00531	9
71.32 - 72.40	2.8079 - 2.8504	RDQ-200-07132	RDQ-100-07132	RDCQ-011-00180	RDTQ-031-00180	RDRY-701-00531	9
72.11 - 73.15	2.8390 - 2.8799	RDQ-200-07211	RDQ-100-07211	RDCQ-011-00182	RDTQ-031-00182	RDRY-701-00531	9
72.93 - 73.96	2.8713 - 2.9118	RDQ-200-07293	RDQ-100-07293	RDCQ-011-00184	RDTQ-031-00184	RDRY-701-00531	9
73.71 - 74.75	2.9020 - 2.9429	RDQ-200-07371	RDQ-100-07371	RDCQ-011-00186	RDTQ-031-00174	RDRY-701-00625	9
74.50 - 75.54	2.9331 - 2.9740	RDQ-200-07450	RDQ-100-07450	RDCQ-011-00188	RDTQ-031-00176	RDRY-701-00625	9
75.28 - 76.33	2.9638 - 3.0051	RDQ-200-07528	RDQ-100-07528	RDCQ-011-00190	RDTQ-031-00178	RDRY-701-00625	9
76.10 - 77.14	2.9961 - 3.0370	RDQ-200-07610	RDQ-100-07610	RDCQ-011-00192	RDTQ-031-00180	RDRY-701-00625	9
76.89 - 77.93	3.0272 - 3.0681	RDQ-200-07689	RDQ-100-07689	RDCQ-011-00194	RDTQ-031-00182	RDRY-701-00625	9
77.67 - 78.72	3.0579 - 3.0992	RDQ-200-07767	RDQ-100-07767	RDCQ-011-00196	RDTQ-031-00184	RDRY-701-00625	9
78.46 - 79.50	3.0890 - 3.1299	RDQ-200-07846	RDQ-100-07846	RDCQ-011-00198	RDTQ-031-00198	RDRY-701-00625	9
79.27 - 80.31	3.1209 - 3.1618	RDQ-200-07927	RDQ-100-07927	RDCQ-011-00200	RDTQ-031-00200	RDRY-701-00625	9
80.06 - 81.11	3.1520 - 3.1933	RDQ-200-08006	RDQ-100-08006	RDCQ-011-00202	RDTQ-031-00202	RDRY-701-00625	9
80.85 - 81.89	3.1831 - 3.2240	RDQ-200-08085	RDQ-100-08085	RDCQ-011-00204	RDTQ-031-00204	RDRY-701-00625	9
81.63 - 82.68	3.2138 - 3.2551	RDQ-200-08163	RDQ-100-08163	RDCQ-011-00206	RDTQ-031-00198	RDRY-701-00687	9
82.45 - 83.49	3.2461 - 3.2870	RDQ-200-08245	RDQ-100-08245	RDCQ-011-00208	RDTQ-031-00200	RDRY-701-00687	9
83.24 - 84.27	3.2772 - 3.3177	RDQ-200-08324	RDQ-100-08324	RDCQ-011-00210	RDTQ-031-00202	RDRY-701-00687	9
84.02 - 85.07	3.3079 - 3.3492	RDQ-200-08402	RDQ-100-08402	RDCQ-011-00212	RDTQ-031-00204	RDRY-701-00687	9

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

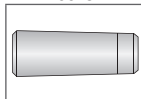
D00: 39 - 40



D00: 41 - 44



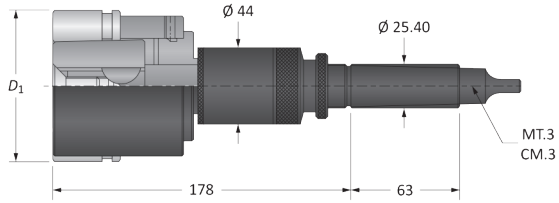
D00: 37





Q Series: 68.93 mm - 85.07 mm (2.7138" - 3.3492")

Blind Holes



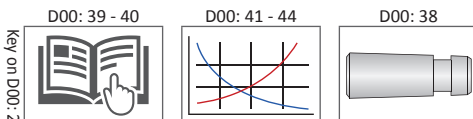
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
68.93 - 69.98	2.7138 - 2.7551	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00174	RSTQ-03x-00174	RSRY-708-00531	7
69.75 - 70.79	2.7461 - 2.7870	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00176	RSTQ-03x-00176	RSRY-708-00531	7
70.54 - 71.57	2.7772 - 2.8177	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00178	RSTQ-03x-00178	RSRY-708-00531	7
71.32 - 72.40	2.8079 - 2.8504	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00180	RSTQ-03x-00180	RSRY-708-00531	7
72.11 - 73.15	2.8390 - 2.8799	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00182	RSTQ-03x-00182	RSRY-708-00531	7
72.93 - 73.96	2.8713 - 2.9118	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00184	RSTQ-03x-00184	RSRY-708-00531	7
73.71 - 74.75	2.9020 - 2.9429	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00186	RSTQ-03x-00174	RSRY-708-00625	7
74.50 - 75.54	2.9331 - 2.9740	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00188	RSTQ-03x-00176	RSRY-708-00625	7
75.28 - 76.33	2.9638 - 3.0051	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00190	RSTQ-03x-00178	RSRY-708-00625	7
76.10 - 77.14	2.9961 - 3.0370	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00192	RSTQ-03x-00180	RSRY-708-00625	7
76.89 - 77.93	3.0272 - 3.0681	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00194	RSTQ-03x-00182	RSRY-708-00625	7
77.67 - 78.72	3.0579 - 3.0992	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00196	RSTQ-03x-00184	RSRY-708-00625	7
78.46 - 79.50	3.0890 - 3.1299	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00198	RSTQ-03x-00198	RSRY-708-00625	7
79.27 - 80.31	3.1209 - 3.1618	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00200	RSTQ-03x-00200	RSRY-708-00625	7
80.06 - 81.11	3.1520 - 3.1933	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00202	RSTQ-03x-00202	RSRY-708-00625	7
80.85 - 81.89	3.1831 - 3.2240	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00204	RSTQ-03x-00204	RSRY-708-00625	7
81.63 - 82.68	3.2138 - 3.2551	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00206	RSTQ-03x-00198	RSRY-708-00687	7
82.45 - 83.49	3.2461 - 3.2870	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00208	RSTQ-03x-00200	RSRY-708-00687	7
83.24 - 84.27	3.2772 - 3.3177	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00210	RSTQ-03x-00202	RSRY-708-00687	7
84.02 - 85.07	3.3079 - 3.3492	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00212	RSTQ-03x-00204	RSRY-708-00687	7

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher Ø 75.00 mm with MT.3 shank: RSKQ-200-07500).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

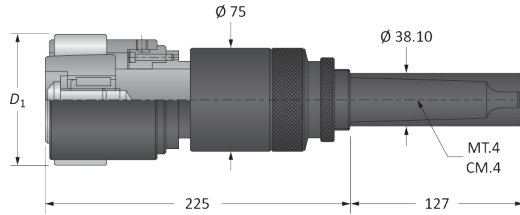


Key on D00: 2

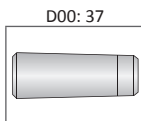
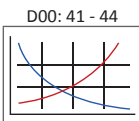
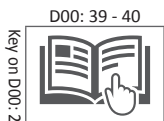
**R Series: 84.81 mm - 104.12 mm (3.3390" - 4.0992")**

