



# ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Drilling



Boring



Reaming



Threading



Specials



## Roller Burnishing

► *BURNISHING*

Finishing Solutions by S.C.A.M.I.®

**S.C.A.M.I.®**



SECTION

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D

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Burnishing

# Roller Burnishing Systems

Through Hole Style | Blind Hole Style



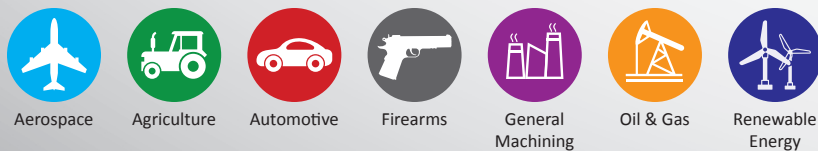
## Get the Finish You Need

Allied Machine is proud to offer roller burnishing tools from S.C.A.M.I. These hole finishing tools provide 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.

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

## Applicable Industries



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**

**WARNING** (shown above) 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](http://www.alliedmachine.com) for the most up-to-date information and procedures.

# Roller Burnishing Systems Contents

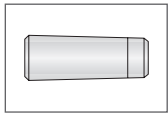
## Reference Icons

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



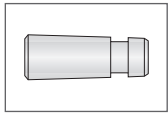
### Technical Information

Detailed instructions and information regarding the corresponding part(s)



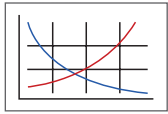
### Through Hole Rolls

Refers to the rolls available for through hole burnishing tools



### Blind Hole Rolls

Refers to the rolls available for blind hole burnishing tools



### Recommended Cutting Data

Speed and feed recommendations for optimum and safe burnishing

| Series | Diameter Range  |                 |
|--------|-----------------|-----------------|
|        | Imperial (inch) | Metric (mm)     |
| H      | 0.1555 - 0.5028 | 3.95 - 12.77    |
| I      | 0.4976 - 0.6634 | 12.64 - 16.85   |
| K      | 0.6535 - 0.9740 | 16.60 - 24.74   |
| L      | 0.9661 - 1.2268 | 24.54 - 31.16   |
| F      | 0.9661 - 1.2268 | 24.54 - 31.16   |
| M      | 1.2146 - 1.4118 | 30.85 - 35.86   |
| N      | 1.4020 - 1.8492 | 35.61 - 46.97   |
| O      | 1.8390 - 2.2240 | 46.71 - 56.49   |
| P      | 2.2138 - 2.7240 | 56.23 - 69.19   |
| Q      | 2.7138 - 3.3492 | 68.93 - 85.07   |
| R      | 3.3390 - 4.0992 | 84.81 - 104.12  |
| S      | 4.0890 - 5.0370 | 103.86 - 127.94 |
| T      | 5.0354 - 5.9016 | 127.90 - 149.90 |
| U      | 5.9016 - 6.5315 | 149.90 - 165.90 |



Allied Machine & Engineering offers ALVAN® Burnishers through an exclusive supply agreement with S.C.A.M.I. s.n.c.

S.C.A.M.I. is an Italian manufacturer that has been producing high-quality cutting tools for over 40 years.

For additional information about all Allied Machine products, visit [www.alliedmachine.com](http://www.alliedmachine.com). For technical assistance, contact our Application Engineering department.  
ext: 7611 | email: [appeng@alliedmachine.com](mailto:appeng@alliedmachine.com)

## Introduction Information

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## Burnishing Series

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| O Series . . . . . | 24 - 25 |
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## Recommended Cutting Data

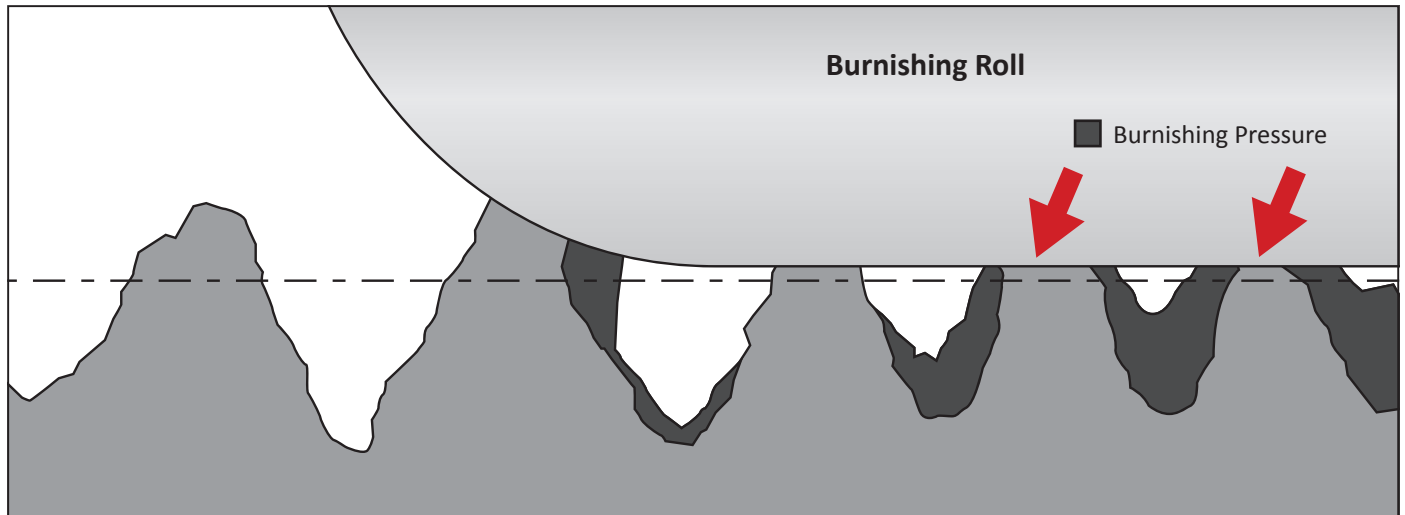
|                           |         |
|---------------------------|---------|
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## Roller Burnishing Overview

### 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.



#### Advantages of Roller Burnishing: Metallurgical Properties

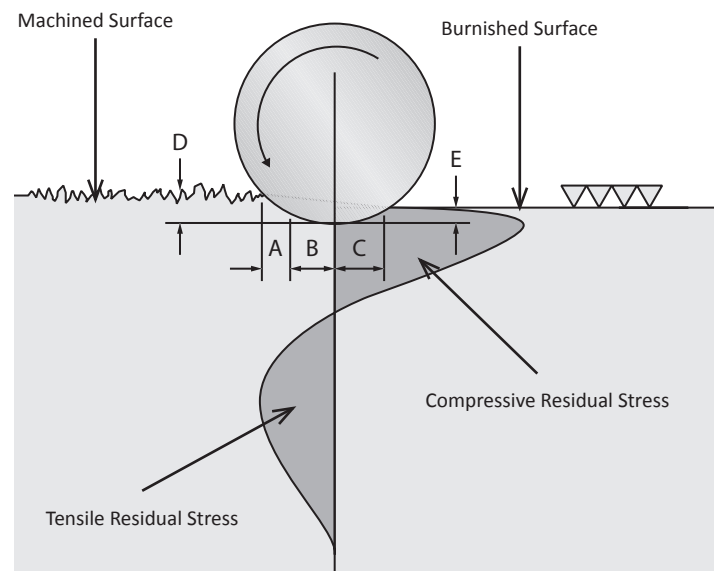
- Grain structure is condensed and refined.
- The compacted surface is **smoother, harder, and more wear resistant** than ground or honed surfaces.
- The process reduces surface porosity and also removes scratches that could hold reactive substances or contaminants. **This increases the corrosion resistance.**
- 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 1mm below the surface. This increases the surface hardness.



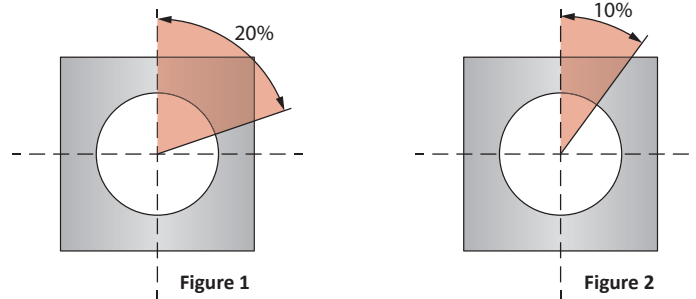
## Roller Burnishing Overview

### 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).



- **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.

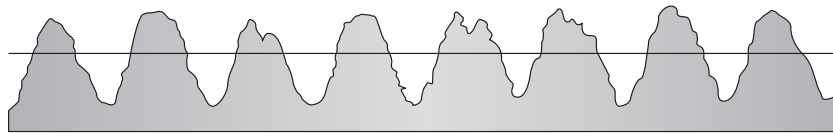


Figure 3

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).

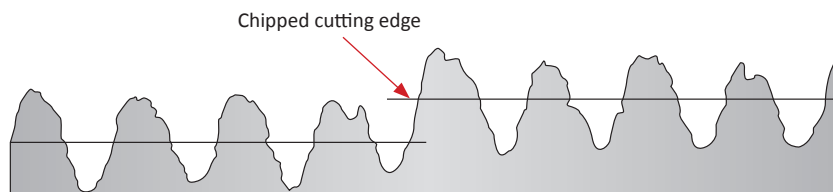


Figure 4

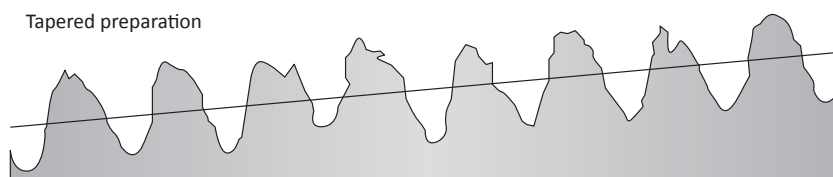


Figure 5

## Product Offering



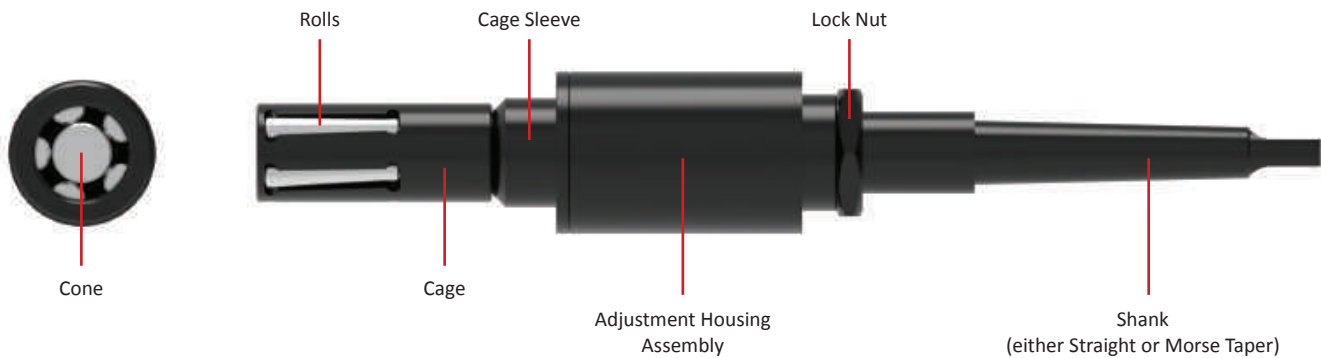
**Through Hole Style**  
0.1555" - 6.5315" (3.95 mm - 165.90 mm)



**Blind Hole Style**  
0.2319" - 6.5315" (5.89 mm - 165.90 mm)

### *Advantages* of the Roller Burnishing Tool

- ✔ **Provides accurate size control**  
 tolerances within 0.0005" or better (depending on variables such as material)
- ✔ **Produces fine surface finishes**  
 between 1 - 10 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:

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



**Product Selection Guide**

| Series  | Diameter Range (inch / mm)  |   |   |   |   |  | Length  |                                     |                                     |                                     |                                     |
|---------|---|---|---|---|---|--|---|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|
|         | 0 - 1   | 1 - 2   | 2 - 3   | 3 - 4   | 4 - 5   | 5 - 6  | 6 - 7   | Short                               | Standard                            | Long                                | Unlimited                           |
|         | 0 - 25.4  | 25.4 - 50.8   | 50.8 - 76.2   | 76.2 - 101.6  | 101.6 - 127   | 127 - 152.4  | 152.4 - 177.8   |                                     |                                     |                                     |                                     |
| H* Mini |  |   |   |   |   |  |   | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |                                     |                                     |
| H*      |  |   |   |   |   |  |   | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |                                     |
| I       |  |   |   |   |   |  |   | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |                                     |
| K       |  |   |   |   |   |  |   | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |                                     |
| L       |   |    |   |   |   |  |   | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> |                                     |
| F       |   |    |   |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| M       |   |    |   |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| N       |   |    |   |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| O       |   |  |   |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| P       |   |   |  |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| Q       |   |   |  |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| R       |   |   |   |  |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| S       |   |   |   |   |  |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| T       |   |   |   |   |   |  |   |                                     |                                     |                                     | <input checked="" type="checkbox"/> |
| U       |   |   |   |   |   |  |  |                                     |                                     |                                     | <input checked="" type="checkbox"/> |

\*For H series: Through hole tools start at 0.1555" (3.95 mm) and blind hole tools start at 0.2319" (5.89mm)

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 24.64mm 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 diameter.

## Product Nomenclature

### Roller Burnishing Tools

|            |          |   |          |          |          |   |               |
|------------|----------|---|----------|----------|----------|---|---------------|
| <b>RDK</b> | <b>H</b> | - | <b>2</b> | <b>1</b> | <b>0</b> | - | <b>004,70</b> |
| 1          | 2        |   | 3        | 4        | 5        |   | 6             |

|  |  |   |
|--|--|---|
| <b>1. Type of Burnisher</b><br>RDK = Through holes<br>RSK = Blind holes    | <b>2. Series</b><br>H = H series    F = F series    P = P series    T = T series<br>I = I series    M = M series    Q = Q series    U = U series<br>K = K series    N = N series    R = R series<br>L = L series    O = O series    S = S series | <b>3. Shank Type</b><br>0 = Straight (mini)<br>1 = Straight<br>2 = Morse Taper  |
| <b>4. Length</b><br>0 = Unlimited<br>1 = Short<br>2 = Standard<br>3 = Long | <b>5. Cage Style</b><br>0 = Standard<br>2 = Mini   | <b>6. Diameter</b><br>Through Hole Tools = Minimum diameter of burnishing range<br>Blind Hole Tools = 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 0.5mm on diameter for tools below 12.7 mm
- Approximately 1.0mm on diameter for tools above 12.7 mm

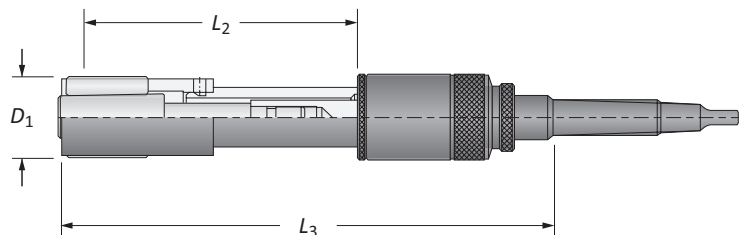
For through hole burnishing tools, the standard cone value "x" is 1. If the standard cone is used for blind hole burnishing, the only way it will not extend past the end of the rolls is to reduce the length of the cone. The required length reduction is dependent on the set diameter versus the minimum 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.

|  |  |  |
|--|--|--|
| <b>Diameter (5.89 mm - 12.77 mm)</b><br>$x = 1 + \frac{Z - Y}{0.05}$ Z = diameter of the hole<br>Y = minimum diameter setting of tool<br><b>Example:</b> Z = 11.05 Y = 10.71mm<br>$x = 1 + \frac{11.05 - 10.71}{0.05} = 7.8$ which is approximated at "x" = 8<br><b>Correct Cone:</b> RSTH-038-11025 | <b>Diameter (12.64 mm - 127.94 mm)</b><br>$x = 1 + \frac{Z - Y}{0.10}$ Z = diameter of the hole<br>Y = minimum diameter setting of tool<br><b>Example:</b> Z = 17.76 Y = 17.40mm<br>$x = 1 + \frac{17.76 - 17.40}{0.10} = 4.6$ which is approximated at "x" = 4<br><b>Correct Cone:</b> RSTK-034-00044 | <b>Diameter (127.90 mm - 165.90 mm)</b><br>$xx = 31 + \frac{Z - Y}{0.10}$ Z = diameter of the hole<br>Y = minimum diameter setting of tool<br><b>Example:</b> Z = 148.20 Y = 147.90mm<br>$xx = 31 + \frac{148.20 - 147.90}{0.10} = 34$ <b>Correct Cone:</b> RSTT-034-01480 |
|--|--|--|

