

Internal Roll-a-Finish™ tools

SRMR/SRMB series

Our premier line of internal Roll-a-Finish™ tools, designed to suit all applications. Ideal for applications where tool length is restricted by tool changers, turrets, etc.



Offered in *three styles*:

- Through-hole style with no-helix cage (machine-feeding) as standard.
- Through-hole style with helix cage (self-feeding), made to order.
- Bottoming-style for blind hole, with no-helix cage (machine-feeding) as standard.



Through-Hole
(No Helix)



Through-Hole
(Helix)



Bottoming
(No Helix)

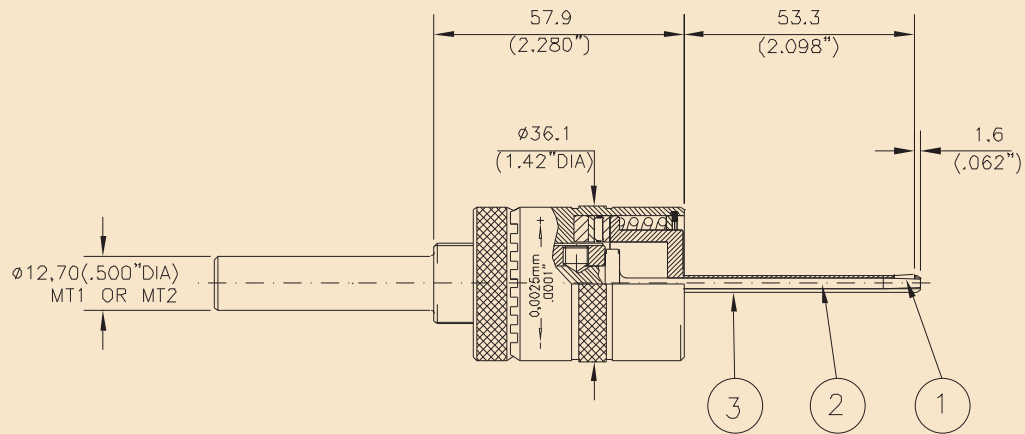
... with up to *three work lengths*:

- SRMR (B)
- SRMR (B)+50mm
- SRMR (B)+100mm
- Longer lengths available on request.

... and *available from stock*:

- for hole sizes from 4,00 to 50,00 mm (.157 to 1.968 inches).
- Tools are adjustable in increments of .002mm (.0001 inch).

Standard tool specifications



MAIN SPARES

1. ROLLS (3/TOOL)
2. MANDREL CONE
3. CAGE

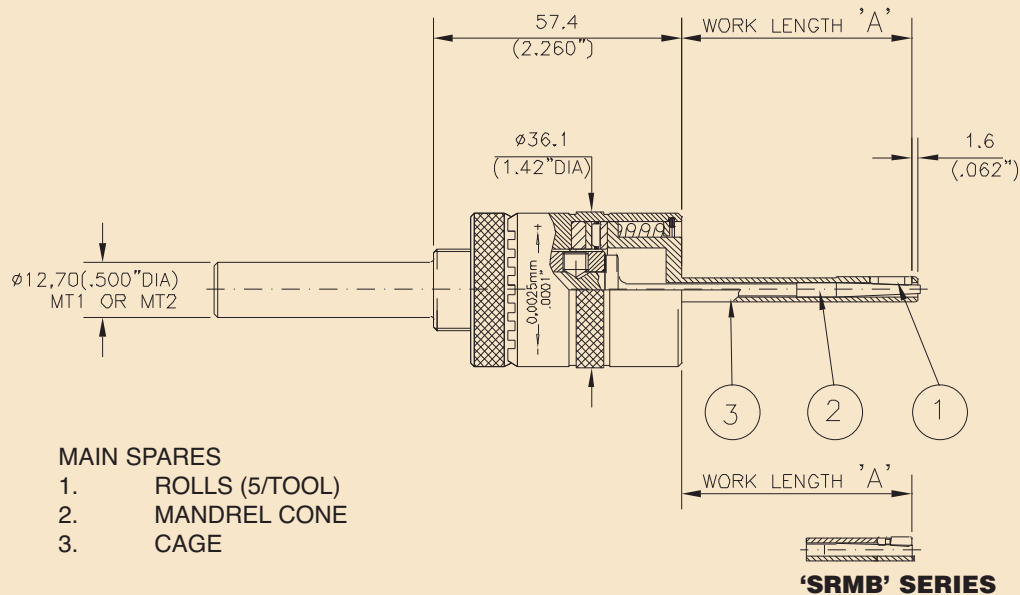
SRMR SERIES ROLL-A-FINISH™ TOOLS

4,0 to 5,75mm (.157" to .226")

DIAMETER RANGE				TOOL NUMBER		
MIN		MAX		THRO-HOLE	BOTTOMING	SELF-FEED OPTION
mm	Inches	mm	Inches	(No Helix)	(No Helix)	(1 1/2° Helix)
3,97	.156	4,25	.167	SRMR 4	-	-
4,22	.166	4,50	.177	SRMR 4,25	-	-
4,47	.176	4,75	.187	SRMR 4,50	-	-
4,72	.186	5,00	.197	SRMR 4,75	-	-
4,97	.196	5,25	.207	SRMR 5	-	Thro-Hole only
5,22	.206	5,50	.217	SRMR 5,25	-	Thro-Hole only
5,47	.215	5,75	.226	SRMR 5,50	-	Thro-Hole only
5,72	.225	6,00	.236	SRMR 5,75	-	Thro-Hole only

Tools other than shown above are available upon request.

Standard tool specifications



SRMR/SRMB SERIES ROLL-A-FINISH™ TOOLS

6,0 to 12,5mm (.236" to .492")

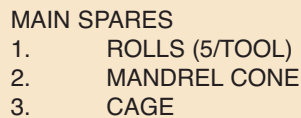
DIAMETER RANGE				TOOL NUMBER			
MIN		MAX		Standard Length 'A' = 53.3mm (2.098")		Extended Length 'A' = 104.1mm (4.098")	
				THRO-HOLE (No Helix)	BOTTOMING (No Helix)	THRO-HOLE (No Helix)	BOTTOMING (No Helix)
mm	Inches	mm	Inches				
5,95	.234	6,50	.256	SRMR 6	SRMB 6	SRMR 6 + 50	SRMB 6 + 50
6,45	.254	7,00	.276	SRMR 6,50	SRMB 6,50	SRMR 6,50 + 50	SRMB 6,50 + 50
6,95	.274	7,50	.295	SRMR 7	SRMB 7	SRMR 7 + 50	SRMB 7 + 50
7,45	.293	8,00	.315	SRMR 7,50	SRMB 7,50	SRMR 7,50 + 50	SRMB 7,50 + 50
7,95	.313	8,50	.335	SRMR 8	SRMB 8	SRMR 8 + 50	SRMB 8 + 50
8,45	.333	9,00	.354	SRMR 8,50	SRMB 8,50	SRMR 8,50 + 50	SRMB 8,50 + 50
8,95	.352	9,50	.374	SRMR 9	SRMB 9	SRMR 9 + 50	SRMB 9 + 50
9,45	.372	10,00	.394	SRMR 9,50	SRMB 9,50	SRMR 9,50 + 50	SRMB 9,50 + 50
9,95	.392	10,50	.413	SRMR 10	SRMB 10	SRMR 10 + 50	SRMB 10 + 50
10,45	.411	11,00	.433	SRMR 10,50	SRMB 10,50	SRMR 10,50 + 50	SRMB 10,50 + 50

Optional Self-Feeding 1 1/2° Helix Style Tools are Available for all Sizes, Styles and Lengths in this Range.