Through Holes

D00



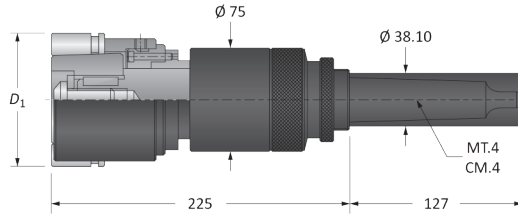
D ₁		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
84.81 - 85.85	3.3390 - 3.3799	RDKR-200-08481	RDKR-100-08481	RDCR-011-00214	RDTR-073-00001	RDRY-701-00468	9
85.63 - 86.66	3.3713 - 3.4118	RDKR-200-08563	RDKR-100-08563	RDCR-011-00216	RDTR-074-00001	RDRY-701-00468	9
86.41 - 87.45	3.4020 - 3.4429	RDKR-200-08641	RDKR-100-08641	RDCR-011-00218	RDTR-071-00001	RDRY-701-00531	9
87.20 - 88.24	3.4331 - 3.4740	RDKR-200-08720	RDKR-100-08720	RDCR-011-00220	RDTR-072-00001	RDRY-701-00531	9
87.99 - 89.03	3.4642 - 3.5051	RDKR-200-08799	RDKR-100-08799	RDCR-011-00222	RDTR-073-00001	RDRY-701-00531	9
88.79 - 89.84	3.4957 - 3.5370	RDKR-200-08879	RDKR-100-08879	RDCR-011-00224	RDTR-074-00001	RDRY-701-00531	9
89.59 - 90.63	3.5272 - 3.5681	RDKR-200-08959	RDKR-100-08959	RDCR-011-00226	RDTR-075-00001	RDRY-701-00531	9
90.37 - 91.42	3.5579 - 3.5992	RDKR-200-09037	RDKR-100-09037	RDCR-011-00228	RDTR-076-00001	RDRY-701-00531	9
91.16 - 92.20	3.5890 - 3.6299	RDKR-200-09116	RDKR-100-09116	RDCR-011-00230	RDTR-071-00001	RDRY-701-00625	9
91.97 - 93.02	3.6209 - 3.6622	RDKR-200-09197	RDKR-100-09197	RDCR-011-00232	RDTR-072-00001	RDRY-701-00625	9
92.76 - 93.80	3.6520 - 3.6929	RDKR-200-09276	RDKR-100-09276	RDCR-011-00234	RDTR-073-00001	RDRY-701-00625	9
93.55 - 94.59	3.6831 - 3.7240	RDKR-200-09355	RDKR-100-09355	RDCR-011-00236	RDTR-074-00001	RDRY-701-00625	9
94.34 - 95.38	3.7142 - 3.7551	RDKR-200-09434	RDKR-100-09434	RDCR-011-00238	RDTR-075-00001	RDRY-701-00625	9
95.15 - 96.19	3.7461 - 3.7870	RDKR-200-09515	RDKR-100-09515	RDCR-011-00240	RDTR-076-00001	RDRY-701-00625	9
95.94 - 96.98	3.7772 - 3.8181	RDKR-200-09594	RDKR-100-09594	RDCR-011-00242	RDTR-077-00001	RDRY-701-00625	9
96.72 - 97.77	3.8079 - 3.8492	RDKR-200-09672	RDKR-100-09672	RDCR-011-00244	RDTR-078-00001	RDRY-701-00625	9
97.51 - 98.55	3.8390 - 3.8799	RDKR-200-09751	RDKR-100-09751	RDCR-011-00246	RDTR-075-00001	RDRY-701-00687	9
98.32 - 99.37	3.8709 - 3.9122	RDKR-200-09832	RDKR-100-09832	RDCR-011-00248	RDTR-076-00001	RDRY-701-00687	9
99.11 - 100.15	3.9020 - 3.9429	RDKR-200-09911	RDKR-100-09911	RDCR-011-00250	RDTR-077-00001	RDRY-701-00687	9
99.90 - 100.94	3.9331 - 3.9740	RDKR-200-09990	RDKR-100-09990	RDCR-011-00252	RDTR-078-00001	RDRY-701-00687	9
100.69 - 101.73	3.9642 - 4.0051	RDKR-200-10069	RDKR-100-10069	RDCR-011-00254	RDTR-079-00001	RDRY-701-00687	9
101.50 - 102.54	3.9961 - 4.0370	RDKR-200-10150	RDKR-100-10150	RDCR-011-00256	RDTR-080-00001	RDRY-701-00687	9
102.29 - 103.33	4.0272 - 4.0681	RDKR-200-10229	RDKR-100-10229	RDCR-011-00258	RDTR-081-00001	RDRY-701-00687	9
103.07 - 104.12	4.0579 - 4.0992	RDKR-200-10307	RDKR-100-10307	RDCR-011-00260	RDTR-082-00001	RDRY-701-00687	9

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



R Series: 84.81 mm - 104.12 mm (3.3390" - 4.0992")

Blind Holes



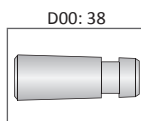
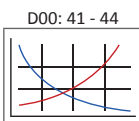
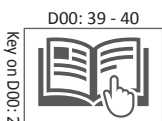
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
84.81 - 85.85	3.3390 - 3.3799	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00214	RSTR-073-0000x	RSRY-708-00468	9
85.63 - 86.66	3.3713 - 3.4118	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00216	RSTR-074-0000x	RSRY-708-00468	9
86.41 - 87.45	3.4020 - 3.4429	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00218	RSTR-071-0000x	RSRY-708-00531	9
87.20 - 88.24	3.4331 - 3.4740	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00220	RSTR-072-0000x	RSRY-708-00531	9
87.99 - 89.03	3.4642 - 3.5051	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00222	RSTR-073-0000x	RSRY-708-00531	9
88.79 - 89.84	3.4957 - 3.5370	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00224	RSTR-074-0000x	RSRY-708-00531	9
89.59 - 90.63	3.5272 - 3.5681	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00226	RSTR-075-0000x	RSRY-708-00531	9
90.37 - 91.42	3.5579 - 3.5992	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00228	RSTR-076-0000x	RSRY-708-00531	9
91.16 - 92.20	3.5890 - 3.6299	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00230	RSTR-071-0000x	RSRY-708-00625	9
91.97 - 93.02	3.6209 - 3.6622	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00232	RSTR-072-0000x	RSRY-708-00625	9
92.76 - 93.80	3.6520 - 3.6929	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00234	RSTR-073-0000x	RSRY-708-00625	9
93.55 - 94.59	3.6831 - 3.7240	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00236	RSTR-074-0000x	RSRY-708-00625	9
94.34 - 95.38	3.7142 - 3.7551	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00238	RSTR-075-0000x	RSRY-708-00625	9
95.15 - 96.19	3.7461 - 3.7870	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00240	RSTR-076-0000x	RSRY-708-00625	9
95.94 - 96.98	3.7772 - 3.8181	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00242	RSTR-077-0000x	RSRY-708-00625	9
96.72 - 97.77	3.8079 - 3.8492	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00244	RSTR-078-0000x	RSRY-708-00625	9
97.51 - 98.55	3.8390 - 3.8799	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00246	RSTR-075-0000x	RSRY-708-00687	9
98.32 - 99.37	3.8709 - 3.9122	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00248	RSTR-076-0000x	RSRY-708-00687	9
99.11 - 100.15	3.9020 - 3.9429	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00250	RSTR-077-0000x	RSRY-708-00687	9
99.90 - 100.94	3.9331 - 3.9740	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00252	RSTR-078-0000x	RSRY-708-00687	9
100.69 - 101.73	3.9642 - 4.0051	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00254	RSTR-079-0000x	RSRY-708-00687	9
101.50 - 102.54	3.9961 - 4.0370	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00256	RSTR-080-0000x	RSRY-708-00687	9
102.29 - 103.33	4.0272 - 4.0681	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00258	RSTR-081-0000x	RSRY-708-00687	9
103.07 - 104.12	4.0579 - 4.0992	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00260	RSTR-082-0000x	RSRY-708-00687	9

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 100.00 mm with straight shank: RSKR-100-10000).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