### Reference Key

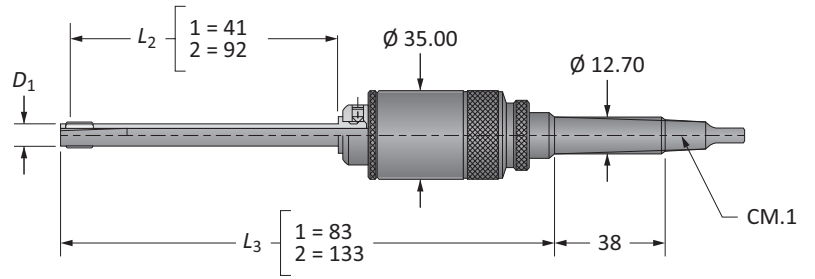
| Symbol         | Attribute         |
|----------------|-------------------|
| D <sub>1</sub> | Diameter range    |
| L <sub>2</sub> | Burnishing length |
| L <sub>3</sub> | Reference length  |





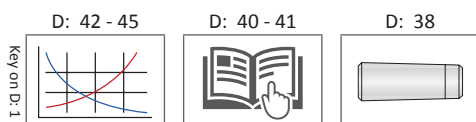
## Roller Burnishing Tools | Through Holes

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



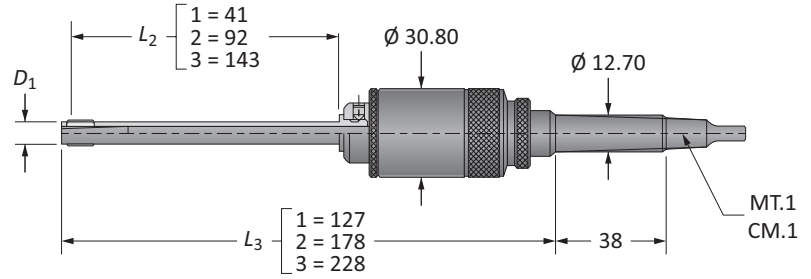
| $D_1$           |             | $L$ | Part No.<br>Assembly with<br>Straight Shank | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|-------------|-----|---|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm) |     |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

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



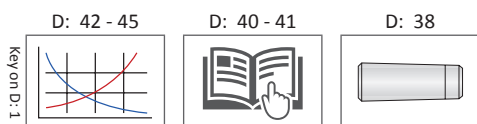
## Roller Burnishing Tools | Through Holes

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



| D <sub>1</sub>  |             | L | Part No.                        |                              | Spare Parts    |                |                | Qty Rolls |
|-----------------|-------------|---|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm) |   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          |           |
| 0.1850 - 0.1929 | 4.70 - 4.90 | 1 | RDKH-210-00470                  | RDKH-110-00470               | RDCH-011-10012 | RDTH-031-10012 | RDRY-704-00062 | 3         |
| 0.1850 - 0.1929 | 4.70 - 4.90 | 2 | RDKH-220-00470                  | RDKH-120-00470               | RDCH-011-20012 | RDTH-031-20012 | RDRY-704-00062 | 3         |
| 0.1850 - 0.1929 | 4.70 - 4.90 | 3 | RDKH-230-00470                  | RDKH-130-00470               | RDCH-011-30012 | RDTH-031-30012 | RDRY-704-00062 | 3         |
| 0.1917 - 0.2035 | 4.87 - 5.17 | 1 | RDKH-210-00487                  | RDKH-110-00487               | RDCH-011-10011 | RSTH-033-10012 | RDRY-704-00062 | 3         |
| 0.1917 - 0.2035 | 4.87 - 5.17 | 2 | RDKH-220-00487                  | RDKH-120-00487               | RDCH-011-20011 | RSTH-033-20012 | RDRY-704-00062 | 3         |
| 0.1917 - 0.2035 | 4.87 - 5.17 | 3 | RDKH-230-00487                  | RDKH-130-00487               | RDCH-011-30011 | RSTH-033-30012 | RDRY-704-00062 | 3         |
| 0.1996 - 0.2200 | 5.07 - 5.59 | 1 | RDKH-210-00507                  | RDKH-110-00507               | RDCH-011-10013 | RDTH-031-10013 | RDRY-704-00062 | 5         |
| 0.1996 - 0.2200 | 5.07 - 5.59 | 2 | RDKH-220-00507                  | RDKH-120-00507               | RDCH-011-20013 | RDTH-031-20013 | RDRY-704-00062 | 5         |
| 0.1996 - 0.2200 | 5.07 - 5.59 | 3 | RDKH-230-00507                  | RDKH-130-00507               | RDCH-011-30013 | RDTH-031-30013 | RDRY-704-00062 | 5         |
| 0.2161 - 0.2358 | 5.49 - 5.99 | 1 | RDKH-210-00549                  | RDKH-110-00549               | RDCH-011-10014 | RDTH-031-10013 | RDRY-704-00070 | 5         |
| 0.2161 - 0.2358 | 5.49 - 5.99 | 2 | RDKH-220-00549                  | RDKH-120-00549               | RDCH-011-20014 | RDTH-031-20013 | RDRY-704-00070 | 5         |
| 0.2161 - 0.2358 | 5.49 - 5.99 | 3 | RDKH-230-00549                  | RDKH-130-00549               | RDCH-011-30014 | RDTH-031-30013 | RDRY-704-00070 | 5         |
| 0.2319 - 0.2524 | 5.89 - 6.41 | 1 | RDKH-210-00589                  | RDKH-110-00589               | RDCH-011-10015 | RDTH-031-10015 | RDRY-704-00070 | 5         |
| 0.2319 - 0.2524 | 5.89 - 6.41 | 2 | RDKH-220-00589                  | RDKH-120-00589               | RDCH-011-20015 | RDTH-031-20015 | RDRY-704-00070 | 5         |
| 0.2319 - 0.2524 | 5.89 - 6.41 | 3 | RDKH-230-00589                  | RDKH-130-00589               | RDCH-011-30015 | RDTH-031-30015 | RDRY-704-00070 | 5         |
| 0.2484 - 0.2681 | 6.31 - 6.81 | 1 | RDKH-210-00631                  | RDKH-110-00631               | RDCH-011-10016 | RDTH-031-10015 | RDRY-704-00078 | 5         |
| 0.2484 - 0.2681 | 6.31 - 6.81 | 2 | RDKH-220-00631                  | RDKH-120-00631               | RDCH-011-20016 | RDTH-031-20015 | RDRY-704-00078 | 5         |
| 0.2484 - 0.2681 | 6.31 - 6.81 | 3 | RDKH-230-00631                  | RDKH-130-00631               | RDCH-011-30016 | RDTH-031-30015 | RDRY-704-00078 | 5         |
| 0.2642 - 0.2839 | 6.71 - 7.21 | 1 | RDKH-210-00671                  | RDKH-110-00671               | RDCH-011-10017 | RDTH-031-10017 | RDRY-704-00078 | 5         |
| 0.2642 - 0.2839 | 6.71 - 7.21 | 2 | RDKH-220-00671                  | RDKH-120-00671               | RDCH-011-20017 | RDTH-031-20017 | RDRY-704-00078 | 5         |
| 0.2642 - 0.2839 | 6.71 - 7.21 | 3 | RDKH-230-00671                  | RDKH-130-00671               | RDCH-011-30017 | RDTH-031-30017 | RDRY-704-00078 | 5         |
| 0.2803 - 0.3000 | 7.12 - 7.62 | 1 | RDKH-210-00712                  | RDKH-110-00712               | RDCH-011-10018 | RDTH-031-10017 | RDRY-704-00086 | 5         |
| 0.2803 - 0.3000 | 7.12 - 7.62 | 2 | RDKH-220-00712                  | RDKH-120-00712               | RDCH-011-20018 | RDTH-031-20017 | RDRY-704-00086 | 5         |
| 0.2803 - 0.3000 | 7.12 - 7.62 | 3 | RDKH-230-00712                  | RDKH-130-00712               | RDCH-011-30018 | RDTH-031-30017 | RDRY-704-00086 | 5         |
| 0.2945 - 0.3142 | 7.48 - 7.98 | 1 | RDKH-210-00748                  | RDKH-110-00748               | RDCH-011-10019 | RDTH-031-10019 | RDRY-704-00086 | 5         |
| 0.2945 - 0.3142 | 7.48 - 7.98 | 2 | RDKH-220-00748                  | RDKH-120-00748               | RDCH-011-20019 | RDTH-031-20019 | RDRY-704-00086 | 5         |
| 0.2945 - 0.3142 | 7.48 - 7.98 | 3 | RDKH-230-00748                  | RDKH-130-00748               | RDCH-011-30019 | RDTH-031-30019 | RDRY-704-00086 | 5         |
| 0.3102 - 0.3299 | 7.88 - 8.38 | 1 | RDKH-210-00788                  | RDKH-110-00788               | RDCH-011-10020 | RDTH-031-10019 | RDRY-704-00093 | 5         |
| 0.3102 - 0.3299 | 7.88 - 8.38 | 2 | RDKH-220-00788                  | RDKH-120-00788               | RDCH-011-20020 | RDTH-031-20019 | RDRY-704-00093 | 5         |
| 0.3102 - 0.3299 | 7.88 - 8.38 | 3 | RDKH-230-00788                  | RDKH-130-00788               | RDCH-011-30020 | RDTH-031-30019 | RDRY-704-00093 | 5         |
| 0.3260 - 0.3461 | 8.28 - 8.79 | 1 | RDKH-210-00828                  | RDKH-110-00828               | RDCH-011-10021 | RDTH-031-10021 | RDRY-704-00093 | 5         |
| 0.3260 - 0.3461 | 8.28 - 8.79 | 2 | RDKH-220-00828                  | RDKH-120-00828               | RDCH-011-20021 | RDTH-031-20021 | RDRY-704-00093 | 5         |
| 0.3260 - 0.3461 | 8.28 - 8.79 | 3 | RDKH-230-00828                  | RDKH-130-00828               | RDCH-011-30021 | RDTH-031-30021 | RDRY-704-00093 | 5         |

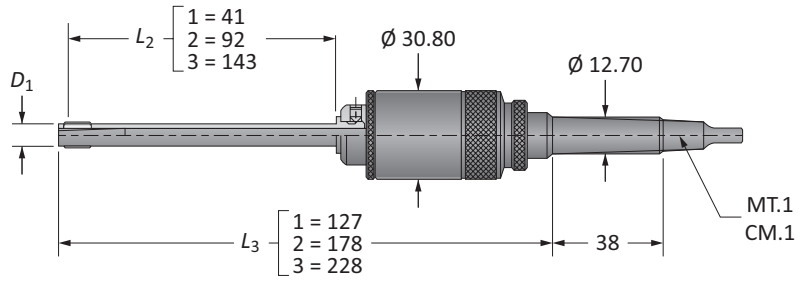
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





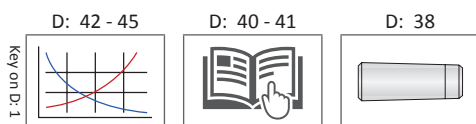
## Roller Burnishing Tools | Through Holes (continued)

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



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

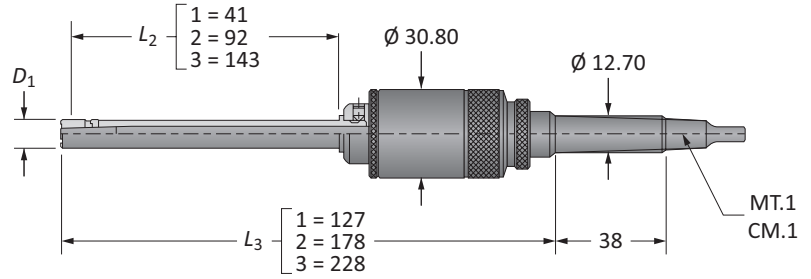
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



H  
A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

**Roller Burnishing Tools | Blind Holes**

H Series | Diameter Range: 0.2319" - 0.5028" (5.89 mm - 12.77 mm)



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

\*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 D: 6 for the correct identification of the "x" value.

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

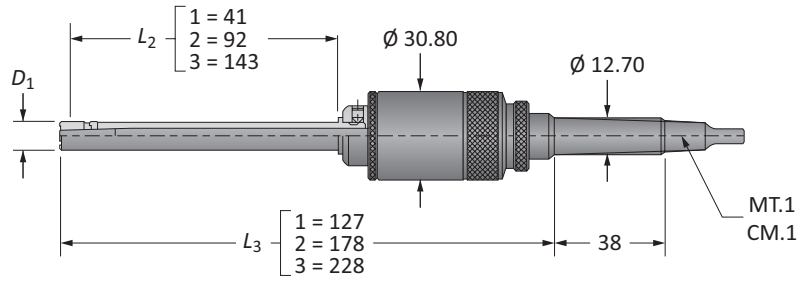
D: 42 - 45      D: 40 - 41      D: 39

Key on D: 1



## Roller Burnishing Tools | Blind Holes (continued)

H Series | Diameter Range: 0.2319" - 0.5028" (5.89 mm - 12.77 mm)

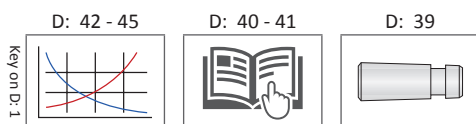


| $D_1$           |               | $L$ | Part No.*                       |                              | Spare Parts    |                |                | Qty Rolls |
|-----------------|---------------|-----|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|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

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. short series roller burnisher  $\varnothing 10.25$  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 D: 6 for the correct identification of the "x" value.

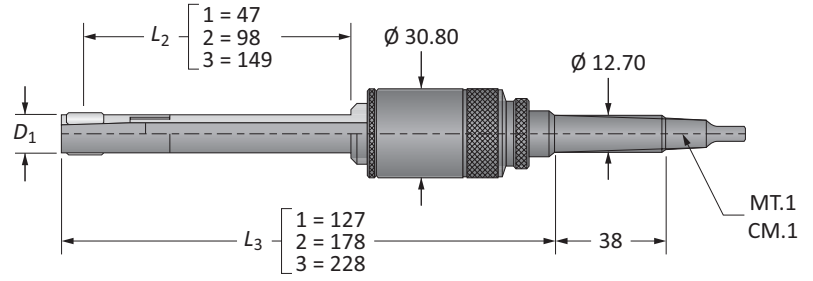
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

## Roller Burnishing Tools | Through Holes

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



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

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

Key on D: 1

D: 42 - 45

D: 40 - 41

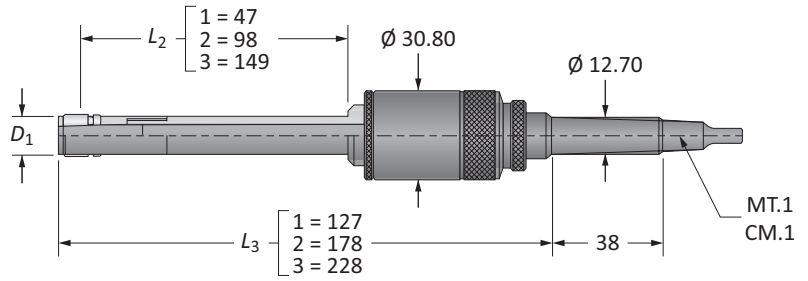
D: 38





## Roller Burnishing Tools | Blind Holes

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



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

\*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 D: 6 for the correct identification of the "x" value.