DIAMETER RANGE				TOOL NUMBER					
MIN		MAX		Standard Length 'A' = 66.3mm (2.610")		Extended Length 'A' = 117.1mm (4.610")		Extra Length 'A' = 167.9mm (6.610")	
				THRO-HOLE (No Helix)	BOTTOMING (No Helix)	THRO-HOLE (No Helix)	BOTTOMING (No Helix)	THRO-HOLE (No Helix)	BOTTOMING (No Helix)
mm	Inches	mm	Inches						
10,95	.431	11,50	.453	SRMR 11	SRMB 11	SRMR 11 + 50	SRMB 11 + 50	SRMR 11 + 100	SRMB 11 + 100
11,45	.451	12,00	.472	SRMR 11,50	SRMB 11,50	SRMR 11,50 + 50	SRMB 11,50 + 50	SRMR 11,50 + 100	SRMB 11,50 + 100
11,95	.470	12,50	.492	SRMR 12	SRMB 12	SRMR 12 + 50	SRMB 12 + 50	SRMR 12 + 100	SRMB 12 + 100
12,45	.490	13,00	.512	SRMR 12,50	SRMB 12,50	SRMR 12,50 + 50	SRMB 12,50 + 50	SRMR 12,50 + 100	SRMB 12,50 + 100

Optional Self-Feeding 1 1/2° Helix Style Tools are Available for all Sizes, Styles and Lengths in this Range

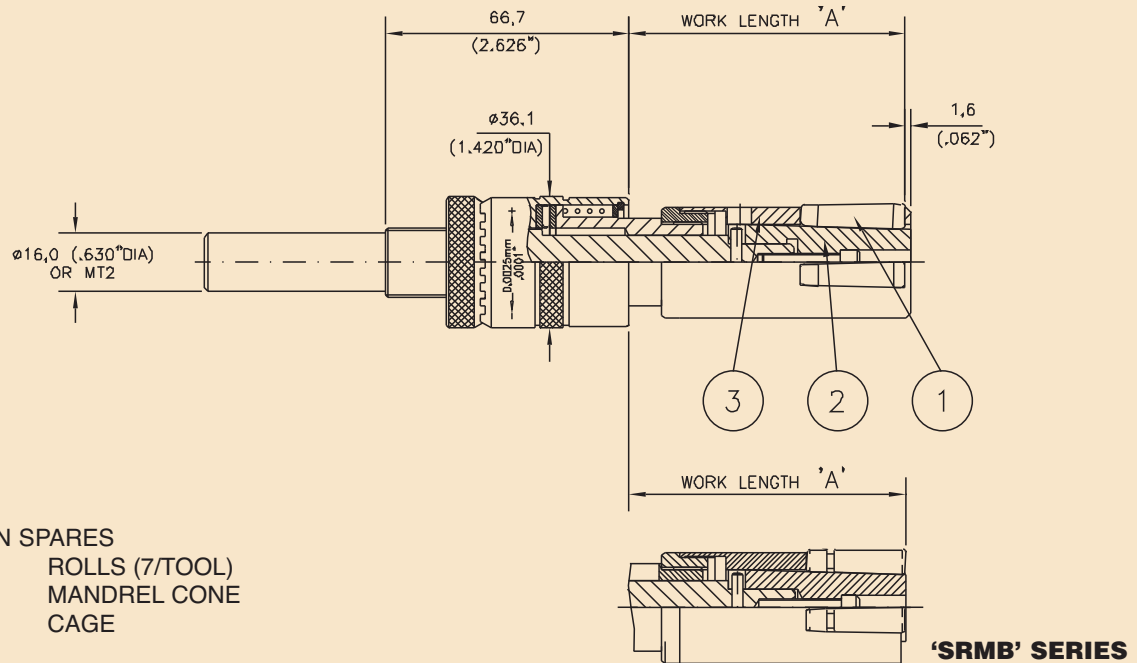
*When ordering Blind Bore Tools please state actual size to be burnished.
Tools other than shown above are available upon request.*



13,0 to 24,0mm (.512" to .945")

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Standard tool specifications



SRMR/SRMB SERIES ROLL-A-FINISH™ TOOLS

25,0 to 50,0mm (.984" to 1.969")

