



COGSDILL TOOL

products, inc.

APPLICATION *news*

DATE October 31, 2007

NUMBER CAN2-07

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Universal™ Burnishing Tool Achieves Finish, Reduces Down Time

A job shop was machining a six-speed transmission hub for a major automotive manufacturer. Their production requirement is some 75,000 to 80,000 parts per year. They were achieving the desired size and finish, but changing cutting tool inserts every 20 to 50 parts. Although the carbide inserts were relatively inexpensive, down time for changing the insert and re-setting the machine was costly.

A Cogsdill UBT-B1 Universal Burnishing tool was applied. The tool is used to achieve the finish requirement of 10 to 24 microinch Ra. This allows for an increase in the number of parts per cutting tool insert (now averaging 750), for reduced down time, faster production, and lower costs.

A Quick Primer on Universal™ Burnishing Tools (UBT)

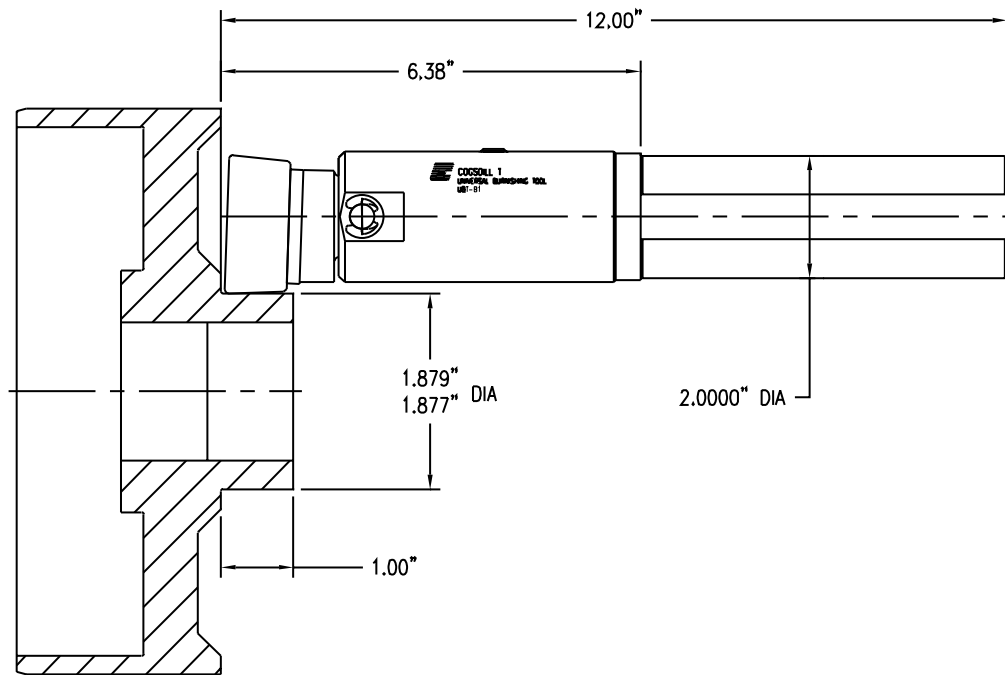
While Cogsdill's standard **Roll-a-Finish™** tools feature multiple rollers for burnishing a specific size diameter, either internal or external, our versatile **Universal™ Burnishing Tools (UBT™)** have a single roll for burnishing shafts, faces, tapers, contours, and relatively large IDs. A variety of tool designs, boring-bar style and turning-holder style, are available from stock to produce low surface finishes on any part size or configuration, on any turning machine. The tools are adjustable for optimum burnishing pressure, and are equipped with hardened steel or carbide rollers.

Note: UBT™ tools do not have the advantage of an overlapping effect as with multi-roll tools, and for this reason slower feed rates and/or multiple passes over the part may be required to produce the desired finish.

Refer to our full catalog on Burnishing Tools & Machines for more information on these and other burnishing products from Cogsdill Tool.

— see reverse side for tool and part drawing and application data —

Cogsdill Universal™ Burnishing Tool on six-speed automotive transmission hub



Application data	
Machine type	CNC lathe
Material type	Nodular cast iron
Tool type	UBT-B1 Universal Burnishing Tool
Spindle speed	1800 RPM
Feed rate	.0035 IPR
Cycle time	7 seconds
Coolant	Water-soluble
Size required	1.879-1.877 in.
Size achieved	As required
Finish required	10-24 microinch Ra
Finish achieved	10-20 microinch Ra