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

D: 42 - 45

D: 40 - 41

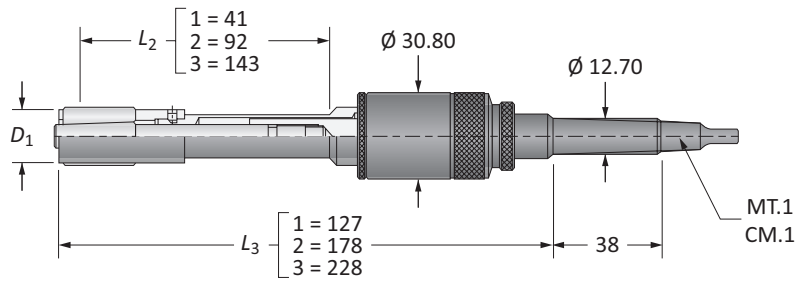
D: 39

Key on D: 1

A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

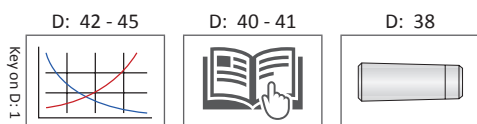
## Roller Burnishing Tools | Through Holes

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



| D <sub>1</sub>  |               | L | Part No.                           |                                 | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|---------------|---|------------------------------------|---------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)   |   | Assembly with<br>Morse Taper Shank | Assembly with<br>Straight Shank | Cage           | Cone           | Rolls          |              |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 1 | RDKK-210-01660                     | RDKK-110-01660                  | RDCK-011-00042 | RDTK-031-00042 | RDRY-701-00187 | 5            |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 2 | RDKK-220-01660                     | RDKK-120-01660                  | RDCK-011-00042 | RDTK-031-00042 | RDRY-701-00187 | 5            |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 3 | RDKK-230-01660                     | RDKK-130-01660                  | RDCK-011-00042 | RDTK-031-00042 | RDRY-701-00187 | 5            |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 1 | RDKK-210-01740                     | RDKK-110-01740                  | RDCK-011-00044 | RDTK-031-00044 | RDRY-701-00187 | 5            |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 2 | RDKK-220-01740                     | RDKK-120-01740                  | RDCK-011-00044 | RDTK-031-00044 | RDRY-701-00187 | 5            |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 3 | RDKK-230-01740                     | RDKK-130-01740                  | RDCK-011-00044 | RDTK-031-00044 | RDRY-701-00187 | 5            |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 1 | RDKK-210-01819                     | RDKK-110-01819                  | RDCK-011-00046 | RDTK-031-00042 | RDRY-701-00218 | 5            |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 2 | RDKK-220-01819                     | RDKK-120-01819                  | RDCK-011-00046 | RDTK-031-00042 | RDRY-701-00218 | 5            |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 3 | RDKK-230-01819                     | RDKK-130-01819                  | RDCK-011-00046 | RDTK-031-00042 | RDRY-701-00218 | 5            |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 1 | RDKK-210-01896                     | RDKK-110-01896                  | RDCK-011-00048 | RDTK-031-00044 | RDRY-701-00218 | 5            |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 2 | RDKK-220-01896                     | RDKK-120-01896                  | RDCK-011-00048 | RDTK-031-00044 | RDRY-701-00218 | 5            |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 3 | RDKK-230-01896                     | RDKK-130-01896                  | RDCK-011-00048 | RDTK-031-00044 | RDRY-701-00218 | 5            |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 1 | RDKK-210-01974                     | RDKK-110-01974                  | RDCK-011-00050 | RDTK-031-00050 | RDRY-701-00218 | 5            |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 2 | RDKK-220-01974                     | RDKK-120-01974                  | RDCK-011-00050 | RDTK-031-00050 | RDRY-701-00218 | 5            |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 3 | RDKK-230-01974                     | RDKK-130-01974                  | RDCK-011-00050 | RDTK-031-00050 | RDRY-701-00218 | 5            |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 1 | RDKK-210-02052                     | RDKK-110-02052                  | RDCK-011-00052 | RDTK-031-00052 | RDRY-701-00218 | 5            |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 2 | RDKK-220-02052                     | RDKK-120-02052                  | RDCK-011-00052 | RDTK-031-00052 | RDRY-701-00218 | 5            |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 3 | RDKK-230-02052                     | RDKK-130-02052                  | RDCK-011-00052 | RDTK-031-00052 | RDRY-701-00218 | 5            |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 1 | RDKK-210-02131                     | RDKK-110-02131                  | RDCK-011-00054 | RDTK-031-00054 | RDRY-701-00218 | 5            |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 2 | RDKK-220-02131                     | RDKK-120-02131                  | RDCK-011-00054 | RDTK-031-00054 | RDRY-701-00218 | 5            |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 3 | RDKK-230-02131                     | RDKK-130-02131                  | RDCK-011-00054 | RDTK-031-00054 | RDRY-701-00218 | 5            |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 1 | RDKK-210-02213                     | RDKK-110-02213                  | RDCK-011-00056 | RDTK-031-00050 | RDRY-701-00265 | 5            |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 2 | RDKK-220-02213                     | RDKK-120-02213                  | RDCK-011-00056 | RDTK-031-00050 | RDRY-701-00265 | 5            |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 3 | RDKK-230-02213                     | RDKK-130-02213                  | RDCK-011-00056 | RDTK-031-00050 | RDRY-701-00265 | 5            |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 1 | RDKK-210-02291                     | RDKK-110-02291                  | RDCK-011-00058 | RDTK-031-00052 | RDRY-701-00265 | 5            |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 2 | RDKK-220-02291                     | RDKK-120-02291                  | RDCK-011-00058 | RDTK-031-00052 | RDRY-701-00265 | 5            |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 3 | RDKK-230-02291                     | RDKK-130-02291                  | RDCK-011-00058 | RDTK-031-00052 | RDRY-701-00265 | 5            |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 1 | RDKK-210-02370                     | RDKK-110-02370                  | RDCK-011-00060 | RDTK-031-00054 | RDRY-701-00265 | 5            |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 2 | RDKK-220-02370                     | RDKK-120-02370                  | RDCK-011-00060 | RDTK-031-00054 | RDRY-701-00265 | 5            |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 3 | RDKK-230-02370                     | RDKK-130-02370                  | RDCK-011-00060 | RDTK-031-00054 | RDRY-701-00265 | 5            |

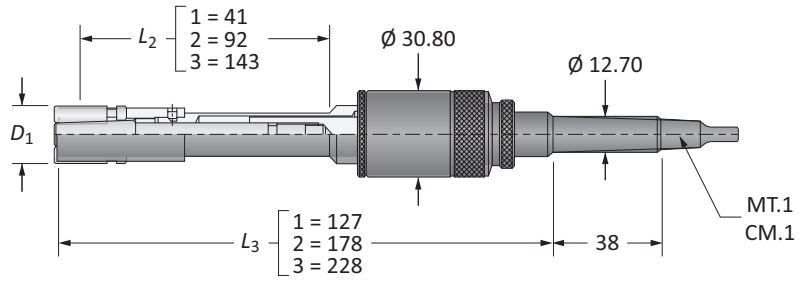
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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

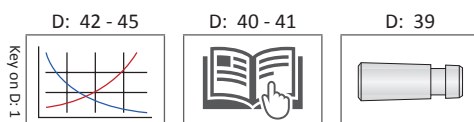


| $D_1$           |               | $L$ | Part No.*                       |                              | Spare Parts    |                |                | Qty Rolls |
|-----------------|---------------|-----|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   |     | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |           |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00042 | RSTK-03x-00042 | RSRY-708-00187 | 5         |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00042 | RSTK-03x-00042 | RSRY-708-00187 | 5         |
| 0.6535 - 0.6933 | 16.60 - 17.61 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00042 | RSTK-03x-00042 | RSRY-708-00187 | 5         |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00044 | RSTK-03x-00044 | RSRY-708-00187 | 5         |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00044 | RSTK-03x-00044 | RSRY-708-00187 | 5         |
| 0.6850 - 0.7240 | 17.40 - 18.39 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00044 | RSTK-03x-00044 | RSRY-708-00187 | 5         |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00046 | RSTK-03x-00042 | RSRY-708-00218 | 5         |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00046 | RSTK-03x-00042 | RSRY-708-00218 | 5         |
| 0.7161 - 0.7551 | 18.19 - 19.18 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00046 | RSTK-03x-00042 | RSRY-708-00218 | 5         |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00048 | RSTK-03x-00044 | RSRY-708-00218 | 5         |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00048 | RSTK-03x-00044 | RSRY-708-00218 | 5         |
| 0.7465 - 0.7870 | 18.96 - 19.99 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00048 | RSTK-03x-00044 | RSRY-708-00218 | 5         |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00050 | RSTK-03x-00050 | RSRY-708-00218 | 5         |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00050 | RSTK-03x-00050 | RSRY-708-00218 | 5         |
| 0.7772 - 0.8177 | 19.74 - 20.77 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00050 | RSTK-03x-00050 | RSRY-708-00218 | 5         |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00052 | RSTK-03x-00052 | RSRY-708-00218 | 5         |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00052 | RSTK-03x-00052 | RSRY-708-00218 | 5         |
| 0.8079 - 0.8492 | 20.52 - 21.57 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00052 | RSTK-03x-00052 | RSRY-708-00218 | 5         |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00054 | RSTK-03x-00054 | RSRY-708-00218 | 5         |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00054 | RSTK-03x-00054 | RSRY-708-00218 | 5         |
| 0.8390 - 0.8799 | 21.31 - 22.35 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00054 | RSTK-03x-00054 | RSRY-708-00218 | 5         |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00056 | RSTK-03x-00050 | RSRY-708-00265 | 5         |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00056 | RSTK-03x-00050 | RSRY-708-00265 | 5         |
| 0.8713 - 0.9118 | 22.13 - 23.16 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00056 | RSTK-03x-00050 | RSRY-708-00265 | 5         |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00058 | RSTK-03x-00052 | RSRY-708-00265 | 5         |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00058 | RSTK-03x-00052 | RSRY-708-00265 | 5         |
| 0.9020 - 0.9433 | 22.91 - 23.96 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00058 | RSTK-03x-00052 | RSRY-708-00265 | 5         |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 1   | RSKK-210-xxxxx                  | RSKK-110-xxxxx               | RSCK-015-00060 | RSTK-03x-00054 | RSRY-708-00265 | 5         |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 2   | RSKK-220-xxxxx                  | RSKK-120-xxxxx               | RSCK-015-00060 | RSTK-03x-00054 | RSRY-708-00265 | 5         |
| 0.9331 - 0.9740 | 23.70 - 24.74 | 3   | RSKK-230-xxxxx                  | RSKK-130-xxxxx               | RSCK-015-00060 | RSTK-03x-00054 | RSRY-708-00265 | 5         |

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

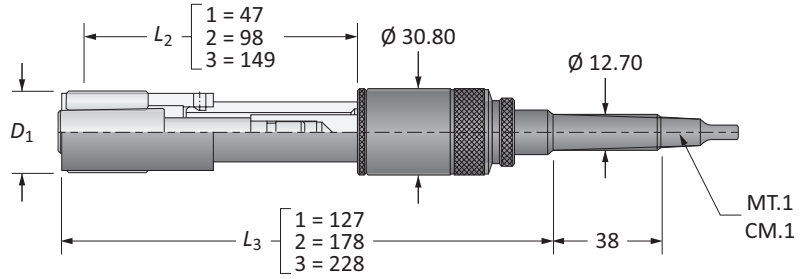
\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D: 6 for the correct identification of the "x" value.

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



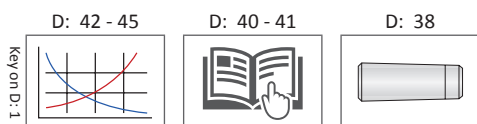
## Roller Burnishing Tools | Through Holes

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



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

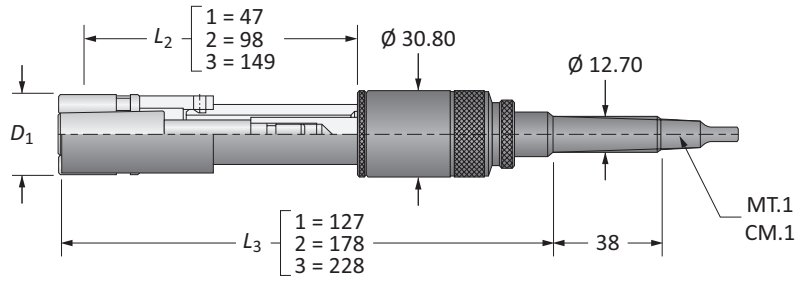
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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

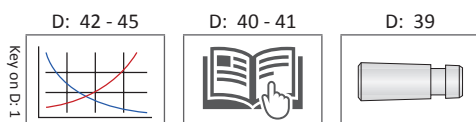


| $D_1$           |               | L | Part No.*                       |                              | Spare Parts    |                |                | Qty Rolls |
|-----------------|---------------|---|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   |   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |           |
| 0.9661 - 1.0075 | 24.54 - 25.59 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00062 | RSTL-03x-00062 | RSRY-708-00265 | 5         |
| 0.9661 - 1.0075 | 24.54 - 25.59 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00062 | RSTL-03x-00062 | RSRY-708-00265 | 5         |
| 0.9661 - 1.0075 | 24.54 - 25.59 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00062 | RSTL-03x-00062 | RSRY-708-00265 | 5         |
| 0.9992 - 1.0402 | 25.38 - 26.42 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00064 | RSTL-03x-00064 | RSRY-708-00265 | 5         |
| 0.9992 - 1.0402 | 25.38 - 26.42 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00064 | RSTL-03x-00064 | RSRY-708-00265 | 5         |
| 0.9992 - 1.0402 | 25.38 - 26.42 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00064 | RSTL-03x-00064 | RSRY-708-00265 | 5         |
| 1.0299 - 1.0709 | 26.16 - 27.20 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00066 | RSTL-03x-00066 | RSRY-708-00265 | 5         |
| 1.0299 - 1.0709 | 26.16 - 27.20 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00066 | RSTL-03x-00066 | RSRY-708-00265 | 5         |
| 1.0299 - 1.0709 | 26.16 - 27.20 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00066 | RSTL-03x-00066 | RSRY-708-00265 | 5         |
| 1.0610 - 1.1024 | 26.95 - 28.00 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00068 | RSTL-03x-00068 | RSRY-708-00265 | 5         |
| 1.0610 - 1.1024 | 26.95 - 28.00 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00068 | RSTL-03x-00068 | RSRY-708-00265 | 5         |
| 1.0610 - 1.1024 | 26.95 - 28.00 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00068 | RSTL-03x-00068 | RSRY-708-00265 | 5         |
| 1.0917 - 1.1327 | 27.73 - 28.77 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00070 | RSTL-03x-00070 | RSRY-708-00265 | 5         |
| 1.0917 - 1.1327 | 27.73 - 28.77 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00070 | RSTL-03x-00070 | RSRY-708-00265 | 5         |
| 1.0917 - 1.1327 | 27.73 - 28.77 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00070 | RSTL-03x-00070 | RSRY-708-00265 | 5         |
| 1.1240 - 1.1650 | 28.55 - 29.59 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00072 | RSTL-03x-00066 | RSRY-708-00312 | 5         |
| 1.1240 - 1.1650 | 28.55 - 29.59 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00072 | RSTL-03x-00066 | RSRY-708-00312 | 5         |
| 1.1240 - 1.1650 | 28.55 - 29.59 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00072 | RSTL-03x-00066 | RSRY-708-00312 | 5         |
| 1.1551 - 1.1965 | 29.34 - 30.39 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00074 | RSTL-03x-00068 | RSRY-708-00312 | 5         |
| 1.1551 - 1.1965 | 29.34 - 30.39 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00074 | RSTL-03x-00068 | RSRY-708-00312 | 5         |
| 1.1551 - 1.1965 | 29.34 - 30.39 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00074 | RSTL-03x-00068 | RSRY-708-00312 | 5         |
| 1.1858 - 1.2268 | 30.12 - 31.16 | 1 | RSKL-210-xxxxx                  | RSKL-110-xxxxx               | RSCL-015-00076 | RSTL-03x-00070 | RSRY-708-00312 | 5         |
| 1.1858 - 1.2268 | 30.12 - 31.16 | 2 | RSKL-220-xxxxx                  | RSKL-120-xxxxx               | RSCL-015-00076 | RSTL-03x-00070 | RSRY-708-00312 | 5         |
| 1.1858 - 1.2268 | 30.12 - 31.16 | 3 | RSKL-230-xxxxx                  | RSKL-130-xxxxx               | RSCL-015-00076 | RSTL-03x-00070 | RSRY-708-00312 | 5         |

\*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 D: 6 for the correct identification of the "x" value.