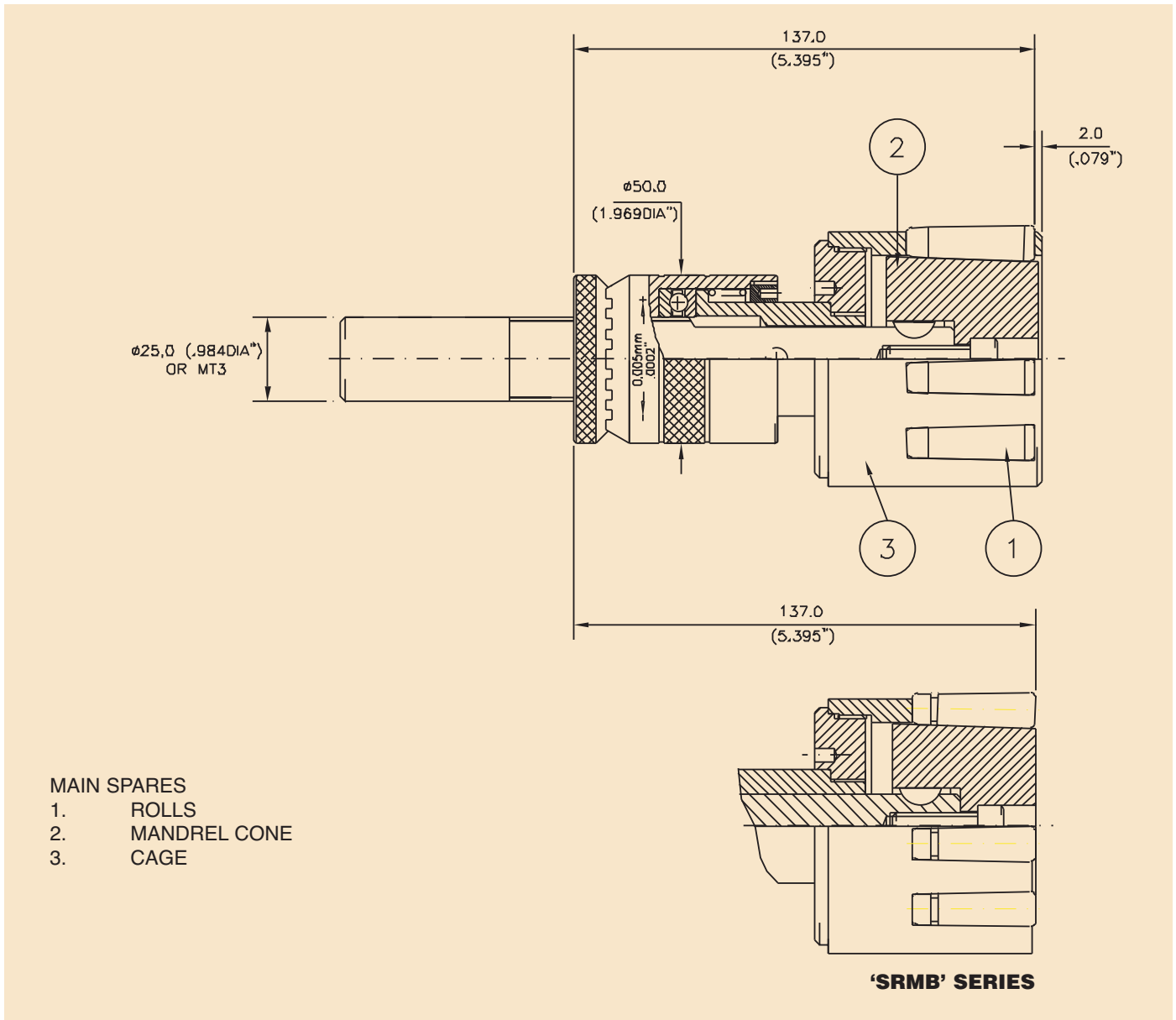
DIAMETER RANGE				TOOL NUMBER					
MIN		MAX		Standard Length 'A' = 75,7mm (2.980")		Extended Length 'A' = 126,5mm (4.980")		Extra Length 'A' = 177,3mm (6.980")	
mm	Inches	mm	Inches	THRO-HOLE (No Helix)	BOTTOMING (No Helix)	THRO-HOLE (No Helix)	BOTTOMING (No Helix)	THRO-HOLE (No Helix)	BOTTOMING (No Helix)
24,90	.980	26,00	1.024	SRMR 25	SRMB 25	SRMR 25 + 50	SRMB 25 + 50	SRMR 25 + 100	SRMB 25 + 100
25,90	1.020	27,00	1.063	SRMR 26	SRMB 26	SRMR 26 + 50	SRMB 26 + 50	SRMR 26 + 100	SRMB 26 + 100
26,90	1.059	28,00	1.102	SRMR 27	SRMB 27	SRMR 27 + 50	SRMB 27 + 50	SRMR 27 + 100	SRMB 27 + 100
27,90	1.098	29,00	1.142	SRMR 28	SRMB 28	SRMR 28 + 50	SRMB 28 + 50	SRMR 28 + 100	SRMB 28 + 100
28,90	1.138	30,00	1.181	SRMR 29	SRMB 29	SRMR 29 + 50	SRMB 29 + 50	SRMR 29 + 100	SRMB 29 + 100
29,90	1.177	31,00	1.220	SRMR 30	SRMB 30	SRMR 30 + 50	SRMB 30 + 50	SRMR 30 + 100	SRMB 30 + 100
30,90	1.217	32,00	1.260	SRMR 31	SRMB 31	SRMR 31 + 50	SRMB 31 + 50	SRMR 31 + 100	SRMB 31 + 100
31,90	1.256	33,00	1.300	SRMR 32	SRMB 32	SRMR 32 + 50	SRMB 32 + 50	SRMR 32 + 100	SRMB 32 + 100
32,90	1.295	34,00	1.339	SRMR 33	SRMB 33	SRMR 33 + 50	SRMB 33 + 50	SRMR 33 + 100	SRMB 33 + 100
33,90	1.335	35,00	1.378	SRMR 34	SRMB 34	SRMR 34 + 50	SRMB 34 + 50	SRMR 34 + 100	SRMB 34 + 100
34,90	1.374	36,00	1.417	SRMR 35	SRMB 35	SRMR 35 + 50	SRMB 35 + 50	SRMR 35 + 100	SRMB 35 + 100
35,90	1.413	37,00	1.457	SRMR 36	SRMB 36	SRMR 36 + 50	SRMB 36 + 50	SRMR 36 + 100	SRMB 36 + 100
36,90	1.453	38,00	1.496	SRMR 37	SRMB 37				
37,90	1.492	39,00	1.535	SRMR 38	SRMB 38				
38,90	1.531	40,00	1.574	SRMR 39	SRMB 39				
39,90	1.571	41,00	1.614	SRMR 40	SRMB 40				
40,90	1.610	42,00	1.654	SRMR 41	SRMB 41				
41,90	1.649	43,00	1.693	SRMR 42	SRMB 42				
42,90	1.689	44,00	1.732	SRMR 43	SRMB 43				
43,90	1.728	45,00	1.772	SRMR 44	SRMB 44				
44,90	1.768	46,00	1.811	SRMR 45	SRMB 45				
45,90	1.807	47,00	1.850	SRMR 46	SRMB 46				
46,90	1.846	48,00	1.890	SRMR 47	SRMB 47				
47,90	1.886	49,00	1.929	SRMR 48	SRMB 48				
48,90	1.925	50,00	1.968	SRMR 49	SRMB 49				
49,90	1.964	51,00	2.008	SRMR 50	SRMB 50				

ON COMPONENT BORES MORE THAN 36MM, INFINITE LENGTHS CAN BE BURNISHED BY ADDING SHANK ADAPTORS

Optional Self-Feeding 1½° Helix Style Tools are Available for all Sizes, Styles and Lengths in this Range

*When ordering Blind Bore Tools please state actual size to be burnished.
Tools other than shown above are available upon request.*

Standard tool specifications



SRMR/SRMB SERIES ROLL-A-FINISH™ TOOLS

51,0 to 89,0mm (2.008" to 3.504")

SEE NEXT PAGE FOR CHART

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Standard tool specifications

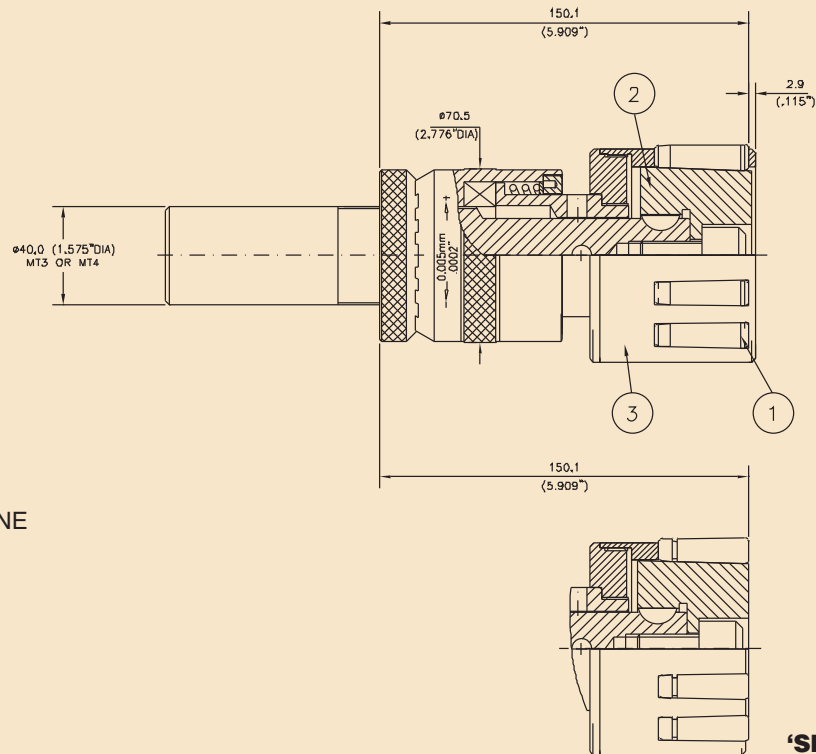
SRMR/SRMB SERIES ROLL-A-FINISH™ TOOLS

51,0 to 89,0mm (2.008" to 3.504")