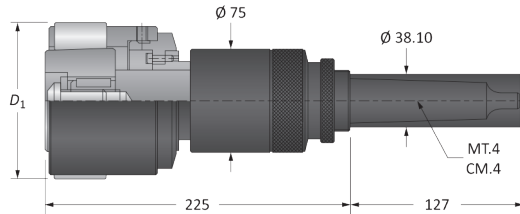


Key on D00: 2

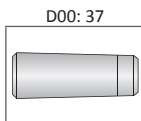
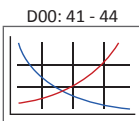
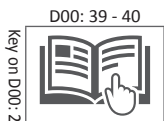
**S Series: 103.86 mm - 127.94 mm (4.0890" - 5.0370")**

Through Holes

D00



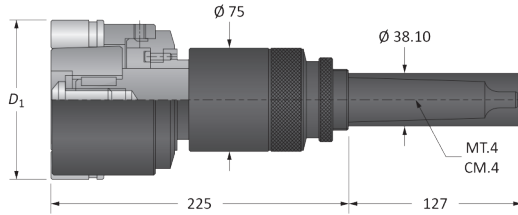
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
103.86 - 104.90	4.0890 - 4.1299	RDKS-200-10386	RDKS-100-10386	RDCS-011-00262	RDTS-083-00001	RDRY-701-00687	9
104.67 - 105.75	4.1209 - 4.1634	RDKS-200-10467	RDKS-100-10467	RDCS-011-00264	RDTS-084-00001	RDRY-701-00687	9
105.46 - 106.50	4.1520 - 4.1929	RDKS-200-10546	RDKS-100-10546	RDCS-011-00266	RDTS-085-00001	RDRY-701-00687	9
106.25 - 107.29	4.1831 - 4.2240	RDKS-200-10625	RDKS-100-10625	RDCS-011-00268	RDTS-086-00001	RDRY-701-00687	9
107.04 - 108.08	4.2142 - 4.2551	RDKS-200-10704	RDKS-100-10704	RDCS-011-00270	RDTS-087-00001	RDRY-701-00687	9
107.85 - 108.89	4.2461 - 4.2870	RDKS-200-10785	RDKS-100-10785	RDCS-011-00272	RDTS-088-00001	RDRY-701-00687	9
108.64 - 109.68	4.2772 - 4.3181	RDKS-200-10864	RDKS-100-10864	RDCS-011-00274	RDTS-089-00001	RDRY-701-00687	9
109.42 - 110.47	4.3079 - 4.3492	RDKS-200-10942	RDKS-100-10942	RDCS-011-00276	RDTS-090-00001	RDRY-701-00687	9
110.21 - 111.25	4.3390 - 4.3799	RDKS-200-11021	RDKS-100-11021	RDCS-011-00278	RDTS-083-00001	RDRY-701-00812	9
111.02 - 112.07	4.3709 - 4.4122	RDKS-200-11102	RDKS-100-11102	RDCS-011-00280	RDTS-084-00001	RDRY-701-00812	9
111.81 - 112.85	4.4020 - 4.4429	RDKS-200-11181	RDKS-100-11181	RDCS-011-00282	RDTS-085-00001	RDRY-701-00812	9
112.60 - 113.64	4.4331 - 4.4740	RDKS-200-11260	RDKS-100-11260	RDCS-011-00284	RDTS-086-00001	RDRY-701-00812	9
113.34 - 114.43	4.4622 - 4.5051	RDKS-200-11334	RDKS-100-11334	RDCS-011-00286	RDTS-087-00001	RDRY-701-00812	9
114.20 - 115.24	4.4961 - 4.5370	RDKS-200-11420	RDKS-100-11420	RDCS-011-00288	RDTS-088-00001	RDRY-701-00812	9
114.99 - 116.03	4.5272 - 4.5681	RDKS-200-11499	RDKS-100-11499	RDCS-011-00290	RDTS-089-00001	RDRY-701-00812	9
115.77 - 116.82	4.5579 - 4.5992	RDKS-200-11577	RDKS-100-11577	RDCS-011-00292	RDTS-090-00001	RDRY-701-00812	9
116.56 - 117.60	4.5890 - 4.6299	RDKS-200-11656	RDKS-100-11656	RDCS-011-00294	RDTS-091-00001	RDRY-701-00812	9
117.37 - 118.42	4.6209 - 4.6622	RDKS-200-11737	RDKS-100-11737	RDCS-011-00296	RDTS-092-00001	RDRY-701-00812	9
118.16 - 119.20	4.6520 - 4.6929	RDKS-200-11816	RDKS-100-11816	RDCS-011-00298	RDTS-093-00001	RDRY-701-00812	9
118.95 - 119.99	4.6831 - 4.7240	RDKS-200-11895	RDKS-100-11895	RDCS-011-00300	RDTS-094-00001	RDRY-701-00812	9
119.74 - 120.78	4.7142 - 4.7551	RDKS-200-11974	RDKS-100-11974	RDCS-011-00302	RDTS-095-00001	RDRY-701-00812	9
120.55 - 121.59	4.7461 - 4.7870	RDKS-200-12055	RDKS-100-12055	RDCS-011-00304	RDTS-096-00001	RDRY-701-00812	9
121.34 - 122.38	4.7772 - 4.8181	RDKS-200-12134	RDKS-100-12134	RDCS-011-00306	RDTS-097-00001	RDRY-701-00812	9
122.12 - 123.17	4.8079 - 4.8492	RDKS-200-12212	RDKS-100-12212	RDCS-011-00308	RDTS-098-00001	RDRY-701-00812	9
122.91 - 123.95	4.8390 - 4.8799	RDKS-200-12291	RDKS-100-12291	RDCS-011-00310	RDTS-099-00001	RDRY-701-00812	9
123.72 - 124.77	4.8709 - 4.9122	RDKS-200-12372	RDKS-100-12372	RDCS-011-00312	RDTS-100-00001	RDRY-701-00812	9
124.51 - 125.55	4.9020 - 4.9429	RDKS-200-12451	RDKS-100-12451	RDCS-011-01245	RDTS-031-01245	RDRY-701-00812	9
125.30 - 126.34	4.9331 - 4.9740	RDKS-200-12530	RDKS-100-12530	RDCS-011-01255	RDTS-031-01255	RDRY-701-00812	9
126.09 - 127.13	4.9642 - 5.0051	RDKS-200-12609	RDKS-100-12609	RDCS-011-01265	RDTS-031-01265	RDRY-701-00812	9
126.90 - 127.94	4.9961 - 5.0370	RDKS-200-12690	RDKS-100-12690	RDCS-011-01275	RDTS-031-01275	RDRY-701-00812	9

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



S Series: 103.86 mm - 127.94 mm (4.0890" - 5.0370")