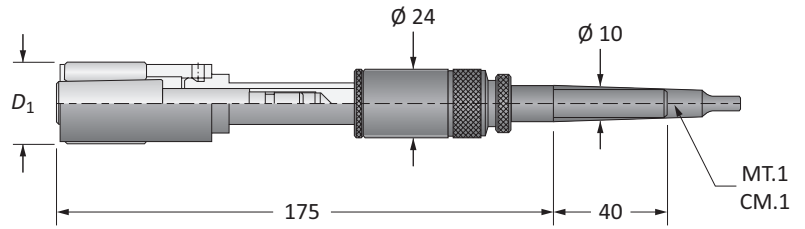
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



L  
A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

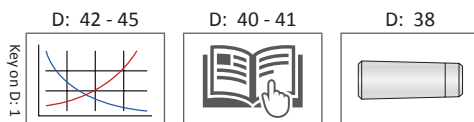
## Roller Burnishing Tools | Through Holes

F Series | Diameter Range: 0.9661" - 1.2268" (24.54 mm - 31.16 mm)



| $D_1$           |               | Part No.                        |                              | Spare Parts    |                |                |           |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          | Qty Rolls |
| 0.9661 - 1.0075 | 24.54 - 25.59 | <b>RDKF-200-02454</b>           | <b>RDKF-100-02454</b>        | RDCL-011-00062 | RDTF-031-00062 | RDRY-701-00265 | 5         |
| 0.9992 - 1.0402 | 25.38 - 26.42 | <b>RDKF-200-02538</b>           | <b>RDKF-100-02538</b>        | RDCL-011-00064 | RDTF-031-00064 | RDRY-701-00265 | 7         |
| 1.0299 - 1.0709 | 26.16 - 27.20 | <b>RDKF-200-02616</b>           | <b>RDKF-100-02616</b>        | RDCL-011-00066 | RDTF-031-00066 | RDRY-701-00265 | 7         |
| 1.0610 - 1.1024 | 26.95 - 28.00 | <b>RDKF-200-02695</b>           | <b>RDKF-100-02695</b>        | RDCL-011-00068 | RDTF-031-00068 | RDRY-701-00265 | 7         |
| 1.0917 - 1.1327 | 27.73 - 28.77 | <b>RDKF-200-02773</b>           | <b>RDKF-100-02773</b>        | RDCL-011-00070 | RDTF-031-00070 | RDRY-701-00265 | 7         |
| 1.1240 - 1.1650 | 28.55 - 29.59 | <b>RDKF-200-02855</b>           | <b>RDKF-100-02855</b>        | RDCL-011-00072 | RDTF-031-00066 | RDRY-701-00312 | 7         |
| 1.1551 - 1.1965 | 29.34 - 30.39 | <b>RDKF-200-02934</b>           | <b>RDKF-100-02934</b>        | RDCL-011-00074 | RDTF-031-00068 | RDRY-701-00312 | 7         |
| 1.1858 - 1.2268 | 30.12 - 31.16 | <b>RDKF-200-03012</b>           | <b>RDKF-100-03012</b>        | RDCL-011-00076 | RDTF-031-00070 | RDRY-701-00312 | 7         |

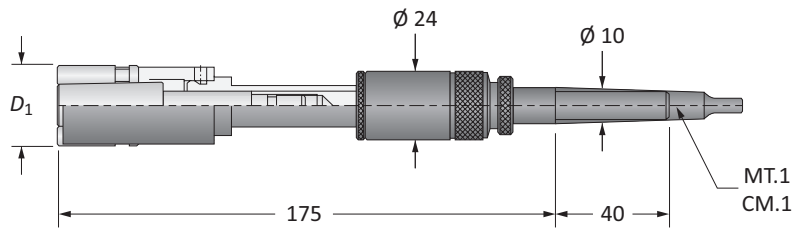
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

F Series | Diameter Range: 0.9661" - 1.2268" (24.54 mm - 31.16 mm)



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

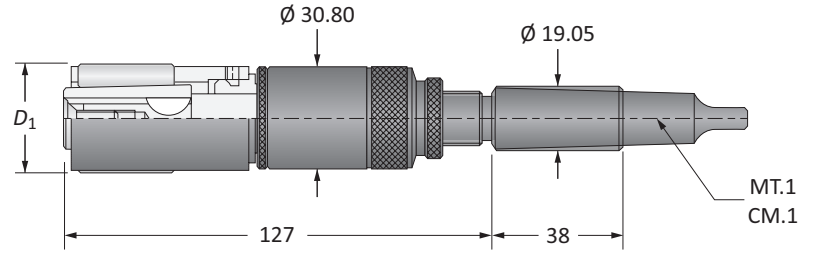
\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D: 6 for the correct identification of the "x" value.

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

D: 42 - 45      D: 40 - 41      D: 39

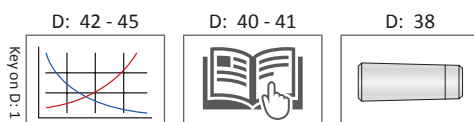
## Roller Burnishing Tools | Through Holes

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



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

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

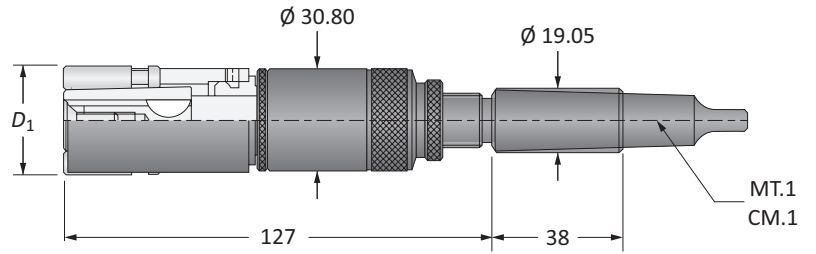






## Roller Burnishing Tools | Blind Holes

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



| D <sub>1</sub>  |               | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 1.2146 - 1.2559 | 30.85 - 31.90 | RSKM-200-xxxxx                  | RSKM-100-xxxxx               | RSCM-015-00078 | RSTM-03x-00078 | RSRY-708-00265 | 5            |
| 1.2469 - 1.2878 | 31.67 - 32.71 | RSKM-200-xxxxx                  | RSKM-100-xxxxx               | RSCM-015-00080 | RSTM-03x-00080 | RSRY-708-00265 | 5            |
| 1.2772 - 1.3177 | 32.44 - 33.47 | RSKM-200-xxxxx                  | RSKM-100-xxxxx               | RSCM-015-00082 | RSTM-03x-00082 | RSRY-708-00265 | 5            |
| 1.3087 - 1.3500 | 33.24 - 34.29 | RSKM-200-xxxxx                  | RSKM-100-xxxxx               | RSCM-015-00084 | RSTM-03x-00078 | RSRY-708-00312 | 5            |
| 1.3406 - 1.3815 | 34.05 - 35.09 | RSKM-200-xxxxx                  | RSKM-100-xxxxx               | RSCM-015-00086 | RSTM-03x-00080 | RSRY-708-00312 | 5            |
| 1.3713 - 1.4118 | 34.83 - 35.86 | 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 Ø 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 D: 6 for the correct identification of the "x" value.

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

D: 42 - 45

D: 40 - 41

D: 39

Key on D: 1

N

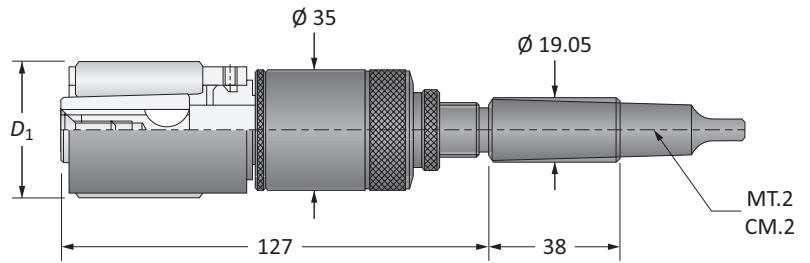

 BURNISHING | S.C.A.M.I.® Roller Burnishing Systems

A

## Roller Burnishing Tools | Through Holes

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

DRILLING

B

BORING

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

D

BURNISHING

F

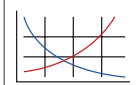
THREADING

X


SPECIALS

Key on D: 1


D: 42 - 45



D: 40 - 41



D: 38



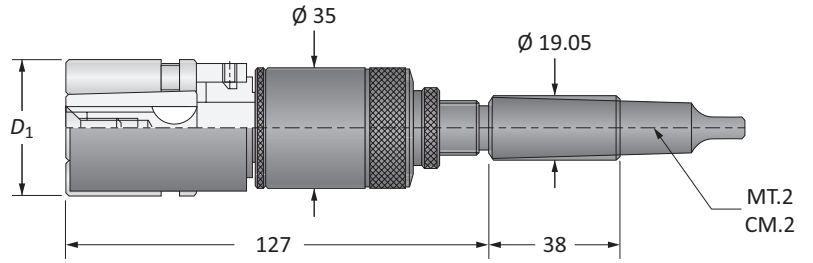
D: 22

[www.alliedmachine.com](http://www.alliedmachine.com) | 1.330.343.4283



## Roller Burnishing Tools | Blind Holes

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



| $D_1$           |               | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 1.4020 - 1.4433 | 35.61 - 36.66 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00090 | RSTN-03x-00090 | RSRY-708-00312 | 5            |
| 1.4331 - 1.4740 | 36.40 - 37.44 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00092 | RSTN-03x-00092 | RSRY-708-00312 | 5            |
| 1.4638 - 1.5051 | 37.18 - 38.23 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00094 | RSTN-03x-00094 | RSRY-708-00312 | 5            |
| 1.4961 - 1.5370 | 38.00 - 39.04 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00096 | RSTN-03x-00096 | RSRY-708-00312 | 5            |
| 1.5272 - 1.5677 | 38.79 - 39.82 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00098 | RSTM-03x-00080 | RSRY-708-00406 | 5            |
| 1.5579 - 1.5992 | 39.57 - 40.62 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00100 | RSTM-03x-00082 | RSRY-708-00406 | 5            |
| 1.5890 - 1.6299 | 40.36 - 41.40 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00102 | RSTN-03x-00090 | RSRY-708-00406 | 5            |
| 1.6213 - 1.6618 | 41.18 - 42.21 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00104 | RSTN-03x-00092 | RSRY-708-00406 | 5            |
| 1.6520 - 1.6933 | 41.96 - 43.01 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00106 | RSTN-03x-00094 | RSRY-708-00406 | 5            |
| 1.6831 - 1.7240 | 42.75 - 43.79 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00108 | RSTM-03x-00082 | RSRY-708-00468 | 5            |
| 1.7138 - 1.7551 | 43.53 - 44.58 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00110 | RSTN-03x-00090 | RSRY-708-00468 | 5            |
| 1.7461 - 1.7870 | 44.35 - 45.39 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00112 | RSTN-03x-00092 | RSRY-708-00468 | 5            |
| 1.7772 - 1.8177 | 45.14 - 46.17 | RSKN-200-xxxxx                  | RSKN-100-xxxxx               | RSCN-015-00114 | RSTN-03x-00094 | RSRY-708-00468 | 5            |
| 1.8079 - 1.8492 | 45.92 - 46.97 | 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 Ø 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 D: 6 for the correct identification of the "x" value.

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

Key on D: 1

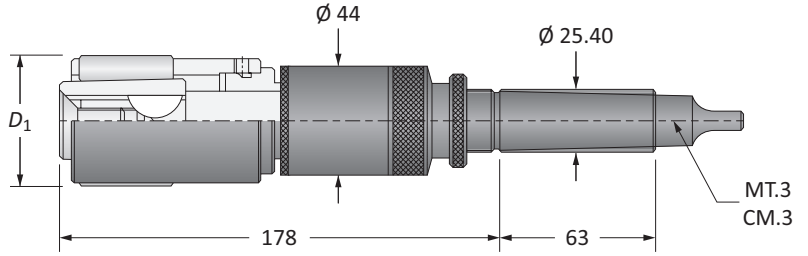
D: 42 - 45

D: 40 - 41

D: 39

## Roller Burnishing Tools | Through Holes

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



### Through Holes

| D <sub>1</sub>  |               | Part No.                        |                              | Spare Parts    |                |                |           |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          | Qty Rolls |
| 1.8390 - 1.8799 | 46.71 - 47.75 | <b>RDKO-200-04671</b>           | <b>RDKO-100-04671</b>        | RDCO-011-00118 | RDTO-031-00118 | RDRY-701-00312 | 9         |
| 1.8713 - 1.9118 | 47.53 - 48.56 | <b>RDKO-200-04753</b>           | <b>RDKO-100-04753</b>        | RDCO-011-00120 | RDTO-031-00120 | RDRY-701-00312 | 9         |
| 1.9020 - 1.9433 | 48.31 - 49.36 | <b>RDKO-200-04831</b>           | <b>RDKO-100-04831</b>        | RDCO-011-00122 | RDTO-031-00122 | RDRY-701-00312 | 9         |
| 1.9331 - 1.9740 | 49.10 - 50.14 | <b>RDKO-200-04910</b>           | <b>RDKO-100-04910</b>        | RDCO-011-00124 | RDTO-031-00124 | RDRY-701-00312 | 9         |
| 1.9638 - 2.0051 | 49.88 - 50.93 | <b>RDKO-200-04988</b>           | <b>RDKO-100-04988</b>        | RDCO-011-00126 | RDTO-031-00126 | RDRY-701-00312 | 9         |
| 1.9961 - 2.0370 | 50.70 - 51.74 | <b>RDKO-200-05070</b>           | <b>RDKO-100-05070</b>        | RDCO-011-00128 | RDTO-031-00128 | RDRY-701-00312 | 9         |
| 2.0272 - 2.0681 | 51.49 - 52.53 | <b>RDKO-200-05149</b>           | <b>RDKO-100-05149</b>        | RDCO-011-00130 | RDTO-031-00118 | RDRY-701-00406 | 9         |
| 2.0579 - 2.0992 | 52.27 - 53.32 | <b>RDKO-200-05227</b>           | <b>RDKO-100-05227</b>        | RDCO-011-00132 | RDTO-031-00120 | RDRY-701-00406 | 9         |
| 2.0890 - 2.1299 | 53.06 - 54.10 | <b>RDKO-200-05306</b>           | <b>RDKO-100-05306</b>        | RDCO-011-00134 | RDTO-031-00122 | RDRY-701-00406 | 9         |
| 2.1209 - 2.1618 | 53.87 - 54.91 | <b>RDKO-200-05387</b>           | <b>RDKO-100-05387</b>        | RDCO-011-00136 | RDTO-031-00124 | RDRY-701-00406 | 9         |
| 2.1520 - 2.1933 | 54.66 - 55.71 | <b>RDKO-200-05466</b>           | <b>RDKO-100-05466</b>        | RDCO-011-00138 | RDTO-031-00126 | RDRY-701-00406 | 9         |
| 2.1831 - 2.2240 | 55.45 - 56.49 | <b>RDKO-200-05545</b>           | <b>RDKO-100-05545</b>        | RDCO-011-00140 | RDTO-031-00128 | RDRY-701-00406 | 9         |

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

Key on D: 1

D: 42 - 45

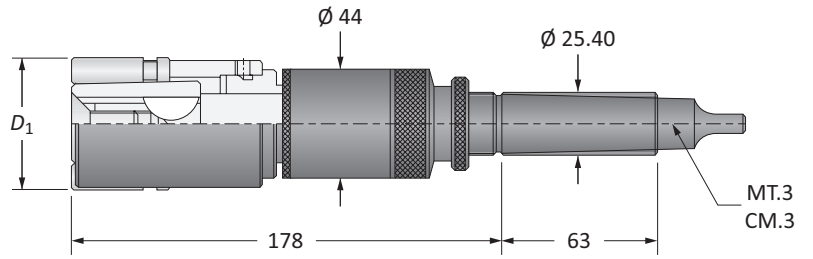
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



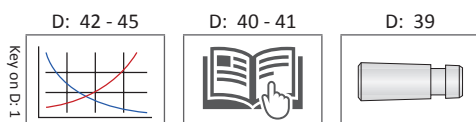
### Blind Holes

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

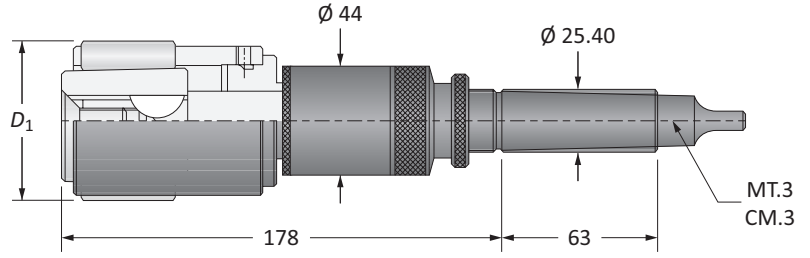
\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D: 6 for the correct identification of the "x" value.