DIAMETER RANGE				TOOL NUMBER	
MIN		MAX		(UNLIMITED WORKING LENGTH USING SHANK EXTENSIONS)	
				THRO-HOLE (No Helix)	BOTTOMING (No Helix)
mm	Inches	mm	Inches		
50,90	2.004	52,00	2.047	SRMR 51	SRMB 51
51,90	2.043	53,00	2.087	SRMR 52	SRMB 52
52,90	2.083	54,00	2.126	SRMR 53	SRMB 53
53,90	2.122	55,00	2.165	SRMR 54	SRMB 54
54,90	2.161	56,00	2.205	SRMR 55	SRMB 55
55,90	2.201	57,00	2.244	SRMR 56	SRMB 56
56,90	2.240	58,00	2.283	SRMR 57	SRMB 57
57,90	2.280	59,00	2.323	SRMR 58	SRMB 58
58,90	2.319	60,00	2.362	SRMR 59	SRMB 59
59,90	2.358	61,00	2.402	SRMR 60	SRMB 60
60,90	2.398	62,00	2.441	SRMR 61	SRMB 61
61,90	2.437	63,00	2.480	SRMR 62	SRMB 62
62,90	2.476	64,00	2.520	SRMR 63	SRMB 63
63,90	2.516	65,00	2.559	SRMR 64	SRMB 64
64,90	2.555	66,00	2.598	SRMR 65	SRMB 65
65,90	2.594	67,00	2.638	SRMR 66	SRMB 66
66,90	2.634	68,00	2.677	SRMR 67	SRMB 67
67,90	2.673	69,00	2.717	SRMR 68	SRMB 68
68,90	2.713	70,00	2.756	SRMR 69	SRMB 69
69,90	2.752	71,00	2.795	SRMR 70	SRMB 70
70,90	2.791	72,00	2.835	SRMR 71	SRMB 71
71,90	2.831	73,00	2.874	SRMR 72	SRMB 72
72,90	2.870	74,00	2.913	SRMR 73	SRMB 73
73,90	2.909	75,00	2.953	SRMR 74	SRMR 74
74,90	2.949	76,00	2.992	SRMR 75	SRMB 75
75,90	2.988	77,00	3.031	SRMR 76	SRMB 76
76,90	3.028	78,00	3.071	SRMR 77	SRMB 77
77,90	3.067	79,00	3.110	SRMR 78	SRMB 78
78,90	3.106	80,00	3.150	SRMR 79	SRMB 79
79,90	3.146	81,00	3.189	SRMR 80	SRMB 80
80,90	3.185	82,00	3.228	SRMR 81	SRMB 81
81,90	3.224	83,00	3.268	SRMR 82	SRMB 82
82,90	3.264	84,00	3.307	SRMR 83	SRMB 83
83,90	3.303	85,00	3.346	SRMR 84	SRMB 84
84,90	3.343	86,00	3.386	SRMR 85	SRMB 85
85,90	3.382	87,00	3.425	SRMR 86	SRMB 86
86,90	3.421	88,00	3.465	SRMR 87	SRMB 87
87,90	3.461	89,00	3.504	SRMR 88	SRMB 88
88,90	3.500	90,00	3.543	SRMR 89	SRMB 89

Optional Self-Feeding 1½° Helix Style Tools are Available for all Sizes and Styles in this Range

Standard tool specifications



MAIN SPARES

1. ROLLS
2. MANDREL CONE
3. CAGE

SRMR/SRMB SERIES ROLL-A-FINISH™ TOOLS

90,0 to 177,0 mm (3.543" to 6.969")

DIAMETER RANGE				TOOL NUMBER	
MIN		MAX		(UNLIMITED WORKING LENGTH USING SHANK EXTENSIONS)	
mm	Inches	mm	Inches	THRO-HOLE (No Helix)	BOTTOMING (No Helix)
89,90	3.539	91,00	3.583	SRMR 90	SRMB 90
90,90	3.579	92,00	3.622	SRMR 91	SRMB 91
91,90	3.618	93,00	3.661	SRMR 92	SRMB 92
92,90	3.657	94,00	3.701	SRMR 93	SRMB 93
93,90	3.697	95,00	3.740	SRMR 94	SRMB 94
94,90	3.736	96,00	3.780	SRMR 95	SRMB 95
95,90	3.776	97,00	3.819	SRMR 96	SRMB 96
96,90	3.815	98,00	3.858	SRMR 97	SRMB 97
97,90	3.854	99,00	3.898	SRMR 98	SRMB 98
98,90	3.894	100,00	3.937	SRMR 99	SRMB 99
99,90	3.933	101,00	3.976	SRMR 100	SRMB 100
100,90	3.972	102,00	4.016	SRMR 101	SRMB 101
101,90	4.012	103,00	4.055	SRMR 102	SRMB 102
102,90	4.052	104,00	4.094	SRMR 103	SRMB 103
103,90	4.091	105,00	4.134	SRMR 104	SRMB 104
104,90	4.130	106,00	4.173	SRMR 105	SRMB 105
105,90	4.169	107,00	4.213	SRMR 106	SRMB 106
106,90	4.209	108,00	4.252	SRMR 107	SRMB 107
107,90	4.248	109,00	4.291	SRMR 108	SRMB 108
108,90	4.287	110,00	4.331	SRMR 109	SRMB 109
109,90	4.327	111,00	4.370	SRMR 110	SRMB 110
110,90	4.366	112,00	4.409	SRMR 111	SRMB 111
111,90	4.406	113,00	4.449	SRMR 112	SRMB 112
112,90	4.445	114,00	4.488	SRMR 113	SRMB 113

Optional Self-Feeding 1½° Helix Style Tools are Available for all Sizes and Styles in this Range