Blind Holes



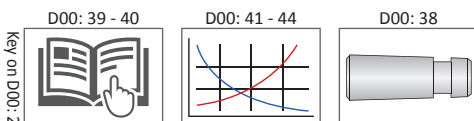
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
103.86 - 104.90	4.0890 - 4.1299	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00262	RSTS-083-0000x	RSRY-708-00687	9
104.67 - 105.75	4.1209 - 4.1634	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00264	RSTS-084-0000x	RSRY-708-00687	9
105.46 - 106.50	4.1520 - 4.1929	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00266	RSTS-085-0000x	RSRY-708-00687	9
106.25 - 107.29	4.1831 - 4.2240	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00268	RSTS-086-0000x	RSRY-708-00687	9
107.04 - 108.08	4.2142 - 4.2551	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00270	RSTS-087-0000x	RSRY-708-00687	9
107.85 - 108.89	4.2461 - 4.2870	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00272	RSTS-088-0000x	RSRY-708-00687	9
108.64 - 109.68	4.2772 - 4.3181	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00274	RSTS-089-0000x	RSRY-708-00687	9
109.42 - 110.47	4.3079 - 4.3492	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00276	RSTS-090-0000x	RSRY-708-00687	9
110.21 - 111.25	4.3390 - 4.3799	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00278	RSTS-083-0000x	RSRY-708-00812	9
111.02 - 112.07	4.3709 - 4.4122	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00280	RSTS-084-0000x	RSRY-708-00812	9
111.81 - 112.85	4.4020 - 4.4429	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00282	RSTS-085-0000x	RSRY-708-00812	9
112.60 - 113.64	4.4331 - 4.4740	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00284	RSTS-086-0000x	RSRY-708-00812	9
113.34 - 114.43	4.4622 - 4.5051	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00286	RSTS-087-0000x	RSRY-708-00812	9
114.20 - 115.24	4.4961 - 4.5370	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00288	RSTS-088-0000x	RSRY-708-00812	9
114.99 - 116.03	4.5272 - 4.5681	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00290	RSTS-089-0000x	RSRY-708-00812	9
115.77 - 116.82	4.5579 - 4.5992	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00292	RSTS-090-0000x	RSRY-708-00812	9
116.56 - 117.60	4.5890 - 4.6299	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00294	RSTS-091-0000x	RSRY-708-00812	9
117.37 - 118.42	4.6209 - 4.6622	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00296	RSTS-092-0000x	RSRY-708-00812	9
118.16 - 119.20	4.6520 - 4.6929	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00298	RSTS-093-0000x	RSRY-708-00812	9
118.95 - 119.99	4.6831 - 4.7240	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00300	RSTS-094-0000x	RSRY-708-00812	9
119.74 - 120.78	4.7142 - 4.7551	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00302	RSTS-095-0000x	RSRY-708-00812	9
120.55 - 121.59	4.7461 - 4.7870	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00304	RSTS-096-0000x	RSRY-708-00812	9
121.34 - 122.38	4.7772 - 4.8181	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00306	RSTS-097-0000x	RSRY-708-00812	9
122.12 - 123.17	4.8079 - 4.8492	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00308	RSTS-098-0000x	RSRY-708-00812	9
122.91 - 123.95	4.8390 - 4.8799	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00310	RSTS-099-0000x	RSRY-708-00812	9
123.72 - 124.77	4.8709 - 4.9122	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00312	RSTS-100-0000x	RSRY-708-00812	9
124.51 - 125.55	4.9020 - 4.9429	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01245	RSTS-03x-01245	RSRY-708-00812	9
125.30 - 126.34	4.9331 - 4.9740	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01255	RSTS-03x-01255	RSRY-708-00812	9
126.09 - 127.13	4.9642 - 5.0051	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01265	RSTS-03x-01265	RSRY-708-00812	9
126.90 - 127.94	4.9961 - 5.0370	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01275	RSTS-03x-01275	RSRY-708-00812	9

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 120.05 mm with MT.4 shank: RSKS-200-12005).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

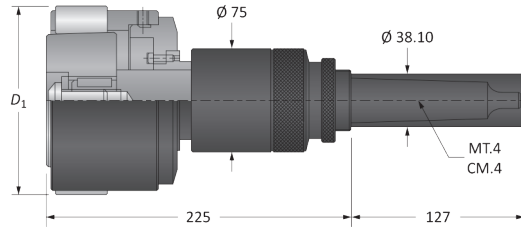


Key on D00: 2

**T Series: 127.90 mm - 149.90 mm (5.0354" - 5.9016")**

Through Holes

D00



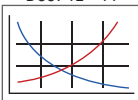
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
127.90 - 128.90	5.0354 - 5.0748	RDKT-200-12790	RDKT-100-12790	RDCT-011-01280	RDTT-031-01280	RDRY-701-00812	11
128.90 - 129.90	5.0748 - 5.1142	RDKT-200-12890	RDKT-100-12890	RDCT-011-01290	RDTT-031-01290	RDRY-701-00812	11
129.90 - 130.90	5.1142 - 5.1535	RDKT-200-12990	RDKT-100-12990	RDCT-011-01300	RDTT-031-01300	RDRY-701-00812	11
130.90 - 131.90	5.1535 - 5.1929	RDKT-200-13090	RDKT-100-13090	RDCT-011-01310	RDTT-031-01310	RDRY-701-00812	11
131.90 - 132.90	5.1929 - 5.2323	RDKT-200-13190	RDKT-100-13190	RDCT-011-01320	RDTT-031-01320	RDRY-701-00812	11
132.90 - 133.90	5.2323 - 5.2717	RDKT-200-13290	RDKT-100-13290	RDCT-011-01330	RDTT-031-01330	RDRY-701-00812	11
133.90 - 134.90	5.2717 - 5.3110	RDKT-200-13390	RDKT-100-13390	RDCT-011-01340	RDTT-031-01340	RDRY-701-00812	11
134.90 - 135.90	5.3110 - 5.3504	RDKT-200-13490	RDKT-100-13490	RDCT-011-01350	RDTT-031-01350	RDRY-701-00812	11
135.90 - 136.90	5.3504 - 5.3898	RDKT-200-13590	RDKT-100-13590	RDCT-011-01360	RDTT-031-01360	RDRY-701-00812	11
136.90 - 137.90	5.3898 - 5.4291	RDKT-200-13690	RDKT-100-13690	RDCT-011-01370	RDTT-031-01370	RDRY-701-00812	11
137.90 - 138.90	5.4291 - 5.4685	RDKT-200-13790	RDKT-100-13790	RDCT-011-01380	RDTT-031-01380	RDRY-701-00812	11
138.90 - 139.90	5.4685 - 5.5079	RDKT-200-13890	RDKT-100-13890	RDCT-011-01390	RDTT-031-01390	RDRY-701-00812	11
139.90 - 140.90	5.5079 - 5.5472	RDKT-200-13990	RDKT-100-13990	RDCT-011-01400	RDTT-031-01400	RDRY-701-00812	11
140.90 - 141.90	5.5472 - 5.5866	RDKT-200-14090	RDKT-100-14090	RDCT-011-01410	RDTT-031-01410	RDRY-701-00812	11
141.60 - 142.90	5.5866 - 5.6260	RDKT-200-14190	RDKT-100-14190	RDCT-011-01420	RDTT-031-01420	RDRY-701-00812	11
142.90 - 143.90	5.6260 - 5.6654	RDKT-200-14290	RDKT-100-14290	RDCT-011-01430	RDTT-031-01430	RDRY-701-00812	11
143.90 - 144.90	5.6654 - 5.7047	RDKT-200-14390	RDKT-100-14390	RDCT-011-01440	RDTT-031-01440	RDRY-701-00812	11
144.90 - 145.90	5.7047 - 5.7441	RDKT-200-14490	RDKT-100-14490	RDCT-011-01450	RDTT-031-01450	RDRY-701-00812	11
145.90 - 146.90	5.7441 - 5.7835	RDKT-200-14590	RDKT-100-14590	RDCT-011-01460	RDTT-031-01460	RDRY-701-00812	11
146.90 - 147.90	5.7835 - 5.8228	RDKT-200-14690	RDKT-100-14690	RDCT-011-01470	RDTT-031-01470	RDRY-701-00812	11
147.90 - 148.90	5.8228 - 5.8622	RDKT-200-14790	RDKT-100-14790	RDCT-011-01480	RDTT-031-01480	RDRY-701-00812	11
148.90 - 149.90	5.8622 - 5.9016	RDKT-200-14890	RDKT-100-14890	RDCT-011-01490	RDTT-031-01490	RDRY-701-00812	11

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

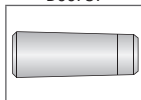
D00: 39 - 40



D00: 41 - 44



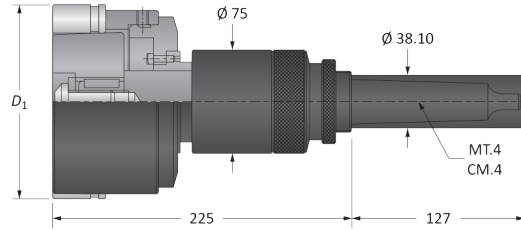
D00: 37





T Series: 127.90 mm - 149.90 mm (5.0354" - 5.9016")