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



## Roller Burnishing Tools | Through Holes

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



### Through Holes

| D <sub>1</sub>  |               | Part No.                        |                              | Spare Parts    |                |                |           |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          | Qty Rolls |
| 2.2138 - 2.2551 | 56.23 - 57.28 | RDKP-200-05623                  | RDKP-100-05623               | RDCP-011-00142 | RDTP-031-00142 | RDRY-701-00406 | 9         |
| 2.2461 - 2.2870 | 57.05 - 58.09 | RDKP-200-05705                  | RDKP-100-05705               | RDCP-011-00144 | RDTP-031-00144 | RDRY-701-00406 | 9         |
| 2.2772 - 2.3177 | 57.84 - 58.87 | RDKP-200-05784                  | RDKP-100-05784               | RDCP-011-00146 | RDTP-031-00146 | RDRY-701-00406 | 9         |
| 2.3079 - 2.3492 | 58.62 - 59.67 | RDKP-200-05862                  | RDKP-100-05862               | RDCP-011-00148 | RDTP-031-00148 | RDRY-701-00406 | 9         |
| 2.3390 - 2.3799 | 59.41 - 60.45 | RDKP-200-05941                  | RDKP-100-05941               | RDCP-011-00150 | RDTP-031-00142 | RDRY-701-00468 | 9         |
| 2.3713 - 2.4118 | 60.23 - 61.26 | RDKP-200-06023                  | RDKP-100-06023               | RDCP-011-00152 | RDTP-031-00144 | RDRY-701-00468 | 9         |
| 2.4020 - 2.4433 | 61.01 - 62.06 | RDKP-200-06101                  | RDKP-100-06101               | RDCP-011-00154 | RDTP-031-00146 | RDRY-701-00468 | 9         |
| 2.4330 - 2.4740 | 61.80 - 62.84 | RDKP-200-06180                  | RDKP-100-06180               | RDCP-011-00156 | RDTP-031-00148 | RDRY-701-00468 | 9         |
| 2.4638 - 2.5051 | 62.58 - 63.63 | RDKP-200-06258                  | RDKP-100-06258               | RDCP-011-00158 | RDTP-031-00158 | RDRY-701-00468 | 9         |
| 2.4961 - 2.5370 | 63.40 - 64.44 | RDKP-200-06340                  | RDKP-100-06340               | RDCP-011-00160 | RDTP-031-00160 | RDRY-701-00468 | 9         |
| 2.5272 - 2.5677 | 64.19 - 65.22 | RDKP-200-06419                  | RDKP-100-06419               | RDCP-011-00162 | RDTP-031-00162 | RDRY-701-00468 | 9         |
| 2.5579 - 2.5992 | 64.97 - 66.02 | RDKP-200-06497                  | RDKP-100-06497               | RDCP-011-00164 | RDTP-031-00164 | RDRY-701-00468 | 9         |
| 2.5890 - 2.6299 | 65.76 - 66.80 | RDKP-200-06576                  | RDKP-100-06576               | RDCP-011-00166 | RDTP-031-00158 | RDRY-701-00531 | 9         |
| 2.6213 - 2.6618 | 66.58 - 67.61 | RDKP-200-06658                  | RDKP-100-06658               | RDCP-011-00168 | RDTP-031-00160 | RDRY-701-00531 | 9         |
| 2.6520 - 2.6933 | 67.36 - 68.41 | RDKP-200-06736                  | RDKP-100-06736               | RDCP-011-00170 | RDTP-031-00162 | RDRY-701-00531 | 9         |
| 2.6830 - 2.7240 | 68.15 - 69.19 | 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.

Key on D: 1

D: 42 - 45

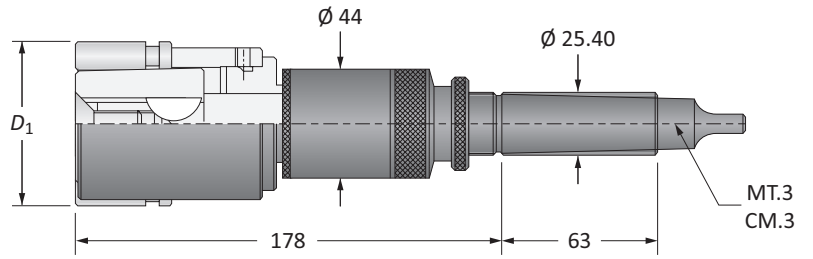
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

| D <sub>1</sub>  |               | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 2.2138 - 2.2551 | 56.23 - 57.28 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00142 | RSTP-03x-00142 | RSRY-708-00406 | 7            |
| 2.2461 - 2.2870 | 57.05 - 58.09 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00144 | RSTP-03x-00144 | RSRY-708-00406 | 7            |
| 2.2772 - 2.3177 | 57.84 - 58.87 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00146 | RSTP-03x-00146 | RSRY-708-00406 | 7            |
| 2.3079 - 2.3492 | 58.62 - 59.67 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00148 | RSTP-03x-00148 | RSRY-708-00406 | 7            |
| 2.3390 - 2.3799 | 59.41 - 60.45 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00150 | RSTP-03x-00142 | RSRY-708-00468 | 7            |
| 2.3713 - 2.4118 | 60.23 - 61.26 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00152 | RSTP-03x-00144 | RSRY-708-00468 | 7            |
| 2.4020 - 2.4433 | 61.01 - 62.06 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00154 | RSTP-03x-00146 | RSRY-708-00468 | 7            |
| 2.4330 - 2.4740 | 61.80 - 62.84 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00156 | RSTP-03x-00148 | RSRY-708-00468 | 7            |
| 2.4638 - 2.5051 | 62.58 - 63.63 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00158 | RSTP-03x-00158 | RSRY-708-00468 | 7            |
| 2.4961 - 2.5370 | 63.40 - 64.44 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00160 | RSTP-03x-00160 | RSRY-708-00468 | 7            |
| 2.5272 - 2.5677 | 64.19 - 65.22 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00162 | RSTP-03x-00162 | RSRY-708-00468 | 7            |
| 2.5579 - 2.5992 | 64.97 - 66.02 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00164 | RSTP-03x-00164 | RSRY-708-00468 | 7            |
| 2.5890 - 2.6299 | 65.76 - 66.80 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00166 | RSTP-03x-00158 | RSRY-708-00531 | 7            |
| 2.6213 - 2.6618 | 66.58 - 67.61 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00168 | RSTP-03x-00160 | RSRY-708-00531 | 7            |
| 2.6520 - 2.6933 | 67.36 - 68.41 | RSKP-200-xxxxx                  | RSKP-100-xxxxx               | RSCP-015-00170 | RSTP-03x-00162 | RSRY-708-00531 | 7            |
| 2.6830 - 2.7240 | 68.15 - 69.19 | 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 D: 6 for the correct identification of the "x" value.

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

Key on D: 1

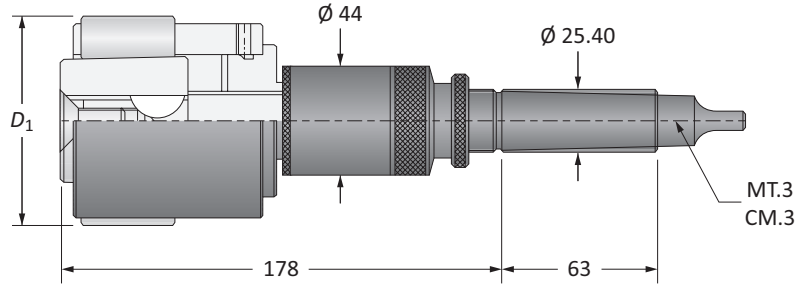
D: 42 - 45

D: 40 - 41

D: 39

## Roller Burnishing Tools | Through Holes

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



### Through Holes

| D <sub>1</sub>  |               | Part No.                        |                              | Spare Parts    |                |                |           |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          | Qty Rolls |
| 2.7138 - 2.7551 | 68.93 - 69.98 | RDKQ-200-06893                  | RDKQ-100-06893               | RDCQ-011-00174 | RDTQ-031-00174 | RDRY-701-00531 | 9         |
| 2.7461 - 2.7870 | 69.75 - 70.79 | RDKQ-200-06975                  | RDKQ-100-06975               | RDCQ-011-00176 | RDTQ-031-00176 | RDRY-701-00531 | 9         |
| 2.7772 - 2.8177 | 70.54 - 71.57 | RDKQ-200-07054                  | RDKQ-100-07054               | RDCQ-011-00178 | RDTQ-031-00178 | RDRY-701-00531 | 9         |
| 2.8079 - 2.8504 | 71.32 - 72.40 | RDKQ-200-07132                  | RDKQ-100-07132               | RDCQ-011-00180 | RDTQ-031-00180 | RDRY-701-00531 | 9         |
| 2.8390 - 2.8799 | 72.11 - 73.15 | RDKQ-200-07211                  | RDKQ-100-07211               | RDCQ-011-00182 | RDTQ-031-00182 | RDRY-701-00531 | 9         |
| 2.8713 - 2.9118 | 72.93 - 73.96 | RDKQ-200-07293                  | RDKQ-100-07293               | RDCQ-011-00184 | RDTQ-031-00184 | RDRY-701-00531 | 9         |
| 2.9020 - 2.9429 | 73.71 - 74.75 | RDKQ-200-07371                  | RDKQ-100-07371               | RDCQ-011-00186 | RDTQ-031-00174 | RDRY-701-00625 | 9         |
| 2.9331 - 2.9740 | 74.50 - 75.54 | RDKQ-200-07450                  | RDKQ-100-07450               | RDCQ-011-00188 | RDTQ-031-00176 | RDRY-701-00625 | 9         |
| 2.9638 - 3.0051 | 75.28 - 76.33 | RDKQ-200-07528                  | RDKQ-100-07528               | RDCQ-011-00190 | RDTQ-031-00178 | RDRY-701-00625 | 9         |
| 2.9961 - 3.0370 | 76.10 - 77.14 | RDKQ-200-07610                  | RDKQ-100-07610               | RDCQ-011-00192 | RDTQ-031-00180 | RDRY-701-00625 | 9         |
| 3.0272 - 3.0681 | 76.89 - 77.93 | RDKQ-200-07689                  | RDKQ-100-07689               | RDCQ-011-00194 | RDTQ-031-00182 | RDRY-701-00625 | 9         |
| 3.0579 - 3.0992 | 77.67 - 78.72 | RDKQ-200-07767                  | RDKQ-100-07767               | RDCQ-011-00196 | RDTQ-031-00184 | RDRY-701-00625 | 9         |
| 3.0890 - 3.1299 | 78.46 - 79.50 | RDKQ-200-07846                  | RDKQ-100-07846               | RDCQ-011-00198 | RDTQ-031-00198 | RDRY-701-00625 | 9         |
| 3.1209 - 3.1618 | 79.27 - 80.31 | RDKQ-200-07927                  | RDKQ-100-07927               | RDCQ-011-00200 | RDTQ-031-00200 | RDRY-701-00625 | 9         |
| 3.1520 - 3.1933 | 80.06 - 81.11 | RDKQ-200-08006                  | RDKQ-100-08006               | RDCQ-011-00202 | RDTQ-031-00202 | RDRY-701-00625 | 9         |
| 3.1831 - 3.2240 | 80.85 - 81.89 | RDKQ-200-08085                  | RDKQ-100-08085               | RDCQ-011-00204 | RDTQ-031-00204 | RDRY-701-00625 | 9         |
| 3.2138 - 3.2551 | 81.63 - 82.68 | RDKQ-200-08163                  | RDKQ-100-08163               | RDCQ-011-00206 | RDTQ-031-00198 | RDRY-701-00687 | 9         |
| 3.2461 - 3.2870 | 82.45 - 83.49 | RDKQ-200-08245                  | RDKQ-100-08245               | RDCQ-011-00208 | RDTQ-031-00200 | RDRY-701-00687 | 9         |
| 3.2772 - 3.3177 | 83.24 - 84.27 | RDKQ-200-08324                  | RDKQ-100-08324               | RDCQ-011-00210 | RDTQ-031-00202 | RDRY-701-00687 | 9         |
| 3.3079 - 3.3492 | 84.02 - 85.07 | RDKQ-200-08402                  | RDKQ-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.

Key on D: 1

D: 42 - 45

D: 40 - 41

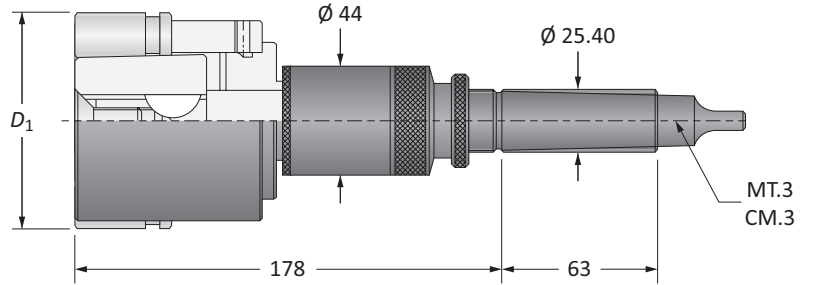
D: 38





## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

| D <sub>1</sub>  |               | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|---------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)   | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 2.7138 - 2.7551 | 68.93 - 69.98 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00174 | RSTQ-03x-00174 | RSRY-708-00531 | 7            |
| 2.7461 - 2.7870 | 69.75 - 70.79 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00176 | RSTQ-03x-00176 | RSRY-708-00531 | 7            |
| 2.7772 - 2.8177 | 70.54 - 71.57 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00178 | RSTQ-03x-00178 | RSRY-708-00531 | 7            |
| 2.8079 - 2.8504 | 71.32 - 72.40 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00180 | RSTQ-03x-00180 | RSRY-708-00531 | 7            |
| 2.8390 - 2.8799 | 72.11 - 73.15 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00182 | RSTQ-03x-00182 | RSRY-708-00531 | 7            |
| 2.8713 - 2.9118 | 72.93 - 73.96 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00184 | RSTQ-03x-00184 | RSRY-708-00531 | 7            |
| 2.9020 - 2.9429 | 73.71 - 74.75 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00186 | RSTQ-03x-00174 | RSRY-708-00625 | 7            |
| 2.9331 - 2.9740 | 74.50 - 75.54 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00188 | RSTQ-03x-00176 | RSRY-708-00625 | 7            |
| 2.9638 - 3.0051 | 75.28 - 76.33 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00190 | RSTQ-03x-00178 | RSRY-708-00625 | 7            |
| 2.9961 - 3.0370 | 76.10 - 77.14 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00192 | RSTQ-03x-00180 | RSRY-708-00625 | 7            |
| 3.0272 - 3.0681 | 76.89 - 77.93 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00194 | RSTQ-03x-00182 | RSRY-708-00625 | 7            |
| 3.0579 - 3.0992 | 77.67 - 78.72 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00196 | RSTQ-03x-00184 | RSRY-708-00625 | 7            |
| 3.0890 - 3.1299 | 78.46 - 79.50 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00198 | RSTQ-03x-00198 | RSRY-708-00625 | 7            |
| 3.1209 - 3.1618 | 79.27 - 80.31 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00200 | RSTQ-03x-00200 | RSRY-708-00625 | 7            |
| 3.1520 - 3.1933 | 80.06 - 81.11 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00202 | RSTQ-03x-00202 | RSRY-708-00625 | 7            |
| 3.1831 - 3.2240 | 80.85 - 81.89 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00204 | RSTQ-03x-00204 | RSRY-708-00625 | 7            |
| 3.2138 - 3.2551 | 81.63 - 82.68 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00206 | RSTQ-03x-00198 | RSRY-708-00687 | 7            |
| 3.2461 - 3.2870 | 82.45 - 83.49 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00208 | RSTQ-03x-00200 | RSRY-708-00687 | 7            |
| 3.2772 - 3.3177 | 83.24 - 84.27 | RSKQ-200-xxxxx                  | RSKQ-100-xxxxx               | RSCQ-015-00210 | RSTQ-03x-00202 | RSRY-708-00687 | 7            |
| 3.3079 - 3.3492 | 84.02 - 85.07 | 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 D: 6 for the correct identification of the "x" value.