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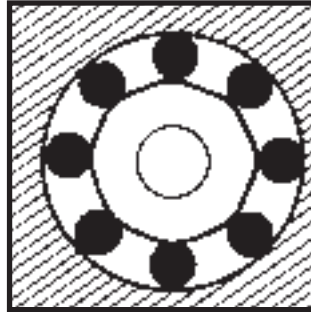
DIAMETER RANGE				TOOL NUMBER	
MIN		MAX		(UNLIMITED WORKING LENGTH USING SHANK EXTENSIONS)	
mm	Inches	mm	Inches	THRO-HOLE (No Helix)	BOTTOMING (No Helix)
113,90	4.484	115,00	4.528	SRMR 114	SRMB 114
114,90	4.524	116,00	4.567	SRMR 115	SRMB 115
115,90	4.563	117,00	4.606	SRMR 116	SRMB 116
116,90	4.602	118,00	4.646	SRMR 117	SRMB 117
117,90	4.642	119,00	4.685	SRMR 118	SRMB 118
118,90	4.681	120,00	4.724	SRMR 119	SRMB 119
119,90	4.720	121,00	4.764	SRMR 120	SRMB 120
120,90	4.760	122,00	4.803	SRMR 121	SRMB 121
121,90	4.799	123,00	4.843	SRMR 122	SRMB 122
122,90	4.839	124,00	4.882	SRMR 123	SRMB 123
123,90	4.878	125,00	4.921	SRMR 124	SRMB 124
124,90	4.917	126,00	4.961	SRMR 125	SRMB 125
125,90	4.957	127,00	5.000	SRMR 126	SRMB 126
126,90	4.996	128,00	5.039	SRMR 127	SRMB 127
127,90	5.035	129,00	5.079	SRMR 128	SRMB 128
128,90	5.075	130,00	5.118	SRMR 129	SRMB 129
129,90	5.114	131,00	5.157	SRMR 130	SRMB 130
130,90	5.154	132,00	5.197	SRMR 131	SRMB 131
131,90	5.193	133,00	5.236	SRMR 132	SRMB 132
132,90	5.232	134,00	5.276	SRMR 133	SRMB 133
133,90	5.272	135,00	5.315	SRMR 134	SRMB 134
134,90	5.311	136,00	5.354	SRMR 135	SRMB 135
135,90	5.350	137,00	5.394	SRMR 136	SRMB 136
136,90	5.390	138,00	5.433	SRMR 137	SRMB 137
137,90	5.429	139,00	5.472	SRMR 138	SRMB 138
138,90	5.469	140,00	5.512	SRMR 139	SRMB 139
139,90	5.508	141,00	5.551	SRMR 140	SRMB 140
140,90	5.547	142,00	5.591	SRMR 141	SRMB 141
141,90	5.587	143,00	5.630	SRMR 142	SRMB 142
142,90	5.626	144,00	5.669	SRMR 143	SRMB 143
143,90	5.665	145,00	5.709	SRMR 144	SRMB 144
144,90	5.705	146,00	5.748	SRMR 145	SRMB 145
145,90	5.744	147,00	5.787	SRMR 146	SRMB 146
146,90	5.783	148,00	5.827	SRMR 147	SRMB 147
147,90	5.823	149,00	5.866	SRMR 148	SRMB 148
148,90	5.862	150,00	5.906	SRMR 149	SRMB 149
149,90	5.902	151,00	5.945	SRMR 150	SRMB 150
150,90	5.941	152,00	5.984	SRMR 151	SRMB 151
151,90	5.980	153,00	6.024	SRMR 152	SRMB 152
152,90	6.020	154,00	6.063	SRMR 153	SRMB 153
153,90	6.059	155,00	6.102	SRMR 154	SRMB 154
154,90	6.098	156,00	6.142	SRMR 155	SRMB 155
155,90	6.138	157,00	6.181	SRMR 156	SRMB 156
156,90	6.177	158,00	6.220	SRMR 157	SRMB 157
157,90	6.217	159,00	6.260	SRMR 158	SRMB 158
158,90	6.256	160,00	6.299	SRMR 159	SRMB 159
159,90	6.295	161,00	6.339	SRMR 160	SRMB 160
160,90	6.335	162,00	6.378	SRMR 161	SRMB 161
161,90	6.374	163,00	6.417	SRMR 162	SRMB 162
162,90	6.413	164,00	6.457	SRMR 163	SRMB 163
163,90	6.453	165,00	6.496	SRMR 164	SRMB 164
164,90	6.492	166,00	6.535	SRMR 165	SRMB 165
165,90	6.531	167,00	6.575	SRMR 166	SRMB 166
166,90	6.571	168,00	6.614	SRMR 167	SRMB 167
167,90	6.610	169,00	6.654	SRMR 168	SRMB 168
168,90	6.650	170,00	6.693	SRMR 169	SRMB 169
169,90	6.690	171,00	6.732	SRMR 170	SRMB 170
170,90	6.728	172,00	6.772	SRMR 171	SRMB 171
171,90	6.768	173,00	6.811	SRMR 172	SRMB 172
172,90	6.807	174,00	6.850	SRMR 173	SRMB 173
173,90	6.846	175,00	6.890	SRMR 174	SRMB 174
174,90	6.886	176,00	6.929	SRMR 175	SRMB 175
175,90	6.925	177,00	6.969	SRMR 176	SRMB 176
176,90	6.965	178,00	7.008	SRMR 177	SRMB 177

Optional Self-Feeding 1½° Helix Style Tools are Available for all Sizes and Styles in this Range

ROLLS

INTERNAL ROLLER BURNISHING ROLL CHART				
TOOL NUMBER		ROLL NUMBER		QTY / TOOL
(FROM	- TO)	THRO-HOLE	BOTTOMING	
SRM 4	- 4,75	RR137	-	3
SRM 5	- 5,75	SR187	-	3
SRMR 6	- 7,50	R250	B250	5
SRMR 8	- 9	R312	B312	5
SRMR 9,50	- 10,50	R375	B375	5
SRMR 11	- 12,50	R437	B437	5
SRMR 13	- 17	R500	B500	5
SRMR 18	- 24	R750	B750	5
SRMR 25	- 29	R750	B750	7
SRMR 30	- 35	R875	B875	7
SRMR 36	- 41	R1125	B1125	7
SRMR 42	- 50	R1625	B1625	7
SRMR 51	- 69	R1625	B1625	9
SRMR 70	- 89	R1625	B1625	11
SRMR 90	- 110	R1625	B1625	13
SRMR 111	- 135	R1625	B1625	15
SRMR 136	- 155	R1625	B1625	17
SRMR 156	- 177	R1625	B1625	19

Bearingizing tools



The Bearingizing Tool combines roller burnishing with peening action. As the tool is rotated at a high speed the rolls spin, rise, and fall over a cammed arbor, delivering up to 200,000 rapid fire blows per minute to the work surface. The peaks and valleys of the machined surface are compacted into a smooth, hardened, and ultrafine surface finish.

The Bearingizer *may* be the tool of choice where the following conditions exist:

- Parts with *thin walls* — Bearingizing eliminates barrel-shaping of the part.
- Parts with *irregular wall thicknesses* — the Bearingizing tool will produce a very round hole, whereas the Roll-a-Finish™ tool might generate a slightly egg-shaped hole, due to variations in wall thickness.
- Applications where *porosity* is an issue (e.g., oil-impregnated bearings) — the smaller “footprint” of the Bearingizing roll leaves pores in the surface intact.
- Applications where *very tight tolerances* must be held — the Bearingizer reduces springback in the work surface material. The Bearingizing tool can, in some materials and with proper part preparation, hold size as close as $\pm .002\text{mm}$ (.0001 inch), while the Roll-a-Finish tool can achieve tolerances of $\pm .006\text{mm}$ (.00025 inch).