Blind Holes



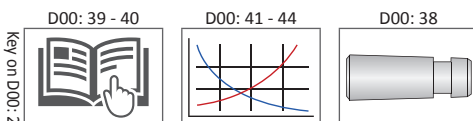
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
127.90 - 128.90	5.0354 - 5.0748	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01280	RSTT-0xx-01280	RSRY-708-00812	11
128.90 - 129.90	5.0748 - 5.1142	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01290	RSTT-0xx-01290	RSRY-708-00812	11
129.90 - 130.90	5.1142 - 5.1535	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01300	RSTT-0xx-01300	RSRY-708-00812	11
130.90 - 131.90	5.1535 - 5.1929	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01310	RSTT-0xx-01310	RSRY-708-00812	11
131.90 - 132.90	5.1929 - 5.2323	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01320	RSTT-0xx-01320	RSRY-708-00812	11
132.90 - 133.90	5.2323 - 5.2717	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01330	RSTT-0xx-01330	RSRY-708-00812	11
133.90 - 134.90	5.2717 - 5.3110	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01340	RSTT-0xx-01340	RSRY-708-00812	11
134.90 - 135.90	5.3110 - 5.3504	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01350	RSTT-0xx-01350	RSRY-708-00812	11
135.90 - 136.90	5.3504 - 5.3898	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01360	RSTT-0xx-01360	RSRY-708-00812	11
136.90 - 137.90	5.3898 - 5.4291	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01370	RSTT-0xx-01370	RSRY-708-00812	11
137.90 - 138.90	5.4291 - 5.4685	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01380	RSTT-0xx-01380	RSRY-708-00812	11
138.90 - 139.90	5.4685 - 5.5079	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01390	RSTT-0xx-01390	RSRY-708-00812	11
139.90 - 140.90	5.5079 - 5.5472	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01400	RSTT-0xx-01400	RSRY-708-00812	11
140.90 - 141.90	5.5472 - 5.5866	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01410	RSTT-0xx-01410	RSRY-708-00812	11
141.60 - 142.90	5.5866 - 5.6260	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01420	RSTT-0xx-01420	RSRY-708-00812	11
142.90 - 143.90	5.6260 - 5.6654	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01430	RSTT-0xx-01430	RSRY-708-00812	11
143.90 - 144.90	5.6654 - 5.7047	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01440	RSTT-0xx-01440	RSRY-708-00812	11
144.90 - 145.90	5.7047 - 5.7441	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01450	RSTT-0xx-01450	RSRY-708-00812	11
145.90 - 146.90	5.7441 - 5.7835	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01460	RSTT-0xx-01460	RSRY-708-00812	11
146.90 - 147.90	5.7835 - 5.8228	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01470	RSTT-0xx-01470	RSRY-708-00812	11
147.90 - 148.90	5.8228 - 5.8622	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01480	RSTT-0xx-01480	RSRY-708-00812	11
148.90 - 149.90	5.8622 - 5.9016	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01490	RSTT-0xx-01490	RSRY-708-00812	11

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 140.00 mm with straight shank: RSKT-100-14000).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

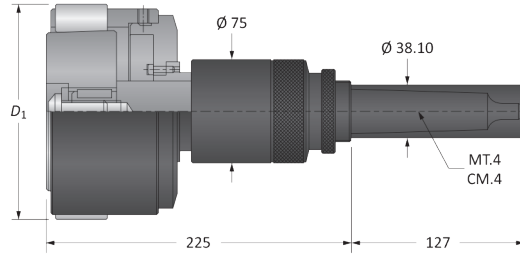


Key on D00: 2

**U Series: 149.90 mm - 165.90 mm (5.9016" - 6.5315")**

Through Holes

D00



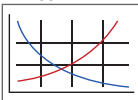
D_1		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone	Rolls Part No.	Qty
5.9016 - 5.9409	149.90 - 150.90	RDKU-200-14990	RDKU-100-14990	RDCU-011-01500	RDTU-031-01500	RDRY-701-00812	13
5.9409 - 5.9803	150.90 - 151.90	RDKU-200-15090	RDKU-100-15090	RDCU-011-01510	RDTU-031-01510	RDRY-701-00812	13
5.9803 - 6.0197	151.90 - 152.90	RDKU-200-15190	RDKU-100-15190	RDCU-011-01520	RDTU-031-01520	RDRY-701-00812	13
6.0197 - 6.0591	152.90 - 153.90	RDKU-200-15290	RDKU-100-15290	RDCU-011-01530	RDTU-031-01530	RDRY-701-00812	13
6.0591 - 6.0984	153.90 - 154.90	RDKU-200-15390	RDKU-100-15390	RDCU-011-01540	RDTU-031-01540	RDRY-701-00812	13
6.0984 - 6.1378	154.90 - 155.90	RDKU-200-15490	RDKU-100-15490	RDCU-011-01550	RDTU-031-01550	RDRY-701-00812	13
6.1378 - 6.1772	155.90 - 156.90	RDKU-200-15590	RDKU-100-15590	RDCU-011-01560	RDTU-031-01560	RDRY-701-00812	13
6.1772 - 6.2165	156.90 - 157.90	RDKU-200-15690	RDKU-100-15690	RDCU-011-01570	RDTU-031-01570	RDRY-701-00812	13
6.2165 - 6.2559	157.90 - 158.90	RDKU-200-15790	RDKU-100-15790	RDCU-011-01580	RDTU-031-01580	RDRY-701-00812	13
6.2559 - 6.2953	158.90 - 159.90	RDKU-200-15890	RDKU-100-15890	RDCU-011-01590	RDTU-031-01590	RDRY-701-00812	13
6.2953 - 6.3346	159.90 - 160.90	RDKU-200-15990	RDKU-100-15990	RDCU-011-01600	RDTU-031-01600	RDRY-701-00812	13
6.3346 - 6.3740	160.90 - 161.90	RDKU-200-16090	RDKU-100-16090	RDCU-011-01610	RDTU-031-01610	RDRY-701-00812	13
6.3740 - 6.4134	161.90 - 162.90	RDKU-200-16190	RDKU-100-16190	RDCU-011-01620	RDTU-031-01620	RDRY-701-00812	13
6.4134 - 6.4528	162.90 - 163.90	RDKU-200-16290	RDKU-100-16290	RDCU-011-01630	RDTU-031-01630	RDRY-701-00812	13
6.4528 - 6.4921	163.90 - 164.90	RDKU-200-16390	RDKU-100-16390	RDCU-011-01640	RDTU-031-01640	RDRY-701-00812	13
6.4921 - 6.5315	164.90 - 165.90	RDKU-200-16490	RDKU-100-16490	RDCU-011-01650	RDTU-031-01650	RDRY-701-00812	13

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

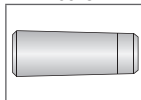
D00: 39 - 40



D00: 41 - 44



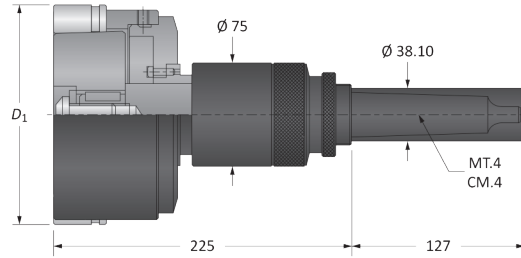
D00: 37





U Series: 149.90 mm - 165.90 mm (5.9016" - 6.5315")

Blind Holes



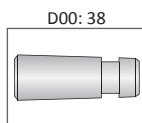
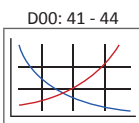
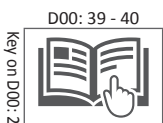
D00