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

D: 42 - 45

D: 40 - 41

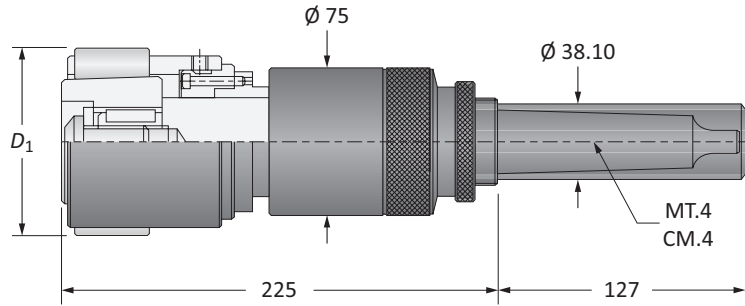
D: 39

Key on D: 1

A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

## Roller Burnishing Tools | Through Holes

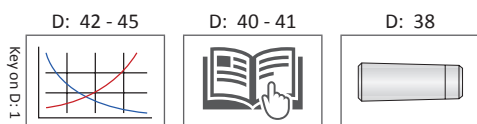
R Series | Diameter Range: 3.3390" - 4.0992" (84.81 mm - 104.12 mm)



### Through Holes

| $D_1$           |                 | Part No.                        |                              | Spare Parts    |                |                |           |
|-----------------|-----------------|---------------------------------|------------------------------|----------------|----------------|----------------|-----------|
| Imperial (in)   | Metric (mm)     | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone           | Rolls          | Qty Rolls |
| 3.3390 - 3.3799 | 84.81 - 85.85   | RDKR-200-08481                  | RDKR-100-08481               | RDCR-011-00214 | RDTR-073-00001 | RDRY-701-00468 | 9         |
| 3.3713 - 3.4118 | 85.63 - 86.66   | RDKR-200-08563                  | RDKR-100-08563               | RDCR-011-00216 | RDTR-074-00001 | RDRY-701-00468 | 9         |
| 3.4020 - 3.4429 | 86.41 - 87.45   | RDKR-200-08641                  | RDKR-100-08641               | RDCR-011-00218 | RDTR-071-00001 | RDRY-701-00531 | 9         |
| 3.4331 - 3.4740 | 87.20 - 88.24   | RDKR-200-08720                  | RDKR-100-08720               | RDCR-011-00220 | RDTR-072-00001 | RDRY-701-00531 | 9         |
| 3.4642 - 3.5051 | 87.99 - 89.03   | RDKR-200-08799                  | RDKR-100-08799               | RDCR-011-00222 | RDTR-073-00001 | RDRY-701-00531 | 9         |
| 3.4957 - 3.5370 | 88.79 - 89.84   | RDKR-200-08879                  | RDKR-100-08879               | RDCR-011-00224 | RDTR-074-00001 | RDRY-701-00531 | 9         |
| 3.5272 - 3.5681 | 89.59 - 90.63   | RDKR-200-08959                  | RDKR-100-08959               | RDCR-011-00226 | RDTR-075-00001 | RDRY-701-00531 | 9         |
| 3.5579 - 3.5992 | 90.37 - 91.42   | RDKR-200-09037                  | RDKR-100-09037               | RDCR-011-00228 | RDTR-076-00001 | RDRY-701-00531 | 9         |
| 3.5890 - 3.6299 | 91.16 - 92.20   | RDKR-200-09116                  | RDKR-100-09116               | RDCR-011-00230 | RDTR-071-00001 | RDRY-701-00625 | 9         |
| 3.6209 - 3.6622 | 91.97 - 93.02   | RDKR-200-09197                  | RDKR-100-09197               | RDCR-011-00232 | RDTR-072-00001 | RDRY-701-00625 | 9         |
| 3.6520 - 3.6929 | 92.76 - 93.80   | RDKR-200-09276                  | RDKR-100-09276               | RDCR-011-00234 | RDTR-073-00001 | RDRY-701-00625 | 9         |
| 3.6831 - 3.7240 | 93.55 - 94.59   | RDKR-200-09355                  | RDKR-100-09355               | RDCR-011-00236 | RDTR-074-00001 | RDRY-701-00625 | 9         |
| 3.7142 - 3.7551 | 94.34 - 95.38   | RDKR-200-09434                  | RDKR-100-09434               | RDCR-011-00238 | RDTR-075-00001 | RDRY-701-00625 | 9         |
| 3.7461 - 3.7870 | 95.15 - 96.19   | RDKR-200-09515                  | RDKR-100-09515               | RDCR-011-00240 | RDTR-076-00001 | RDRY-701-00625 | 9         |
| 3.7772 - 3.8181 | 95.94 - 96.98   | RDKR-200-09594                  | RDKR-100-09594               | RDCR-011-00242 | RDTR-077-00001 | RDRY-701-00625 | 9         |
| 3.8079 - 3.8492 | 96.72 - 97.77   | RDKR-200-09672                  | RDKR-100-09672               | RDCR-011-00244 | RDTR-078-00001 | RDRY-701-00625 | 9         |
| 3.8390 - 3.8799 | 97.51 - 98.55   | RDKR-200-09751                  | RDKR-100-09751               | RDCR-011-00246 | RDTR-075-00001 | RDRY-701-00687 | 9         |
| 3.8709 - 3.9122 | 98.32 - 99.37   | RDKR-200-09832                  | RDKR-100-09832               | RDCR-011-00248 | RDTR-076-00001 | RDRY-701-00687 | 9         |
| 3.9020 - 3.9429 | 99.11 - 100.15  | RDKR-200-09911                  | RDKR-100-09911               | RDCR-011-00250 | RDTR-077-00001 | RDRY-701-00687 | 9         |
| 3.9331 - 3.9740 | 99.90 - 100.94  | RDKR-200-09990                  | RDKR-100-09990               | RDCR-011-00252 | RDTR-078-00001 | RDRY-701-00687 | 9         |
| 3.9642 - 4.0051 | 100.69 - 101.73 | RDKR-200-10069                  | RDKR-100-10069               | RDCR-011-00254 | RDTR-079-00001 | RDRY-701-00687 | 9         |
| 3.9961 - 4.0370 | 101.50 - 102.54 | RDKR-200-10150                  | RDKR-100-10150               | RDCR-011-00256 | RDTR-080-00001 | RDRY-701-00687 | 9         |
| 4.0272 - 4.0681 | 102.29 - 103.33 | RDKR-200-10229                  | RDKR-100-10229               | RDCR-011-00258 | RDTR-081-00001 | RDRY-701-00687 | 9         |
| 4.0579 - 4.0992 | 103.07 - 104.12 | RDKR-200-10307                  | RDKR-100-10307               | RDCR-011-00260 | RDTR-082-00001 | RDRY-701-00687 | 9         |

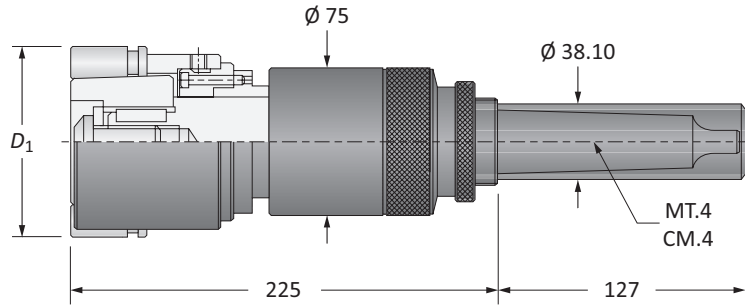
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

| D <sub>1</sub>  |                 | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|-----------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)     | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 3.3390 - 3.3799 | 84.81 - 85.85   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00214 | RSTR-073-0000x | RSRY-708-00468 | 9            |
| 3.3713 - 3.4118 | 85.63 - 86.66   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00216 | RSTR-074-0000x | RSRY-708-00468 | 9            |
| 3.4020 - 3.4429 | 86.41 - 87.45   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00218 | RSTR-071-0000x | RSRY-708-00531 | 9            |
| 3.4331 - 3.4740 | 87.20 - 88.24   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00220 | RSTR-072-0000x | RSRY-708-00531 | 9            |
| 3.4642 - 3.5051 | 87.99 - 89.03   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00222 | RSTR-073-0000x | RSRY-708-00531 | 9            |
| 3.4957 - 3.5370 | 88.79 - 89.84   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00224 | RSTR-074-0000x | RSRY-708-00531 | 9            |
| 3.5272 - 3.5681 | 89.59 - 90.63   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00226 | RSTR-075-0000x | RSRY-708-00531 | 9            |
| 3.5579 - 3.5992 | 90.37 - 91.42   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00228 | RSTR-076-0000x | RSRY-708-00531 | 9            |
| 3.5890 - 3.6299 | 91.16 - 92.20   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00230 | RSTR-071-0000x | RSRY-708-00625 | 9            |
| 3.6209 - 3.6622 | 91.97 - 93.02   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00232 | RSTR-072-0000x | RSRY-708-00625 | 9            |
| 3.6520 - 3.6929 | 92.76 - 93.80   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00234 | RSTR-073-0000x | RSRY-708-00625 | 9            |
| 3.6831 - 3.7240 | 93.55 - 94.59   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00236 | RSTR-074-0000x | RSRY-708-00625 | 9            |
| 3.7142 - 3.7551 | 94.34 - 95.38   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00238 | RSTR-075-0000x | RSRY-708-00625 | 9            |
| 3.7461 - 3.7870 | 95.15 - 96.19   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00240 | RSTR-076-0000x | RSRY-708-00625 | 9            |
| 3.7772 - 3.8181 | 95.94 - 96.98   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00242 | RSTR-077-0000x | RSRY-708-00625 | 9            |
| 3.8079 - 3.8492 | 96.72 - 97.77   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00244 | RSTR-078-0000x | RSRY-708-00625 | 9            |
| 3.8390 - 3.8799 | 97.51 - 98.55   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00246 | RSTR-075-0000x | RSRY-708-00687 | 9            |
| 3.8709 - 3.9122 | 98.32 - 99.37   | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00248 | RSTR-076-0000x | RSRY-708-00687 | 9            |
| 3.9020 - 3.9429 | 99.11 - 100.15  | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00250 | RSTR-077-0000x | RSRY-708-00687 | 9            |
| 3.9331 - 3.9740 | 99.90 - 100.94  | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00252 | RSTR-078-0000x | RSRY-708-00687 | 9            |
| 3.9642 - 4.0051 | 100.69 - 101.73 | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00254 | RSTR-079-0000x | RSRY-708-00687 | 9            |
| 3.9961 - 4.0370 | 101.50 - 102.54 | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00256 | RSTR-080-0000x | RSRY-708-00687 | 9            |
| 4.0272 - 1.0681 | 102.29 - 103.33 | RSKR-200-xxxxx                  | RSKR-100-xxxxx               | RSCR-015-00258 | RSTR-081-0000x | RSRY-708-00687 | 9            |
| 4.0579 - 4.0992 | 103.07 - 104.12 | 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 Ø 100.00 mm with straight shank: RSKR-100-10000).

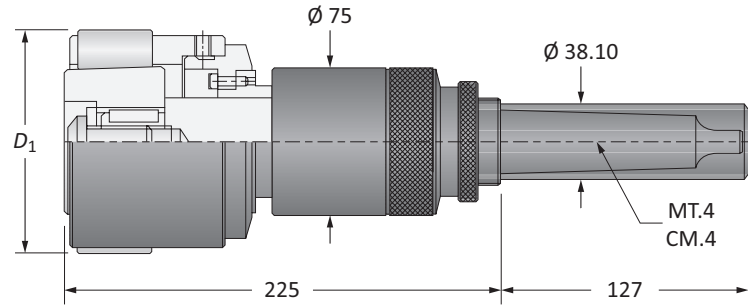
\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page D: 6 for the correct identification of the "x" value.

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

D: 42 - 45      D: 40 - 41      D: 39

## Roller Burnishing Tools | Through Holes

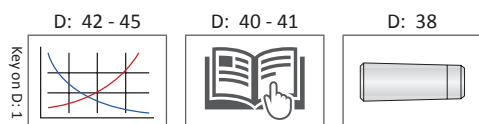
S Series | Diameter Range: 4.0890" - 5.0370" (103.86 mm - 127.94 mm)



### Through Holes

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

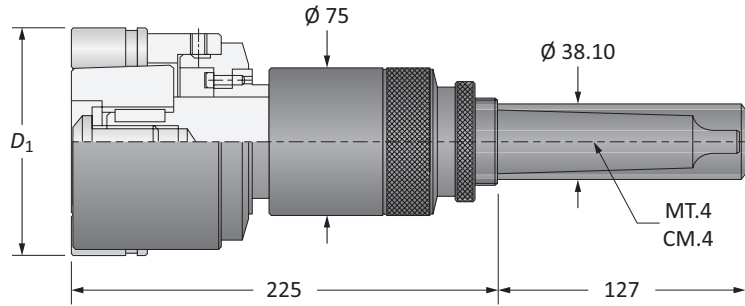
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

| $D_1$           |                 | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|-----------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)     | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 4.0890 - 4.1299 | 103.86 - 104.90 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00262 | RSTS-083-0000x | RSRY-708-00687 | 9            |
| 4.1209 - 4.1634 | 104.67 - 105.75 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00264 | RSTS-084-0000x | RSRY-708-00687 | 9            |
| 4.1520 - 4.1929 | 105.46 - 106.50 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00266 | RSTS-085-0000x | RSRY-708-00687 | 9            |
| 4.1831 - 4.2240 | 106.25 - 107.29 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00268 | RSTS-086-0000x | RSRY-708-00687 | 9            |
| 4.2142 - 4.2551 | 107.04 - 108.08 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00270 | RSTS-087-0000x | RSRY-708-00687 | 9            |
| 4.2461 - 4.2870 | 107.85 - 108.89 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00272 | RSTS-088-0000x | RSRY-708-00687 | 9            |
| 4.2772 - 4.3181 | 108.64 - 109.68 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00274 | RSTS-089-0000x | RSRY-708-00687 | 9            |
| 4.3079 - 4.3492 | 109.42 - 110.47 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00276 | RSTS-090-0000x | RSRY-708-00687 | 9            |
| 4.3390 - 4.3799 | 110.21 - 111.25 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00278 | RSTS-083-0000x | RSRY-708-00812 | 9            |
| 4.3709 - 4.4122 | 111.02 - 112.07 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00280 | RSTS-084-0000x | RSRY-708-00812 | 9            |
| 4.4020 - 4.4429 | 111.81 - 112.85 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00282 | RSTS-085-0000x | RSRY-708-00812 | 9            |
| 4.4331 - 4.4740 | 112.60 - 113.64 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00284 | RSTS-086-0000x | RSRY-708-00812 | 9            |
| 4.4622 - 4.5051 | 113.34 - 114.43 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00286 | RSTS-087-0000x | RSRY-708-00812 | 9            |
| 4.4961 - 4.5370 | 114.20 - 115.24 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00288 | RSTS-088-0000x | RSRY-708-00812 | 9            |
| 4.5272 - 4.5681 | 114.99 - 116.03 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00290 | RSTS-089-0000x | RSRY-708-00812 | 9            |
| 4.5579 - 4.5992 | 115.77 - 116.82 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00292 | RSTS-090-0000x | RSRY-708-00812 | 9            |
| 4.5890 - 4.6299 | 116.56 - 117.60 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00294 | RSTS-091-0000x | RSRY-708-00812 | 9            |
| 4.6209 - 4.6622 | 117.37 - 118.42 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00296 | RSTS-092-0000x | RSRY-708-00812 | 9            |
| 4.6520 - 4.6929 | 118.16 - 119.20 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00298 | RSTS-093-0000x | RSRY-708-00812 | 9            |
| 4.6831 - 4.7240 | 118.95 - 119.99 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00300 | RSTS-094-0000x | RSRY-708-00812 | 9            |
| 4.7142 - 4.7551 | 119.74 - 120.78 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00302 | RSTS-095-0000x | RSRY-708-00812 | 9            |
| 4.7461 - 4.7870 | 120.55 - 121.59 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00304 | RSTS-096-0000x | RSRY-708-00812 | 9            |
| 4.7772 - 4.8181 | 121.34 - 122.38 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00306 | RSTS-097-0000x | RSRY-708-00812 | 9            |
| 4.8079 - 4.8492 | 122.12 - 123.17 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00308 | RSTS-098-0000x | RSRY-708-00812 | 9            |
| 4.8390 - 4.8799 | 122.91 - 123.95 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00310 | RSTS-099-0000x | RSRY-708-00812 | 9            |
| 4.8709 - 4.9122 | 123.72 - 124.77 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-00312 | RSTS-100-0000x | RSRY-708-00812 | 9            |
| 4.9020 - 4.9429 | 124.51 - 125.55 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-01245 | RSTS-03x-01245 | RSRY-708-00812 | 9            |
| 4.9331 - 4.9740 | 125.30 - 126.34 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-01255 | RSTS-03x-01255 | RSRY-708-00812 | 9            |
| 4.9642 - 5.0051 | 126.09 - 127.13 | RSKS-200-xxxxx                  | RSKS-100-xxxxx               | RSCS-015-01265 | RSTS-03x-01265 | RSRY-708-00812 | 9            |
| 4.9961 - 5.0370 | 126.90 - 127.94 | 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 D: 6 for the correct identification of the "x" value.