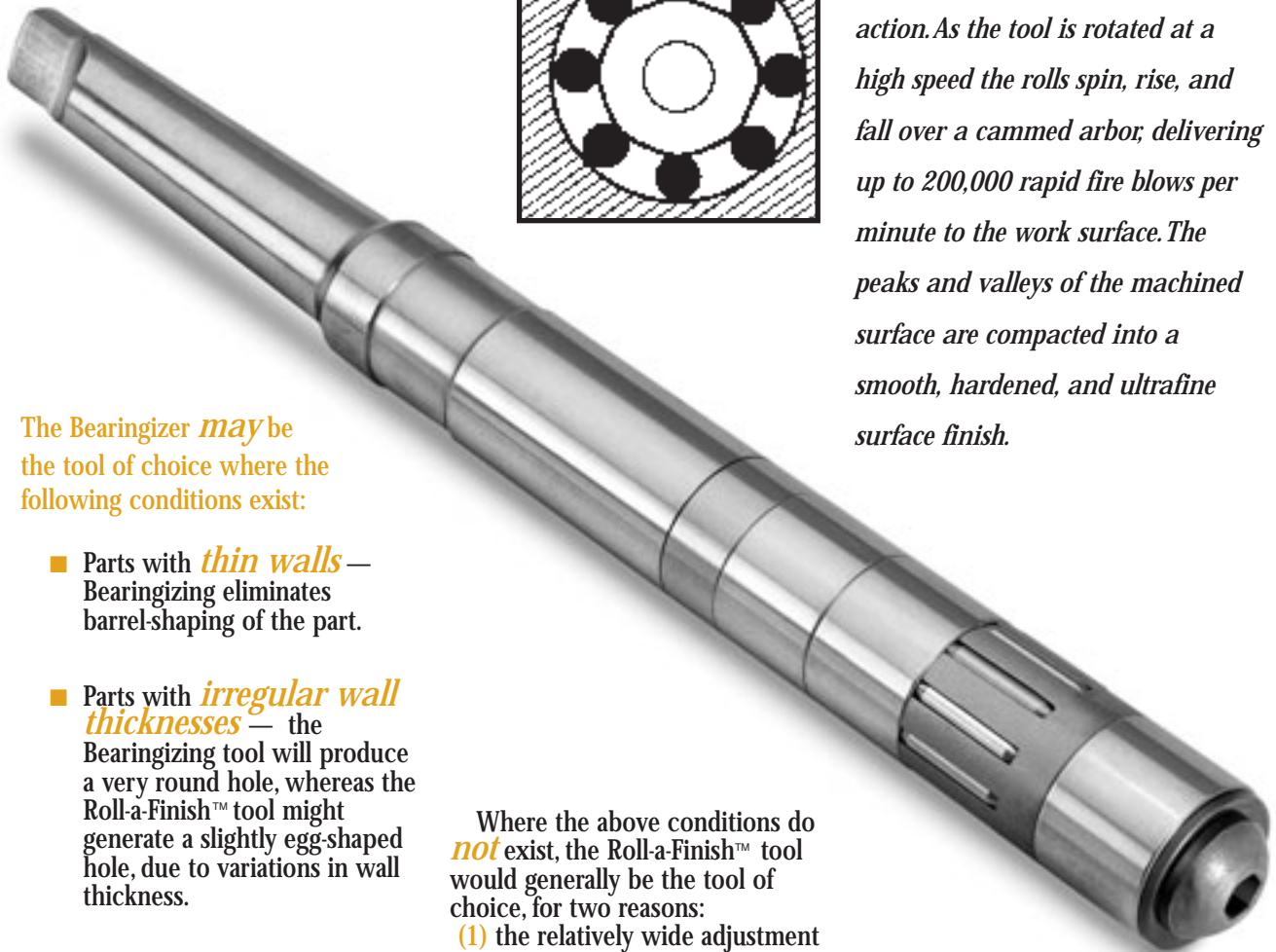
Where the above conditions do *not* exist, the Roll-a-Finish™ tool would generally be the tool of choice, for two reasons:

- (1) the relatively wide adjustment range of the Roll-a-Finish tool, which is typically 1.01mm (.040 inch), and
- (2) the ease of adjustment, with the castellated adjusting collar on the Roll-a-Finish tool.

The Bearingizing tool features a greater number of rolls, and rolls of a smaller diameter, as compared to the Roll-a-Finish tool, and can only be adjusted by change of rolls. The Bearingizer also requires a closer presize than the Roll-a-Finish tool.

But where the above conditions *do* exist, the Bearingizing tool should be considered.

While the Roll-a-Finish Tool increases surface hardness by about 5 to 10%, Bearingizing increases hardness by 10 to 30%, but with less surface penetration.

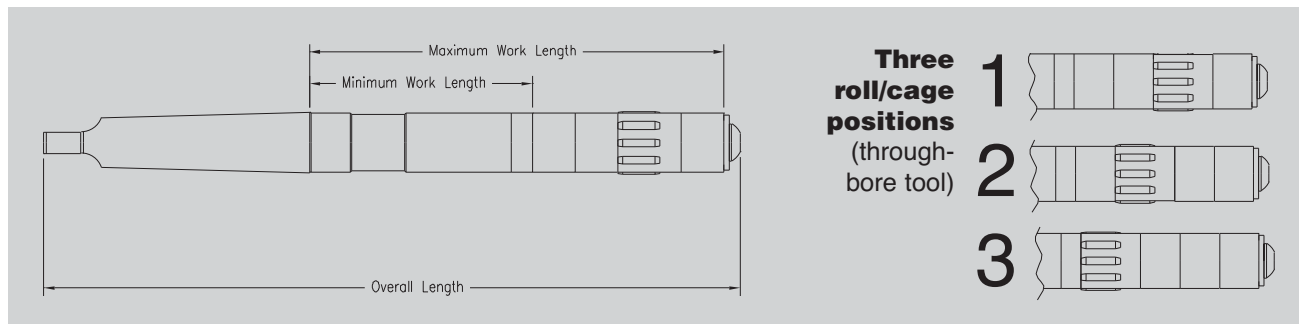


Standard tool specifications

Bearingizing tools provide three roll positions over the cammed arbor (see below). When the forward (#1 position) of cam becomes worn, the roll cage can be repositioned to the #2 and #3 positions by exchanging positions with the moveable collars. This presents NEW cam surfaces and original BUILD-UP. After all positions

on the cam are worn beyond producing acceptable parts, oversize rolls can be used to further extend tool life. Roll sizes are available in increments of .0025 mm (.0001inch) and the tool will accommodate a range of roll sizes up to .0508 mm (.002 inch).

For through-hole, semi-bottoming, or bottoming applications.



