



FEATURES

- ★ Low Production Cost.
- ★ Close Dimensional Tolerance.
- ★ Work Hardened & Wear Resistant Surface.
- ★ Smooth Low Microinch Surface Finish.
- ★ Fatigue & Corrosion Resistant Surface.
- ★ Internal Dia, External Dia, Tapered, Radius and flat parts of Steel, Cast Iron, Aluminium, Bronze etc, of hardness up to 35 HRC can be quickly roller burnished.

Internal Burnishing Tools, Series - DT & DB



DT - Thru Bore Series

DB - Blind Bore Series

DT & DB series are designed to burnish long thru & blind bores upto 60 mm respectively.

In DT series rollers are positioned at a helix angle to provide self feed.

MODEL	BORE Ø mm	ADJ. RANGE mm	SHANK SIZE	REACH (mm)			
				R	R1	R2	R3
DT/DB 500-1000	05-10	-0.1/+0.2	MT2	50	90	150	NA
DT/DB 1100-1300	11-13	-0.1/+0.3	MT2	50	90	150	NA
DT/DB 1400-2400	14-24	-0.2/+0.4	MT2	50	90	150	300
DT/DB 2500-4000	25-40	-0.2/+0.6	MT2/MT3	100	150	300	400
DT/DB 4100-6000	41-60	-0.2/+0.6	MT2/MT3	100	150	300	400

Internal Burnishing Tools, Series - DE & DU



DE - Thru Bore Series.

DU - Blind Bore Series.

DE & DU series are designed to burnish long thru & blind bores of 61mm and above respectively.

Model	Bore Ø mm	Adj. Range mm	Shank size	Reach mm
DE/DU 6100-12400	61-124	-0.2/+0.7	MT3/MT4	300
DE/DU 12500-15000	125-150	-0.2/+0.7	MT4/MT5	350

Note : Tools of higher reach & bigger dia are available on request.

Internal Burnishing Tools, Series - DST & DSB



DST - Thru Bore Series

DSB - Blind Bore Series

DST & DSB series have small adjustment range and is designed to burnish short bores like bearing housings etc.

MODEL	BORE SIZE Ø mm	ADJ. RANGE mm	SHANK SIZE	REACH mm	BEARING SIZE
DST/DSB 1600	16	-0.05/+0.10	MT2	50	625
DST/DSB 1900	19	-0.05/+0.10	MT2	50	607
DST/DSB 2200	22	-0.05/+0.10	MT2	50	608,627
DST/DSB 3000	30	-0.05/+0.10	MT2	50	6200
DST/DSB 3200	32	-0.05/+0.10	MT2	50	6201
DST/DSB 3500	35	-0.05/+0.10	MT2	50	6202
DST/DSB 4000	40	-0.05/+0.10	MT2	100	6203
DST/DSB 4200	42	-0.05/+0.10	MT2	100	6302
DST/DSB 4700	47	-0.05/+0.15	MT2	100	6204,6303
DST/DSB 5200	52	-0.05/+0.15	MT2	100	6205,6304
DST/DSB 6200	62	-0.05/+0.15	MT2	100	6206,6305

External Burnishing Tools, Series - DPO & DSO



DPO - Plain Shaft Series.

DSO - Stepped Shaft Series.

DPO & DSO series are designed to burnish outside diameter of plain and stepped cylindrical parts like shafts rotating in bushings or bearings etc.

MODEL	ADJ. RANGE (mm)	SHANK SIZE*	REACH (mm)
DPO/DSO 200-1600	+0.10/-0.40	MT2	80
DPO/DSO 1700-3000	+0.10/-0.50	MT3	120
DPO/DSO 3100-4000	+0.10/-0.60	MT4	130
DPO/DSO 4000-6000	+0.10/-0.60	MT4/MT5	350

* Hollow straight shank can be provided for long shafts, on request.

SPEED & FEED RECOMENDATIONS

Diameter $\varnothing$ mm	RPM	Feed mm/rev
5.0 - 11.0	2100 - 1000	0.2 - 0.3
12.0 - 24.0	1500 - 750	0.4 - 0.6
25.0 - 37.0	1000 - 400	0.7 - 1.0
38.0 - 49.0	700 - 300	1.5 - 1.8
50.0 - 64.0	500 - 200	2.0 - 2.3
65.0 - 89.0	400 - 150	2.5 - 2.8
90.0 - 149.0	300 - 100	3.3 - 3.8
150.0 - 200.0	200 - 50	4.0 - 5.3

STOCK ALLOWANCE / SURFACE FINISH

	DIAMETER $\varnothing$ mm	BURNISHING ALLOWANCE mm	SURFACE FINISH	
			MACHINED $\mu\text{m Ra}$	BURNISHED $\mu\text{m Ra}$
High ductile material	3 - 12	0.010	2.0	0.2
		0.017	3.1	0.2
	13 - 25	0.017	1.5	0.2
		0.040	3.1	0.2
	26 - 50	0.025	1.5	0.2
		0.050	3.1	0.2
	51 - 200	0.040	1.5	0.2
		0.075	5.0	0.2
Low ductile material	3 - 12	0.010	2.0	0.4
		0.017	2.5	0.4
	13 - 25	0.017	2.2	0.4
		0.025	3.1	0.4
	26 - 50	0.025	3.1	0.4
		0.040	4.5	0.4
	51 - 200	0.040	3.0	0.4
		0.050	5.0	0.6

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NOTE : As we are constantly upgrading our products, specifications are subject to change without notice.