D_1		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Morse Taper Shank Assembly	Straight Shank Assembly	Cage	Cone**	Rolls Part No.	Qty
149.90 - 150.90	5.9016 - 5.9409	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01500	RSTU-0xx-01500	RSRY-708-00812	13
150.90 - 151.90	5.9409 - 5.9803	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01510	RSTU-0xx-01510	RSRY-708-00812	13
151.90 - 152.90	5.9803 - 6.0197	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01520	RSTU-0xx-01520	RSRY-708-00812	13
152.90 - 153.90	6.0197 - 6.0591	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01530	RSTU-0xx-01530	RSRY-708-00812	13
153.90 - 154.90	6.0591 - 6.0984	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01540	RSTU-0xx-01540	RSRY-708-00812	13
154.90 - 155.90	6.0984 - 6.1378	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01550	RSTU-0xx-01550	RSRY-708-00812	13
155.90 - 156.90	6.1378 - 6.1772	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01560	RSTU-0xx-01560	RSRY-708-00812	13
156.90 - 157.90	6.1772 - 6.2165	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01570	RSTU-0xx-01570	RSRY-708-00812	13
157.90 - 158.90	6.2165 - 6.2559	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01580	RSTU-0xx-01580	RSRY-708-00812	13
158.90 - 159.90	6.2559 - 6.2953	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01590	RSTU-0xx-01590	RSRY-708-00812	13
159.90 - 160.90	6.2953 - 6.3346	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01600	RSTU-0xx-01600	RSRY-708-00812	13
160.90 - 161.90	6.3346 - 6.3740	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01610	RSTU-0xx-01610	RSRY-708-00812	13
161.90 - 162.90	6.3740 - 6.4134	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01620	RSTU-0xx-01620	RSRY-708-00812	13
162.90 - 163.90	6.4134 - 6.4528	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01630	RSTU-0xx-01630	RSRY-708-00812	13
163.90 - 164.90	6.4528 - 6.4921	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01640	RSTU-0xx-01640	RSRY-708-00812	13
164.90 - 165.90	6.4921 - 6.5315	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01650	RSTU-0xx-01650	RSRY-708-00812	13

* xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher $\varnothing$ 160.00 mm with MT.4 shank: RSKU-200-16000).

** x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D00: 7 for the correct identification of the "x" value.

NOTE: Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



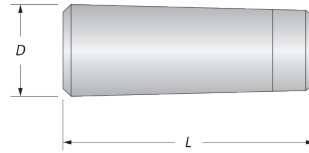
Key on D00: 2



Burnishing Rolls

Through Holes

D00



Rolls 704 and 707

Part No.	Metric (mm)		Imperial (in)	
	D	L	D	L
RDRY-704-00047	1.18	6.35	0.0465	0.2500
RDRY-704-00062	1.57	6.35	0.0618	0.2500
RDRY-704-00070	1.77	7.94	0.0697	0.3126
RDRY-704-00078	1.97	9.53	0.0776	0.3752
RDRY-704-00086	2.17	9.53	0.0854	0.3752
RDRY-704-00093	2.36	9.53	0.0929	0.3752
RDRY-704-00109	2.75	12.70	0.1083	0.5000
RDRY-704-00125	3.16	12.70	0.1244	0.5000
RDRY-704-00148	3.74	12.70	0.1472	0.5000
RDRY-704-00156	3.95	12.70	0.1555	0.5000
RDRY-704-00172	4.34	15.88	0.1709	0.6252
RDRY-704-00187	4.72	22.28	0.1858	0.8772
RDRY-707-00187	4.75	12.70	0.1870	0.5000
RDRY-704-00218	5.52	12.70	0.2173	0.5000
RDRY-707-00218	5.52	25.40	0.2173	1.0000
RDRY-704-00265	6.70	28.58	0.2638	1.1252
RDRY-704-00312	7.90	38.10	0.3110	1.5000
RDRY-707-00312	7.92	28.58	0.3118	1.1252
RDRY-704-00406	10.28	38.10	0.4047	1.5000
RDRY-704-00468	11.86	38.10	0.4669	1.5000
RDRY-704-00531	13.46	38.10	0.5299	1.5000
RDRY-704-00625	15.85	38.10	0.6240	1.5000
RDRY-704-00687	17.42	38.10	0.6858	1.5000
RDRY-704-00812	20.60	38.10	0.8110	1.5000

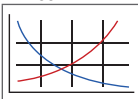
Rolls 701

Part No.	Metric (mm)		Imperial (in)	
	D	L	D	L
RDRY-701-00187	4.65	22.28	0.1831	0.8772
RDRY-701-00218	5.43	25.4	0.2138	1.0000
RDRY-701-00265	6.63	28.58	0.261	1.1252
RDRY-701-00312	7.72	38.1	0.3039	1.5000
RDRY-701-00406	10.11	38.1	0.398	1.5000
RDRY-701-00468	11.68	38.1	0.4598	1.5000
RDRY-701-00531	13.28	38.1	0.5228	1.5000
RDRY-701-00625	15.67	38.1	0.6169	1.5000
RDRY-701-00687	17.27	38.1	0.6799	1.5000
RDRY-701-00812	20.42	38.1	0.8039	1.5000

D00: 39 - 40

D00: 41 - 44

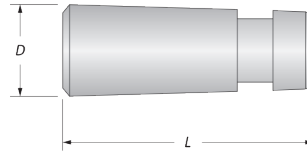
Key on D00: 2





Burnishing Rolls

Blind Holes



D00

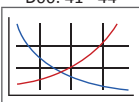
Rolls 708

Part No.	Metric (mm)		Imperial (in)	
	D	L	D	L
RSRY-708-00086	2.17	9.53	0.0854	0.3752
RSRY-708-00125	3.16	12.70	0.1244	0.5000
RSRY-708-00156	3.95	12.70	0.1555	0.5000
RSRY-708-00172	4.35	15.88	0.1709	0.6252
RSRY-708-00187	4.72	22.28	0.1858	0.8772
RSRY-708-00218	5.52	25.40	0.2173	0.5000
RSRY-708-00265	6.70	28.58	0.2638	1.1252
RSRY-708-00312	7.90	38.10	0.3110	1.5000
RSRY-708-00406	10.29	38.10	0.4047	1.5000
RSRY-708-00468	11.86	38.10	0.4669	1.5000
RSRY-708-00531	13.46	38.10	0.5299	1.5000
RSRY-708-00625	15.85	38.10	0.6240	1.5000
RSRY-708-00687	17.42	38.10	0.6858	1.5000
RSRY-708-00812	20.60	38.10	0.8110	1.5000

D00: 39 - 40

D00: 41 - 44

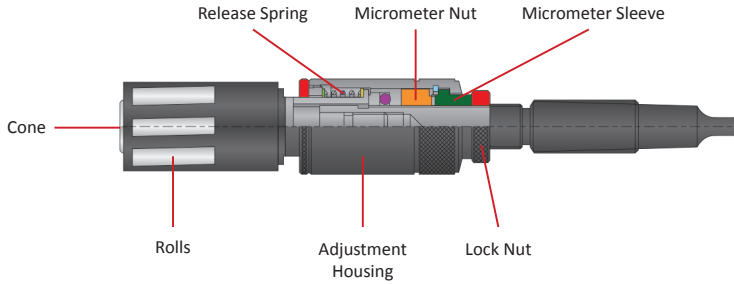
Key on D00: 2





Diameter Adjustment

D00



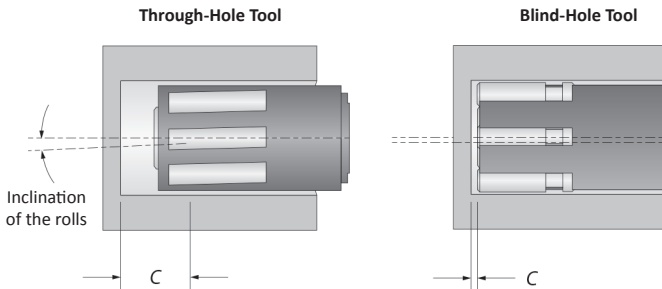
Adjustment

The roller burnishing tool incorporates a shank, a body, and a planetary system of conical rolls that are evenly spaced by a retaining cage.