Bearingizing Tools 4.76 to 31.75 mm (.188 to 1.250 in.)

NOMINAL TOOL SIZE		BUILD-UP RANGE		CAM DIAMETER		SHANK	OVERALL LENGTH		WORK LENGTH				NO. OF ROLLS
									MAXIMUM		MINIMUM		
MM	INCHES	MM	INCHES	MM	INCHES		MM	INCHES	MM	INCHES	MM	INCHES	
4.76	.188	4.727 4.829	.1861 .1901	3.254	.1281	#1 MT	139.7	5.5	74.61	2.938	55.56	2.188	6
5.56	.219	5.522 5.624	.2174 .2214	4.049	.1594	#1 MT	139.7	5.5	74.61	2.938	55.56	2.188	6
6	.236	5.951 6.053	.2343 .2383	4.242	.1670	#1 MT	152.4	6	87.31	3.438	60.32	2.375	6
6.35	.250	6.314 6.416	.2486 .2526	4.587	.1806	#1 MT	152.4	6	87.31	3.438	60.32	2.375	6
7	.276	6.967 7.069	.2743 .2783	5.243	.2064	#1 MT	152.4	6	87.31	3.438	58.74	2.313	6
7.14	.281	7.109 7.211	.2799 .2839	5.382	.2119	#1 MT	152.4	6	87.31	3.438	58.74	2.313	6
7.94	.313	7.904 8.006	.3112 .3152	5.618	.2212	#1 MT	152.4	6	87.31	3.438	58.74	2.313	6
8	.315	7.968 8.069	.3137 .3177	5.667	.2238	#1 MT	152.4	6	87.31	3.438	58.74	2.313	6
8.73	.343	8.700 8.801	.3425 .3465	6.414	.2525	#1 MT	177.8	7	112.71	4.438	77.79	3.063	6
9	.354	8.966 9.068	.3530 .3570	6.683	.2631	#1 MT	177.8	7	112.71	4.438	77.79	3.063	6
9.53	.375	9.495 9.596	.3738 .3778	6.396	.2518	#1 MT	177.8	7.	112.71	4.438	79.38	3.125	6
10	.394	9.970 10.071	.3965 .3925	6.871	.2705	#1 MT	177.8	7	112.71	4.438	79.38	3.125	6
10.32	.406	10.290 10.391	.4051 .4091	7.191	.2831	#1 MT	203.2	8	138.11	5.438	90.49	3.563	6
11	.433	10.973 11.074	.4320 .4360	7.059	.2779	#1 MT	203.2	8	138.11	5.438	93.66	3.688	6
11.11	.438	11.087 11.189	.4365 .4405	7.176	.2825	#1 MT	203.2	8	138.11	5.438	93.66	3.688	6
11.91	.469	11.882 11.984	.4678 .4718	7.971	.3138	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
12	.472	11.963 12.065	.4710 .4750	8.062	.3174	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8

Standard tool specifications

Bearingizing Tools 4.76 to 31.75 mm (.188 to 1.250 in.)

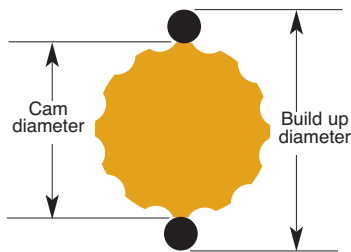
NOMINAL TOOL SIZE		BUILD-UP RANGE		CAM DIAMETER		SHANK	OVERALL LENGTH		WORK LENGTH				NO. OF ROLLS
MM	INCHES	MM	INCHES	MM	INCHES		MM	INCHES	MM	INCHES	MM	INCHES	
12.7	.500	12.675 12.776	.4990 .5030	8.763	.3450	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
13	.512	12.979 13.081	.5110 .5150	9.063	.3568	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
13.49	.531	13.470 13.571	.5303 .5343	9.558	.3763	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
14	.551	13.970 14.072	.5500 .5540	10.063	.3962	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
14.29	.563	14.262 14.364	.5615 .5655	10.351	.4075	#1 MT	203.2	8	138.11	5.438	93.66	3.688	8
15	.591	15.077 14.976	.5936 .5896	11.064	.4356	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
15.09	.594	15.057 15.159	.5928 .5968	11.146	.4388	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
15.87	.625	15.850 15.951	.6240 .6280	10.151	.4390	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
16	.630	15.977 16.078	.6290 .6330	11.275	.4439	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
16.67	.656	16.645 16.746	.6553 .6593	11.946	.4703	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
17	.669	16.967 17.069	.6680 .6720	12.276	.4833	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
17.46	.688	17.437 17.539	.6865 .6905	12.738	.5015	#2 MT	203.2	8	123.83	4.875	79.38	3.125	8
18	.709	17.983 18.085	.7080 .7120	13.277	.5227	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
18.26	.719	18.232 18.334	.7178 .7218	13.533	.5328	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
19	.748	18.974 19.075	.7470 .7510	14.275	.5620	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
19.05	.750	19.025 19.126	.7490 .7530	14.326	.5640	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
19.84	.781	19.820 19.921	.7803 .7843	15.121	.5953	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
20	.787	19.964 20.066	.7860 .7900	15.276	.6014	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
20.64	.813	20.612 20.714	.8115 .8155	15.913	.6265	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
21	.827	20.980 21.082	.8260 .8300	15.276	.6408	#2 MT	203.2	8	123.83	4.875	79.38	3.125	10
21.43	.844	21.407 21.509	.8428 .8468	15.133	.5958	#2 MT	228.6	9	149.23	5.875	95.25	3.75	10
22	.866	21.971 22.076	.8650 .8690	15.700	.6181	#2 MT	228.6	9	149.23	5.875	95.25	3.75	10
22.22	.875	22.200 22.301	.8740 .8780	15.926	.6270	#2 MT	228.6	9	149.23	5.875	95.25	3.75	10
23	.905	22.987 23.087	.9050 .9090	16.721	.6583	#3 MT	254.0	10	155.58	6.125	101.60	4.00	10
23.02	.906	22.995 23.096	.9053 .9093	16.721	.6583	#3 MT	254.0	10	155.58	6.125	101.60	4.00	10
23.81	.938	23.787 23.889	.9365 .9405	17.513	.6895	#3 MT	254.0	10	155.58	6.125	101.60	4.00	10
24	.945	23.978 24.078	.9440 .9480	17.701	.6969	#3 MT	254.0	10	155.58	6.125	101.60	4.00	10
24.61	.969	24.582 24.684	.9678 .9718	18.308	.7208	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
25	.984	24.968 25.070	.9830 .9870	18.702	.7363	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
25.4	1.000	25.375 25.476	.9990 1.0030	19.101	.7520	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
26.99	1.063	26.962 27.064	1.0615 1.0655	20.688	.8145	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
28.57	1.125	28.550 28.651	1.1240 1.1280	22.276	.8770	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
30.16	1.188	30.137 30.239	1.1865 1.1905	23.863	.9395	#3 MT	254.0	10	155.58	6.125	101.60	4.00	12
31.75	1.250	31.725 31.826	1.2490 1.2530	23.851	.9390	#4 MT	279.4	11	155.58	6.125	101.60	4.00	14

Tools for hole diameters from 31.75 to 50.8mm (1.250 to 2.000 inches) are non-stocked standards; tools above 50.8mm (2.000 inches) are special. Shanks other than shown above are available upon request.