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

D: 42 - 45

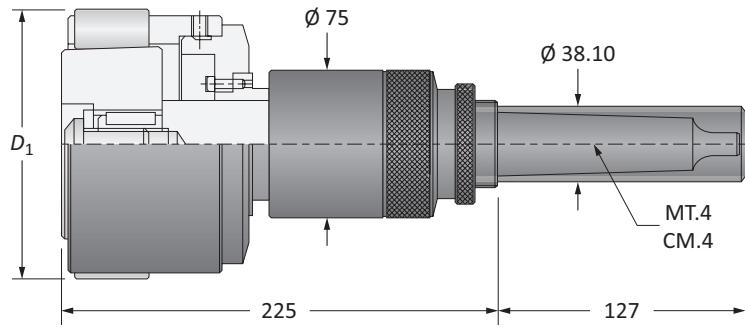
D: 40 - 41

D: 39

Key on D: 1

## Roller Burnishing Tools | Through Holes

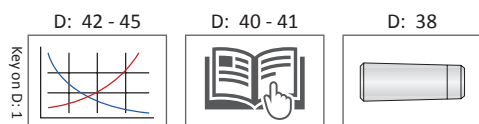
T Series | Diameter Range: 5.0354" - 5.9016" (127.90 mm - 149.90 mm)



### Through Holes

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

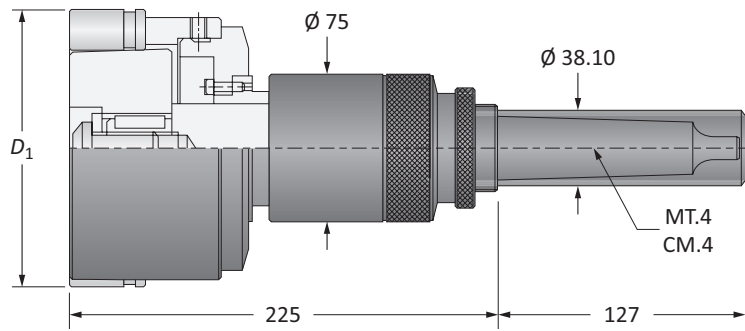
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



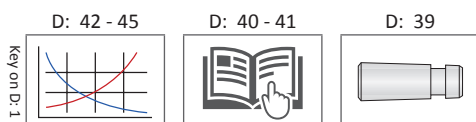
### Blind Holes

| D <sub>1</sub>  |                 | Part No.*                          |                                 | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|-----------------|------------------------------------|---------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)     | Assembly with<br>Morse Taper Shank | Assembly with<br>Straight Shank | Cage           | Cone**         | Rolls          |              |
| 5.0354 - 5.0748 | 127.90 - 128.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01280 | RSTT-0xx-01280 | RSRY-708-00812 | 11           |
| 5.0748 - 5.1142 | 128.90 - 129.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01290 | RSTT-0xx-01290 | RSRY-708-00812 | 11           |
| 5.1142 - 5.1535 | 129.90 - 130.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01300 | RSTT-0xx-01300 | RSRY-708-00812 | 11           |
| 5.1535 - 5.1929 | 130.90 - 131.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01310 | RSTT-0xx-01310 | RSRY-708-00812 | 11           |
| 5.1929 - 5.2323 | 131.90 - 132.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01320 | RSTT-0xx-01320 | RSRY-708-00812 | 11           |
| 5.2323 - 5.2717 | 132.90 - 133.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01330 | RSTT-0xx-01330 | RSRY-708-00812 | 11           |
| 5.2717 - 5.3110 | 133.90 - 134.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01340 | RSTT-0xx-01340 | RSRY-708-00812 | 11           |
| 5.3110 - 5.3504 | 134.90 - 135.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01350 | RSTT-0xx-01350 | RSRY-708-00812 | 11           |
| 5.3504 - 5.3898 | 135.90 - 136.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01360 | RSTT-0xx-01360 | RSRY-708-00812 | 11           |
| 5.3898 - 5.4291 | 136.90 - 137.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01370 | RSTT-0xx-01370 | RSRY-708-00812 | 11           |
| 5.4291 - 5.4685 | 137.90 - 138.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01380 | RSTT-0xx-01380 | RSRY-708-00812 | 11           |
| 5.4685 - 5.5079 | 138.90 - 139.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01390 | RSTT-0xx-01390 | RSRY-708-00812 | 11           |
| 5.5079 - 5.5472 | 139.90 - 140.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01400 | RSTT-0xx-01400 | RSRY-708-00812 | 11           |
| 5.5472 - 5.5866 | 140.90 - 141.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01410 | RSTT-0xx-01410 | RSRY-708-00812 | 11           |
| 5.5866 - 5.6260 | 141.60 - 142.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01420 | RSTT-0xx-01420 | RSRY-708-00812 | 11           |
| 5.6260 - 5.6654 | 142.90 - 143.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01430 | RSTT-0xx-01430 | RSRY-708-00812 | 11           |
| 5.6654 - 5.7047 | 143.90 - 144.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01440 | RSTT-0xx-01440 | RSRY-708-00812 | 11           |
| 5.7047 - 5.7441 | 144.90 - 145.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01450 | RSTT-0xx-01450 | RSRY-708-00812 | 11           |
| 5.7441 - 5.7835 | 145.90 - 146.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01460 | RSTT-0xx-01460 | RSRY-708-00812 | 11           |
| 5.7835 - 5.8228 | 146.90 - 147.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01470 | RSTT-0xx-01470 | RSRY-708-00812 | 11           |
| 5.8228 - 5.8622 | 147.90 - 148.90 | RSKT-200-xxxxx                     | RSKT-100-xxxxx                  | RSCT-015-01480 | RSTT-0xx-01480 | RSRY-708-00812 | 11           |
| 5.8622 - 5.9016 | 148.90 - 149.90 | 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 Ø 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 D: 6 for the correct identification of the "x" value.

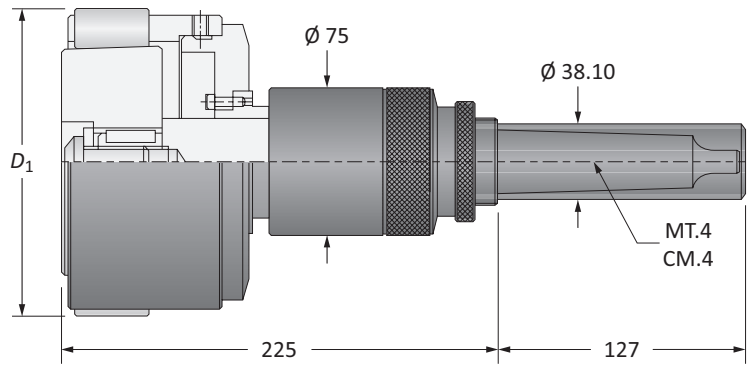
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



T  
A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Roller Burnishing Tools | Through Holes

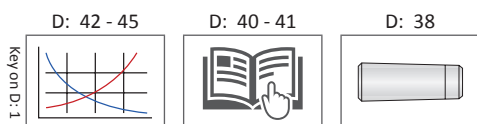
U Series | Diameter Range: 5.9016" - 6.5315" (149.90 mm - 165.90 mm)



### Through Holes

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

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

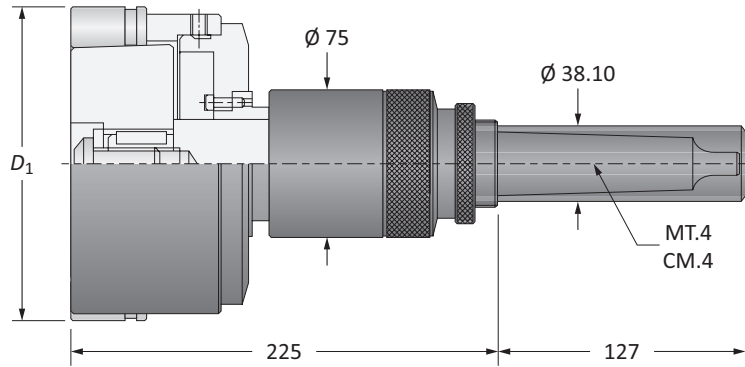






## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

| $D_1$           |                 | Part No.*                       |                              | Spare Parts    |                |                | Qty<br>Rolls |
|-----------------|-----------------|---------------------------------|------------------------------|----------------|----------------|----------------|--------------|
| Imperial (in)   | Metric (mm)     | Assembly with Morse Taper Shank | Assembly with Straight Shank | Cage           | Cone**         | Rolls          |              |
| 5.9016 - 5.9409 | 149.90 - 150.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01500 | RSTU-0xx-01500 | RSRY-708-00812 | 13           |
| 5.9409 - 5.9803 | 150.90 - 151.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01510 | RSTU-0xx-01510 | RSRY-708-00812 | 13           |
| 5.9803 - 6.0197 | 151.90 - 152.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01520 | RSTU-0xx-01520 | RSRY-708-00812 | 13           |
| 6.0197 - 6.0591 | 152.90 - 153.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01530 | RSTU-0xx-01530 | RSRY-708-00812 | 13           |
| 6.0591 - 6.0984 | 153.90 - 154.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01540 | RSTU-0xx-01540 | RSRY-708-00812 | 13           |
| 6.0984 - 6.1378 | 154.90 - 155.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01550 | RSTU-0xx-01550 | RSRY-708-00812 | 13           |
| 6.1378 - 6.1772 | 155.90 - 156.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01560 | RSTU-0xx-01560 | RSRY-708-00812 | 13           |
| 6.1772 - 6.2165 | 156.90 - 157.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01570 | RSTU-0xx-01570 | RSRY-708-00812 | 13           |
| 6.2165 - 6.2559 | 157.90 - 158.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01580 | RSTU-0xx-01580 | RSRY-708-00812 | 13           |
| 6.2559 - 6.2953 | 158.90 - 159.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01590 | RSTU-0xx-01590 | RSRY-708-00812 | 13           |
| 6.2953 - 6.3346 | 159.90 - 160.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01600 | RSTU-0xx-01600 | RSRY-708-00812 | 13           |
| 6.3346 - 6.3740 | 160.90 - 161.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01610 | RSTU-0xx-01610 | RSRY-708-00812 | 13           |
| 6.3740 - 6.4134 | 161.90 - 162.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01620 | RSTU-0xx-01620 | RSRY-708-00812 | 13           |
| 6.4134 - 6.4528 | 162.90 - 163.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01630 | RSTU-0xx-01630 | RSRY-708-00812 | 13           |
| 6.4528 - 6.4921 | 163.90 - 164.90 | RSKU-200-xxxxx                  | RSKU-100-xxxxx               | RSCU-015-01640 | RSTU-0xx-01640 | RSRY-708-00812 | 13           |
| 6.4921 - 6.5315 | 164.90 - 165.90 | 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 D: 6 for the correct identification of the "x" value.

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

D: 42 - 45

D: 40 - 41

D: 39

Key on D: 1

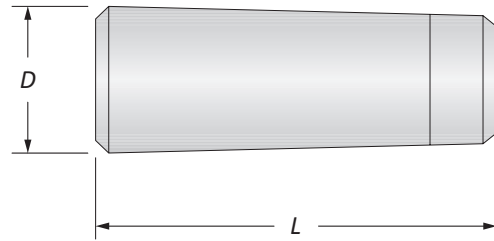
U  
A  
DRILLING  
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BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Rolls

### Through Holes

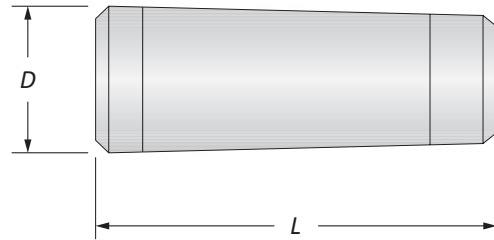
#### Rolls 704 and 707

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



#### Rolls 701

| Part No.       | Imperial (in) |        | Metric (mm) |       |
|----------------|---------------|--------|-------------|-------|
|                | D             | L      | D           | L     |
| RDRY-701-00187 | 0.1831        | 0.8772 | 4.65        | 22.28 |
| RDRY-701-00218 | 0.2138        | 1.0000 | 5.43        | 25.40 |
| RDRY-701-00265 | 0.2610        | 1.1252 | 6.63        | 28.58 |
| RDRY-701-00312 | 0.3039        | 1.5000 | 7.72        | 38.10 |
| RDRY-701-00406 | 0.3980        | 1.5000 | 10.11       | 38.10 |
| RDRY-701-00468 | 0.4598        | 1.5000 | 11.68       | 38.10 |
| RDRY-701-00531 | 0.5228        | 1.5000 | 13.28       | 38.10 |
| RDRY-701-00625 | 0.6169        | 1.5000 | 15.67       | 38.10 |
| RDRY-701-00687 | 0.6799        | 1.5000 | 17.27       | 38.10 |
| RDRY-701-00812 | 0.8039        | 1.5000 | 20.42       | 38.10 |

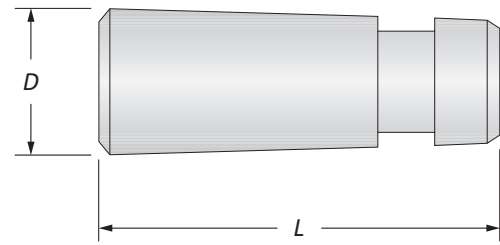


## Rolls

### Blind Holes

#### Rolls 708

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



A

DRILLING

B

BORING

C

REAMING

**D**

BURNISHING

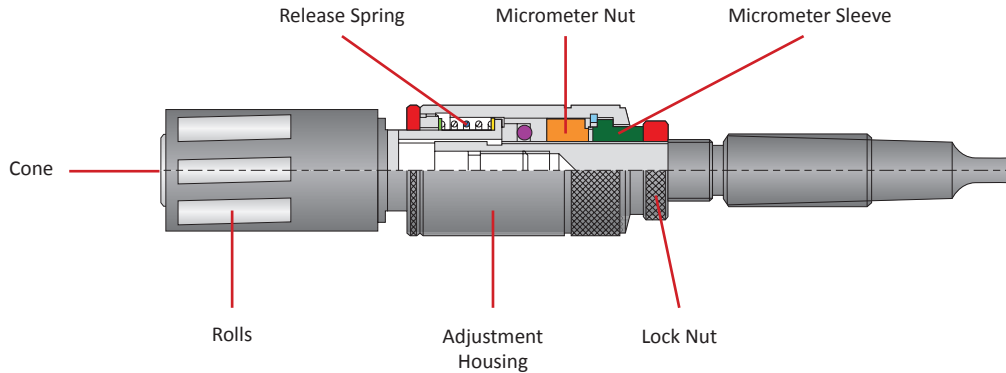
E

THREADING

X

SPECIALS

## Diameter Adjustment



### Adjustment

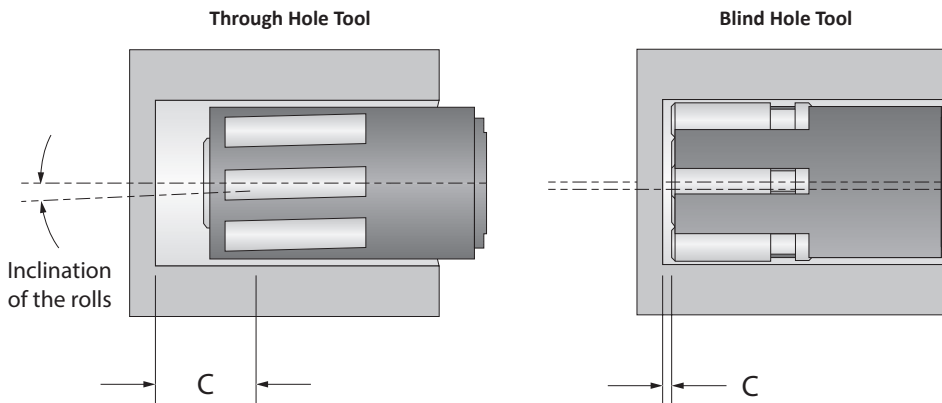
The roller burnishing tool incorporates a shank, a body, and a planetary system of conical rolls that are evenly spaced by a retaining cage.