1. Unscrew the lock nut.
2. Pull the housing toward the lock nut and rotate to increase or decrease the diameter.
3. Tighten the lock nut.

IMPORTANT: As you increase the diameter, the cone moves forward, pushing the rolls outward. Because of this, the cone will protrude from the end of the cage, decreasing the clearance available in blind holes (see Figures 1 and 2).

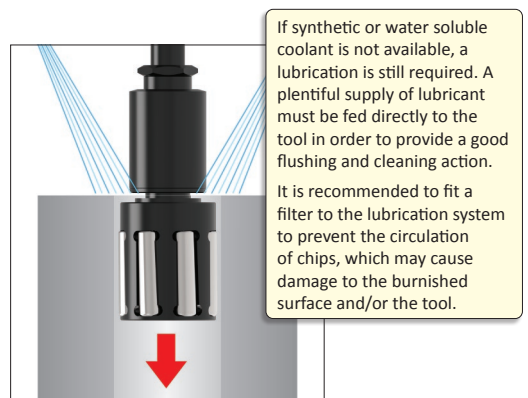
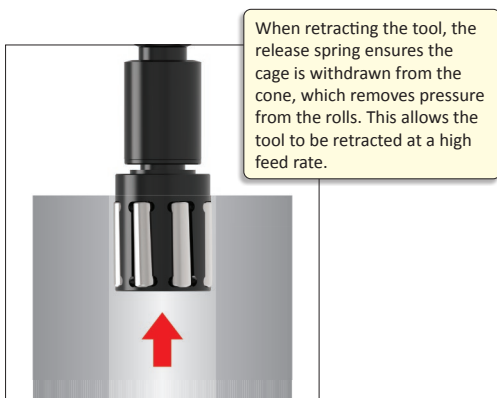
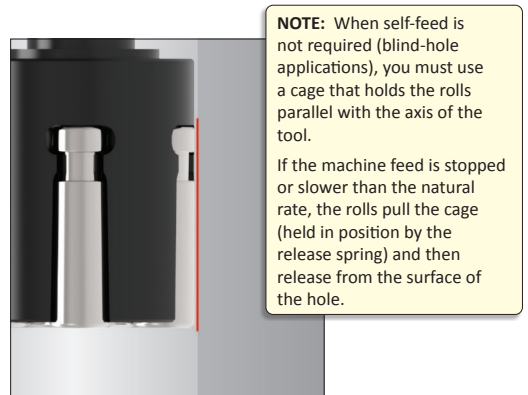
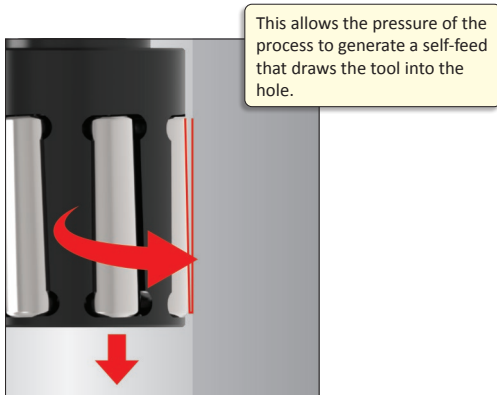
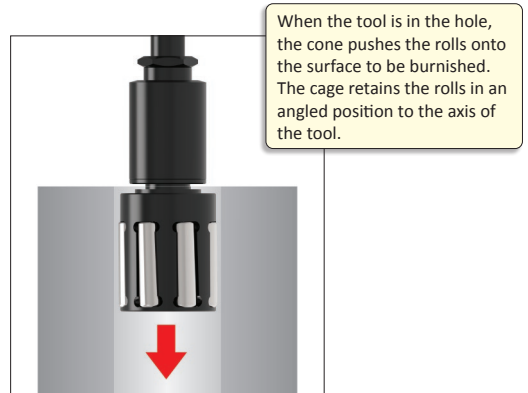
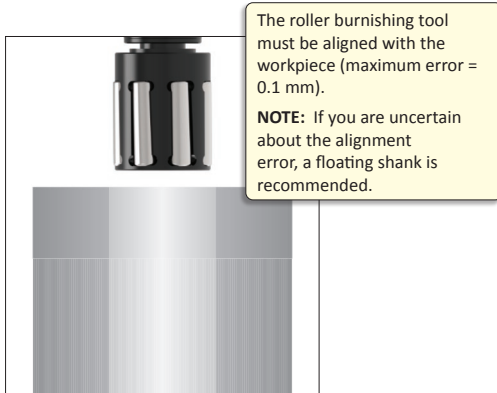
Refer to chart below for clearance values.

Figure 1**Figure 2**

Larger Diameter = Extruded Cone = Decreased Clearance

Adjustment Range		Clearance (C) (mm)		
		Through Holes		Blind Holes
Metric (mm)	Imperial (inch)	Rolls 701	Rolls 704 / 707	Rolls 708
4.70 - 5.88	0.1850 - 0.2315	-	2.40	-
5.89 - 9.47	0.2319 - 0.3728	-	2.40	0.60
9.48 - 15.84	0.3732 - 0.6236	-	2.40	0.60
15.85 - 28.54	0.6240 - 1.1236	5.40	3.20	1.00
28.55 - 46.70	1.1240 - 1.8385	9.50	3.20	1.00
46.71 - 84.80	1.8390 - 3.3386	9.50	4.00	1.00
84.81 - 165.90	3.3390 - 6.5315	10.30	4.70	1.00

How it Works



D00

**Recommended Drilling Data | Metric (mm)****ROLLER BURNISHERS**

ISO	Material	Hardness (BHN)	Speed (m/min)	Recommended Feed (mm/rev) by Diameter			
				4.70 mm - 12.00 mm	12.01 mm - 25.00 mm	25.01 mm - 50.00 mm	50.01 mm - 165.90 mm
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 250	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 275	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, etc.	125 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 325	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 375	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Structural Steel A36, A285, A516, etc.	125 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
M		180 - 350	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Tool Steel H-13, H-21, A-4, S-3, etc.	150 - 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		200 - 250	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Stainless Steel 400 Series 416, 420, etc.	135 - 350	22 - 60	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	22 - 60	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Grey and Ductile Cast Iron, Spheroidal Cast Iron (Pearlitic)	< 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		> 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Spheroidal Cast Iron (Ferritic)	260 - 320	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
N	Copper and Alloys, and Brass	< 500	45 - 105	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Bronze, and Bronze Phosphorous	< 180	45 - 105	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Aluminum and Alloys	< 150	45 - 105	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
S	High-Temp Alloy Hastelloy® B, Inconel® 600, etc.	140 - 310	15 - 45	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Titanium Alloy	140 - 310	15 - 45	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07

NOTE: For diameters less than 4.70 mm (0.1850"), please contact application engineering for recommended speed and feeds.

Max RPM

Series	Max RPM
H	2000
I	1500
K	1200
L	1000
F	1000
M	900
N	900
O	700
P	600
Q	500
R	300
S	300
T	250
U	200

IMPORTANT: The speeds and feeds listed above are a general starting point for all applications. Factory technical assistance is available through our Application Engineering department.