Selection & ordering information

To select a tool for the part and material to be Bearingized, determine the proper tool *build-up*. The build-up is the effective tool diameter required to produce a certain size in a given material. It is measured with the rolls diametrically opposed on the high surfaces of the cam.

The build-up is equal to the maximum finished hole diameter plus a spring-back allowance — see chart. The maximum diameter (high side of tolerance) is used to allow for tool wear and still maintain part size within tolerance limits.



Standard tool sizes

Tools are stocked in diameters of 4.7625mm (.187 inch) through 50.80mm (2.000 inch). Each tool provides a build-up range of .1016mm (.004 inch). The required build-up must be within the range of the tool size shown — otherwise select non-stocked tool. See ordering information at right.

EXAMPLE

Stainless Steel part	
12.725/12.720mm	
(.5010/.5008 inch) tolerance	12.7250
Add Stainless Steel spring-back allowance	+ .0254
Build-up	12.7504

Since a 12.75mm (.5020 inch) build-up falls within a range of 12.67-12.78mm (.4990-.5030 inch), order a standard 12.7mm (.500 inch) through-hole Bearingizing tool and rolls ... or order through-hole Bearingizing tool with 12.75mm (.5020 inch) build-up — Cogsdill will furnish proper tool and rolls.

Roll Sizes

To determine the roll size for a standard tool, subtract the cam diameter from the build-up and divide by two (2). This establishes the single roll diameter.

EXAMPLE

Build-up required for part	12.75mm (.5020 inch)
Subtract cam diameter of 12.75mm (.500 inch) tool	<u>- 8.76mm (.3450 inch)</u> 3.99mm (.1570 inch)
Divided by 2	$3.99\text{mm} \div 2 = 1.99\text{mm} (.0785 \text{ inch})$
Single roll size	1.99mm (.0785 inch)

**Order 12.77mm (.500 inch)
Bearingizing tool with
1.99mm (.0785 inch) rolls.**

Spring-Back Allowances	4.76 to 12.7 mm (.188 to .500)		12.7 mm & up (.500 & up)	
	mm	IN.	mm	IN.
Stainless	.0203	.0008	.0254	.001
Steel	.0203	.0008	.0254	.001
Cast Iron	.0127	.0005	.0203	.0008
Sintered Iron	.0127	.0005	.0203	.0008
Aluminum	.0050	.0002	.0102	.0004
Brass	.0127	.0005	.0203	.0008
Sintered Bronze	.0025	.0001	.0051	.0002
Oilite	.0025	.0001	.0051	.0002

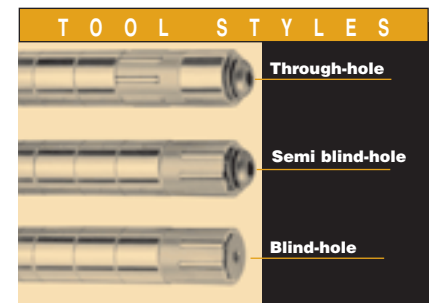
Note: Above are recommended starting points only. Final build-up can best be determined by actual trial and several extra sets of rolls in increments of .0025mm (.0001 inch) are recommended.

Ordering stocked tools

1 Specify tool size and roll diameter, or specify hole size and material.

2 Specify tool style: through-hole, semi-blind or blind-hole tool. Through-hole tools use chamfered rolls; semi-blind or blind-hole tools use radius rolls. Blind-hole tools have a special roll retainer which permits finishing within .635mm (.025 inch) of the bottom.

3 Extra sets of rolls in increments of .002mm (.0001 inch) are recommended with initial orders to allow for final size adjustment and compensate for eventual tool wear.



Ordering non-stocked tools

Intermediate sizes

Sizes that do not fall within the range of stocked tools are ordered by build-up only. Cogsdill will design tool and specify roll size.

Tools over 31.75mm (1.250 inch) in diameter

Order by build-up diameter. Cogsdill will design tool and specify roll size. We suggest that part print be furnished with inquiry. This will enable Cogsdill engineers to quote on any special features that may be desirable, such as extended front pilot, etc.

Re-ordering tools and parts

Re-order stocked tools and parts by fractional tool size shown on shank—except roll sizes, which should be determined by the required build-up. Re-order non-stocked tools and parts, including rolls by BT number shown on shank. If cams are worn, larger rolls may be required (available in increments of .0025mm (.0001 inch)). Cogsdill will also re-grind cams and supply rolls to maintain original build-up.

Operation & maintenance

Machines

Any machine capable of rotating the tool — e.g. drill press, speed lathe, or turret lathe — may be used.

Material

Any ductile or malleable material — powdered, laminated, cast, forged, extruded, sintered or hardened (maximum Rc 38) can be bearingized. Steel, stainless, alloy, cast iron, aluminum, copper and brass are examples.

Procedure

Proper part preparation is essential in order to obtain precise results. Cogsdill will recommend the surface preparation and amount of stock to leave for Bearingizing, but some trials may be required to determine these factors for optimum results.

Since the change in dimension is partly governed by the character of the prepared surface, usually coarser preparation will permit a greater change in dimension than is possible with finer preparation. The consistent pattern obtained from boring will produce the best finish.

The other major factor in dimensional change is the ability of the material to grain-flow without flaking. The total change may vary from .0025mm (.0001 inch) on harder materials to as much as .0762mm (.003 inch) on sintered self-lubricating bushings. Less than .0254mm (.001 inch) stock for Bearingizing generally provides a good starting point for trials.

Tool diameter changes

Bearingizing rolls are manufactured in increments of .0025mm (.0001 inch). Bearingizing Tools are adjustable by roll change only. One set of rolls can be removed and a new set of a different size installed, thus effectively changing the size of the tool — or compensating for tool wear. The working diameter of any tool can be changed over an approximate .1016mm (.004 inch) range by installing different sets of rolls. The rolls are diametrically opposed and available in .0025mm (.0001 inch) increments, therefore the effective tool diameter can be changed in .0051mm (.0002 inch) increments. (Refer to preceding page “Ordering Stocked Tools.”)

Lubrication

For most metals use any standard grade of lightweight, low viscosity lubricating oil, or any mineral, sulphur or soluble oil that is compatible with the alloy or metal to be burnished and is recommended for fine surface finishing.

For aluminum or magnesium alloys, use a highly refined oil-based coolant with low viscosity.

For cast iron a mineral seal or water soluble solution is ideal — flooding the part is recommended.

Cleaning

The Bearingizing tool should be cleaned periodically with a light-bodied oil of about 100 Saybolt universal scale, similar to a light spindle oil. A few drops applied with squirt can or brush to the rolls and cage (with cage stopped) will wash metal dust particles out when tool is operated, keeping the cam surfaces and roll pockets clean.

bearingizing tools