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**

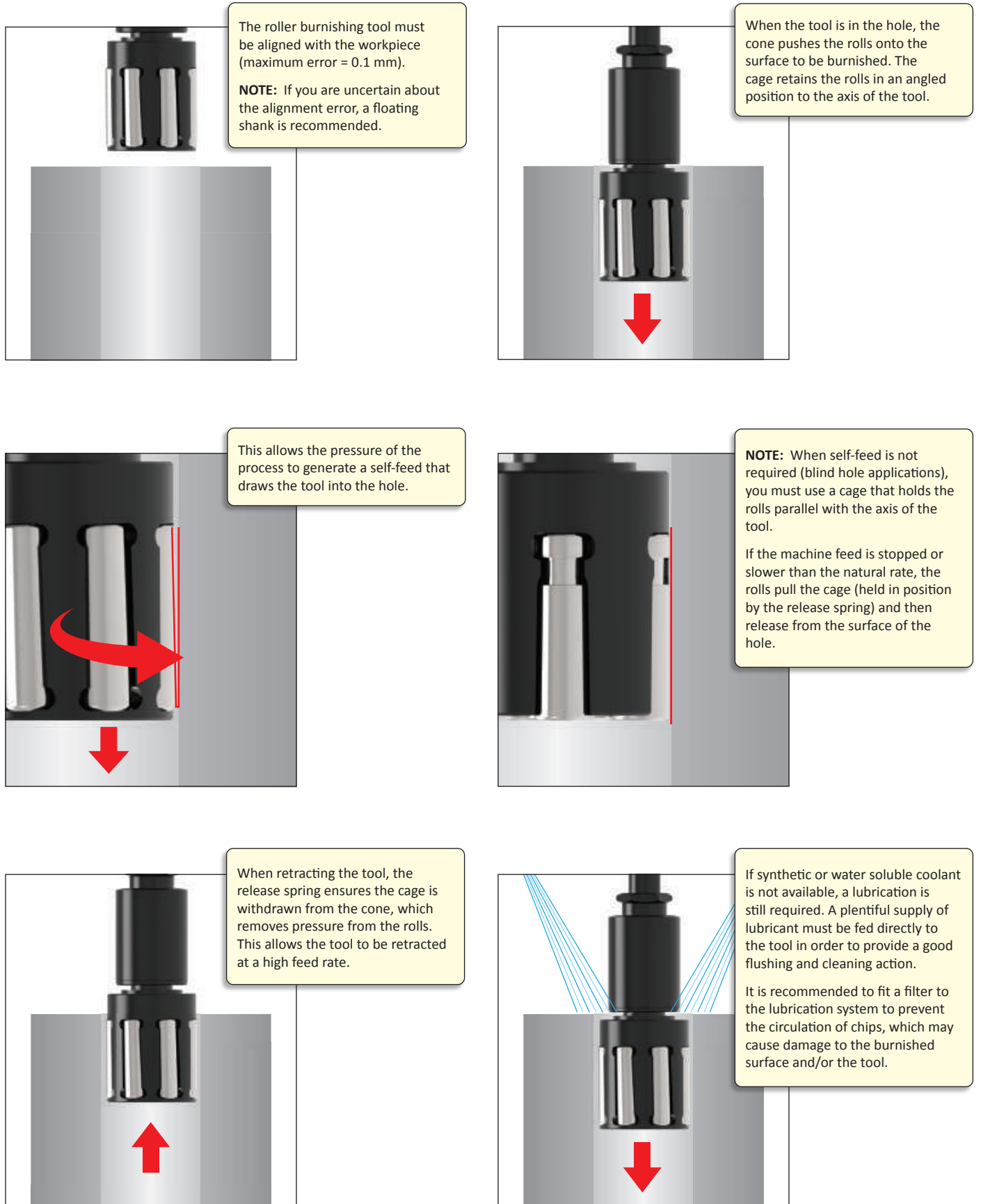


Larger Diameter = Extruded Cone = Decreased Clearance

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

## How it Works

### Roller Burnishing Tools



## Recommended Cutting Data | Imperial (inch)

### Roller Burnishing

| ISO   | Material  | Hardness (BHN) | Speed (SFM)   | Recommended Feed (IPR) by Burnisher Diameter |                   |                   |                   |
|---|---|----------------|---------------|--|-------------------|-------------------|-------------------|
|   |   |                |               | 0.1850" - 0.4724"                            | 0.4725" - 0.9843" | 0.9844" - 1.9685" | 1.9686" - 6.5315" |
| P   | Free-Machining Steel<br>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<br>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<br>1030, 1040, 1050, 1527, 1140, 1151, 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<br>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<br>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<br>A36, A285, A516, etc.                         | 125 - 180      | 75 - 300      | 0.005 - 0.020                                | 0.014 - 0.037     | 0.032 - 0.086     | 0.070 - 0.121     |
| 180 - 350                                     |   | 75 - 300       | 0.005 - 0.020 | 0.014 - 0.037                                | 0.032 - 0.086     | 0.070 - 0.121     |                   |
| Tool Steel<br>H-13, H-21, A-4, O-2, 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     |                   |
| S   | High-Temp Alloy<br>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     |
| M   | Stainless Steel 400 Series<br>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<br>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     |
| K   | Grey Cast Iron, Ductile Iron,<br>Spheroidal Cast Iron (Pearlitic) | < 200          | 75 - 300      | 0.005 - 0.020                                | 0.014 - 0.037     | 0.032 - 0.086     | 0.070 - 0.121     |
|   | Spheroidal Cast Iron (Ferritic)                                   | > 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   | < 500          | 150 - 350     | 0.005 - 0.020                                | 0.014 - 0.037     | 0.032 - 0.086     | 0.070 - 0.121     |
|   | Brass   | < 180          | 150 - 350     | 0.005 - 0.020                                | 0.014 - 0.037     | 0.032 - 0.086     | 0.070 - 0.121     |
|   | Bronze  | < 180          | 150 - 350     | 0.005 - 0.020                                | 0.014 - 0.037     | 0.032 - 0.086     | 0.070 - 0.121     |
|   | 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     |

#### 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     |

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## Stock Allowance | Imperial (inch)

### Roller Burnishing

| ISO  | Material   | Hardness (BHN)  | Recommended Stock (inch) by Burnisher Diameter* |                   |                   |                   |
|--|--|-----------------|---|-------------------|-------------------|-------------------|
|  |  |                 | 0.1850" - 0.4724"                               | 0.4725" - 0.9843" | 0.9844" - 1.9685" | 1.9686" - 6.5315" |
| P  | <b>Free-Machining Steel</b><br>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   |
|  | <b>Low-Carbon Steel</b><br>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   |
|  | <b>Medium-Carbon Steel</b><br>1030, 1040, 1050, 1527, 1140, 1151, 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   |
|  | <b>Alloy Steel</b><br>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   |
|  | <b>High-Strength Alloy</b><br>4340, 4330V, 300M, etc.                  | 240 - 450       | 0.0004 - 0.0007                                 | 0.0005 - 0.0007   | 0.0005 - 0.0010   | 0.0008 - 0.0014   |
|  | <b>Structural Steel</b><br>A36, A285, A516, etc.                       | 125 - 180       | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | 180 - 350  | 0.0004 - 0.0007 | 0.0005 - 0.0007                                 | 0.0005 - 0.0010   | 0.0008 - 0.0014   |                   |
| <b>Tool Steel</b><br>H-13, H-21, A-4, O-2, 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   |                   |
| S  | <b>High-Temp Alloy</b><br>Hastelloy B, Inconel 600, etc.               | 140 - 310       | 0.0004 - 0.0007                                 | 0.0005 - 0.0007   | 0.0005 - 0.0010   | 0.0008 - 0.0014   |
|  | <b>Titanium Alloy</b>  | 140 - 310       | 0.0004 - 0.0007                                 | 0.0005 - 0.0007   | 0.0005 - 0.0010   | 0.0008 - 0.0014   |
| M  | <b>Stainless Steel 400 Series</b><br>416, 420, etc.                    | 135 - 350       | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | <b>Stainless Steel 300 Series</b><br>304, 316, 17-4PH, etc.            | 135 - 275       | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
| K  | <b>Grey Cast Iron, Ductile Iron, Spheroidal Cast Iron (Pearlitic)</b>  | < 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   |
|  | <b>Spheroidal Cast Iron (Ferritic)</b>                                 | 260 - 320       | 0.0004 - 0.0007                                 | 0.0005 - 0.0007   | 0.0005 - 0.0010   | 0.0008 - 0.0014   |
| N  | <b>Copper and Alloys</b>   | < 500           | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | <b>Brass</b>   | < 180           | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | <b>Bronze</b>  | < 180           | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | <b>Bronze Phosphorous</b>  | < 180           | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |
|  | <b>Aluminum and Alloys</b>   | < 150           | 0.0004 - 0.0007                                 | 0.0007 - 0.0016   | 0.0010 - 0.0018   | 0.0012 - 0.0020   |

\*Stock value is on diameter.

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A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS

## Recommended Cutting Data | Metric (mm)

### Roller Burnishing

| ISO | Material   | Hardness (BHN) | Speed (M/min) | Recommended Feed (mm/rev) by Burnisher 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   | <b>Free-Machining Steel</b><br>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          |
|     | <b>Low-Carbon Steel</b><br>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          |
|     | <b>Medium-Carbon Steel</b><br>1030, 1040, 1050, 1527, 1140, 1151, 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          |
|     | <b>Alloy Steel</b><br>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          |
|     | <b>High-Strength Alloy</b><br>4340, 4330V, 300M, etc.                  | 240 - 450      | 22 - 90       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     |  |                |               |   |                     |                     |                      |
| S   | <b>High-Temp Alloy</b><br>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          |
|     | <b>Titanium Alloy</b>  | 140 - 310      | 15 - 45       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
| M   | <b>Stainless Steel 400 Series</b><br>416, 420, etc.                    | 135 - 350      | 22 - 60       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     | <b>Stainless Steel 300 Series</b><br>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          |
| K   | <b>Grey Cast Iron, Ductile Iron,</b>                                   | < 200          | 22 - 90       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     | <b>Spheroidal Cast Iron (Pearlitic)</b>                                | > 200          | 22 - 90       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     | <b>Spheroidal Cast Iron (Ferritic)</b>                                 | 260 - 320      | 22 - 90       | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
| N   | <b>Copper and Alloys</b>   | < 500          | 45 - 105      | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     | <b>Brass</b>   |                |               |   |                     |                     |                      |
|     | <b>Bronze</b>  | < 180          | 45 - 105      | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |
|     | <b>Bronze Phosphorous</b>  |                |               |   |                     |                     |                      |
|     | <b>Aluminum and Alloys</b>   | < 150          | 45 - 105      | 0.13 - 0.51                                     | 0.36 - 0.94         | 0.81 - 2.18         | 1.78 - 3.07          |

#### 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     |

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## Stock Allowance | Metric (mm)

### Roller Burnishing

| ISO  | Material   | Hardness (BHN) | Recommended Stock (mm) by Burnisher 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  | <b>Free-Machining Steel</b><br>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        |
|  | <b>Low-Carbon Steel</b><br>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        |
|  | <b>Medium-Carbon Steel</b><br>1030, 1040, 1050, 1527, 1140, 1151, 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        |
|  | <b>Alloy Steel</b><br>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        |
|  | <b>High-Strength Alloy</b><br>4340, 4330V, 300M, etc.                  | 240 - 450      | 0.010 - 0.018                                 | 0.012 - 0.018       | 0.012 - 0.025       | 0.020 - 0.036        |
|  | <b>Structural Steel</b><br>A36, A285, A516, etc.                       | 125 - 180      | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | 180 - 350  | 0.010 - 0.018  | 0.012 - 0.018                                 | 0.012 - 0.025       | 0.020 - 0.036       |                      |
| <b>Tool Steel</b><br>H-13, H-21, A-4, O-2, 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       |                      |
| S  | <b>High-Temp Alloy</b><br>Hastelloy B, Inconel 600, etc.               | 140 - 310      | 0.010 - 0.018                                 | 0.012 - 0.018       | 0.012 - 0.025       | 0.020 - 0.036        |
|  | <b>Titanium Alloy</b>  | 140 - 310      | 0.010 - 0.018                                 | 0.012 - 0.018       | 0.012 - 0.025       | 0.020 - 0.036        |
| M  | <b>Stainless Steel 400 Series</b><br>416, 420, etc.                    | 135 - 350      | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | <b>Stainless Steel 300 Series</b><br>304, 316, 17-4PH, etc.            | 135 - 275      | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
| K  | <b>Grey Cast Iron, Ductile Iron, Spheroidal Cast Iron (Pearlitic)</b>  | < 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        |
|  | <b>Spheroidal Cast Iron (Ferritic)</b>                                 | 260 - 320      | 0.010 - 0.018                                 | 0.012 - 0.018       | 0.012 - 0.025       | 0.020 - 0.036        |
| N  | <b>Copper and Alloys</b>   | < 500          | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | <b>Brass</b>   | < 180          | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | <b>Bronze</b>  | < 180          | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | <b>Bronze Phosphorous</b>  | < 180          | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |
|  | <b>Aluminum and Alloys</b>   | < 150          | 0.010 - 0.018                                 | 0.018 - 0.041       | 0.025 - 0.046       | 0.030 - 0.051        |

\*Stock value is on diameter.

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A  
DRILLING  
B  
BORING  
C  
REAMING  
D  
BURNISHING  
E  
THREADING  
X  
SPECIALS





# Guaranteed Test / Demo Application Form

Distributor PO # \_\_\_\_\_

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

## 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: _____<br>(4150 / A36 / Cast Iron / etc.) |
| Preexisting Diameter: _____ in/mm | Depth of Cut: _____ in/mm                        | Hardness: _____<br>(BHN / Rc)                      |
| Required Finish: _____ RMS        | State: _____<br>(Casting / Hot rolled / Forging) |  |

## Machine Information

|  |  |                              |
|--|--|------------------------------|
| Machine Type: _____<br>(Lathe / Screw machine / Machine center / etc.) | Builder: _____<br>(Haas, Mori Seiki, etc.) | Model #: _____               |
| Shank Required: _____<br>(CAT50 / Morse taper, etc.)                   |  | Power: _____ HP/KW           |
| Rigidity: _____  | Orientation: _____                         | Tool Rotating: _____         |
| <input type="checkbox"/> Excellent                                     | <input type="checkbox"/> Vertical          | <input type="checkbox"/> Yes |
| <input type="checkbox"/> Good  | <input type="checkbox"/> Horizontal        | <input type="checkbox"/> No  |
| <input type="checkbox"/> Poor  |  | Thrust: _____ lbs/N          |

## Coolant Information

|  |                                   |
|--|-----------------------------------|
| Coolant Delivery: _____<br>(Through tool / Flood)                      | Coolant Pressure: _____ PSI / bar |
| Coolant Type: _____<br>(Air mist, oil, synthetic, water soluble, etc.) | Coolant Volume: _____ GPM / LPM   |

## Requested Tooling

| QTY | Item Number | QTY | Item Number |
|-----|-------------|-----|-------------|
|     |             |     |             |
|     |             |     |             |
|     |             |     |             |
|     |             |     |             |
|     |             |     |             |
|     |             |     |             |



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## 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.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. Allied Machine shall have no liability or responsibility for any claim, whether in contract, tort or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery or use of any product sold hereunder, in excess of the cost of replacement or repair as provided herein.

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