Recommended Drilling Data | Imperial (in)

ROLLER BURNISHERS

ISO	Material	Hardness (BHN)	Speed (SFM)	Recommended Feed (IPR) by Diameter			
				0.1850" - 0.4724"	0.4725" - 0.9843"	0.9844" - 1.9685"	1.9686" - 6.5315"
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 250	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 275	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, etc.	125 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 325	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 375	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Structural Steel A36, A285, A516, etc.	125 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
M		180 - 350	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Tool Steel H-13, H-21, A-4, S-3, etc.	150 - 200	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		200 - 250	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Stainless Steel 400 Series 416, 420, etc.	135 - 350	75 - 200	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	75 - 200	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Grey and Ductile Cast Iron, Spheroidal Cast Iron (Pearlitic)	< 200	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		> 200	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Spheroidal Cast Iron (Ferritic)	260 - 320	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
N	Copper and Alloys, and Brass	< 500	150 - 350	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Bronze, and Bronze Phosphorous	< 180	150 - 350	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Aluminum and Alloys	< 150	150 - 350	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
S	High-Temp Alloy Hastelloy® B, Inconel® 600, etc.	140 - 310	50 - 150	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Titanium Alloy	140 - 310	50 - 150	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121

NOTE: For diameters less than 4.70 mm (0.1850"), please contact application engineering for recommended speed and feeds.

Max RPM

Series	Max RPM
H	2000
I	1500
K	1200
L	1000
F	1000
M	900
N	900
O	700
P	600
Q	500
R	300
S	300
T	250
U	200

IMPORTANT: The speeds and feeds listed above are a general starting point for all applications. Factory technical assistance is available through our Application Engineering department.

**Stock Allowance | Metric (mm)****ROLLER BURNISHERS**

ISO	Material	Hardness (BHN)	Recommended Stock (mm) by Diameter			
			4.70 mm - 12.00 mm	12.01 mm - 25.00 mm	25.01 mm - 50.00 mm	50.01 mm - 165.90 mm
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
		180 - 250	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
		180 - 275	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, etc.	125 - 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
		180 - 325	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
		180 - 375	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Structural Steel A36, A285, A516, etc.	125 - 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
M		180 - 350	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Tool Steel H-13, H-21, A-4, S-3, etc.	150 - 200	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
		200 - 250	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Stainless Steel 400 Series 416, 420, etc.	135 - 350	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	Grey and Ductile Cast Iron, Spheroidal Cast Iron (Pearlitic)	< 200	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
		> 200	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Spheroidal Cast Iron (Ferritic)	260 - 320	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Copper and Alloys, and Brass	< 500	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	Bronze, and Bronze Phosphorous	< 180	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
N	Aluminum and Alloys	< 150	0.010 - 0.018	0.018 - 0.041	0.025 - 0.046	0.030 - 0.051
	High-Temp Alloy Hastelloy® B, Inconel® 600, etc.	140 - 310	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036
	Titanium Alloy	140 - 310	0.010 - 0.018	0.012 - 0.018	0.012 - 0.025	0.020 - 0.036

*Stock value is on diameter.

NOTE: For diameters less than 4.70 mm (0.1850"), please contact application engineering for recommended stock allowance.



Stock Allowance | Imperial (in)

ROLLER BURNISHERS						
ISO	Material	Hardness (BHN)	Recommended Stock (in) by Diameter			
			0.1850" - 0.4724"	0.4725" - 0.9843"	0.9844" - 1.9685"	1.9686" - 6.5315"
P	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 250	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 275	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, etc.	125 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 325	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 375	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Structural Steel A36, A285, A516, etc.	125 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
M		180 - 350	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Tool Steel H-13, H-21, A-4, S-3, etc.	150 - 200	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		200 - 250	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Stainless Steel 400 Series 416, 420, etc.	135 - 350	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Grey and Ductile Cast Iron, Spheroidal Cast Iron (Pearlitic)	< 200	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
		> 200	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Spheroidal Cast Iron (Ferritic)	260 - 320	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Copper and Alloys, and Brass	< 500	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Bronze, and Bronze Phosphorous	< 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
N	Aluminum and Alloys	< 150	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	High-Temp Alloy Hastelloy® B, Inconel® 600, etc.	140 - 310	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Titanium Alloy	140 - 310	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014

*Stock value is on diameter.

NOTE: For diameters less than 4.70 mm (0.1850"), please contact application engineering for recommended stock allowance.

D00

Guaranteed Test / Demo Application Form

Distributor PO #

The following must be filled out completely before your test will be considered.

IMPORTANT: For processing, send purchase order to your Allied Field Sales Engineer (FSE).
Please clearly mark the paperwork as "Test Order."

Distributor Information

Company Name: _____
Contact: _____
Account Number: _____
Phone: _____
Email: _____

End User Information

Company Name: _____
Contact: _____
Industry: _____
Phone: _____
Email: _____

Current Process List all tooling, coatings, substrates, speeds and feeds, tool life, and any problems you are experiencing.

Test Objective List what would make this a successful test (i.e. penetration rate, finish, tool life, hole size, etc.).

Application Information

Hole Diameter: _____ in/mm	Tolerance: _____	Material: _____ (4150, A36, cast iron, etc.)
Preexisting Diameter: _____ in/mm	Depth of Cut: _____ in/mm	Hardness: _____ (BHN, Rc)
Required Finish: _____ RMS	State: _____ (Casting, hot rolled, forging)	

Machine Information

Machine Type: _____ (Lathe, screw machine, machine center, etc.)	Builder: _____ (Haas, Mori Seiki, etc.)	Model #: _____
Shank Required: _____ (CAT50, Morse taper, etc.)	Power: _____ HP/KW	
Rigidity: _____ ☐ Excellent ☐ Good ☐ Poor	Orientation: _____ ☐ Vertical ☐ Horizontal	Tool Rotating: _____ ☐ Yes ☐ No
		Thrust: _____ lbs/N

Coolant Information

Coolant Delivery: _____ (Through tool, flood)	Coolant Pressure: _____ PSI / bar
Coolant Type: _____ (Air mist, oil, synthetic, water soluble, etc.)	Coolant Volume: _____ GPM / LPM

Requested Tooling

QTY	Item Number

QTY	Item Number



**ALLIED MACHINE
& ENGINEERING**

Allied Machine & Engineering
120 Deeds Drive
Dover, OH 44622

Telephone: (330) 343-4283
Toll Free USA & Canada: (800) 321-5537
Email: info@alliedmachine.com



ALLIED MACHINE & ENGINEERING

Warranty Information



Allied Machine & Engineering ("Allied Machine") warrants to original equipment manufacturers, distributors, industrial and commercial users of its products for one year from the original date of sale that each new product manufactured or supplied by Allied Machine shall be free from defects in material and workmanship.

Allied Machine's sole and exclusive obligation under this warranty is limited to, at its option, without additional charge, replacing or repairing this product or issuing a credit. For this warranty to be applied, the product must be returned freight prepaid to the plant designated by an Allied Machine representative and which, upon inspection, is determined by Allied Machine to be defective in material and workmanship.

Complete information as to operating conditions, machine, setup, and the application of cutting fluid should accompany any product returned for inspection. This warranty shall not apply to any Allied Machine products which have been subjected to misuse, abuse, improper operating conditions, improper machine setup or improper application of cutting fluid or which have been repaired or altered if such repair or alteration, in the judgement of Allied Machine, would adversely affect the performance of the product.

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United States

Allied Machine & Engineering
120 Deeds Drive
Dover OH 44622
United States

Allied Machine & Engineering

485 W Third Street
Dover OH 44622
United States

Phone:

+1.330.343.4283

Toll Free (US & CA):

800.321.5537

Toll Free (US & CA):

800.223.5140

Europe

**Allied Machine & Engineering Co.
(Europe) Ltd**
93 Vantage Point, Pensnett Estate
Kingswinford, West Midlands
DY6 7FR England

Phone:

+44 (0) 1384 400 900

Wohlhaupter® GmbH

Maybachstrasse 4
72636 Frickenhausen
Germany

Phone:

+49 (0) 7022 408-0

Asia

Wohlhaupter® India Pvt. Ltd.
B-23, 3rd Floor
B Block Community Centre
Janakpuri, New Delhi - 110058
India

Phone:

+91 (0) 11.41827044

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