



**ALLIED MACHINE  
& ENGINEERING**

**WOHLHAUPTER®**

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.®**



The background of the page features a complex geometric pattern. It consists of several concentric circles of varying radii, centered on the left side of the page. Overlaid on these circles is a grid of thin, light-colored lines that form a series of overlapping rectangular shapes. The overall effect is a layered, architectural design in shades of light red and white against the darker red background.

SECTION

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D

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Burnishing

# S.C.A.M.I.® 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.
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## Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General Machining



Oil & Gas



Renewable Energy

Your safety and the safety of others is very important. This catalogue 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 catalogue, 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 catalogue. 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.

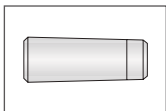
**Reference Icons**

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



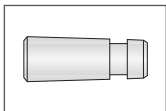
**Technical Information**

Detailed instructions and information regarding the corresponding part(s)



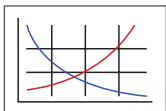
**Through Hole Rolls**

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

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



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.  
 email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

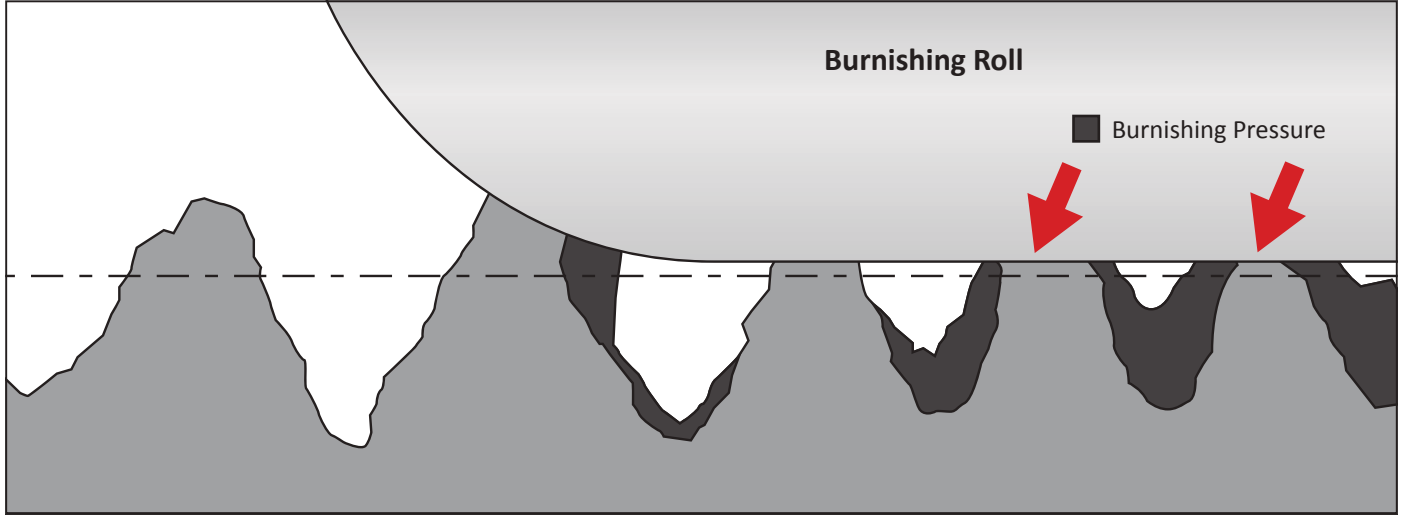
## Roller Burnishing Overview

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

### 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

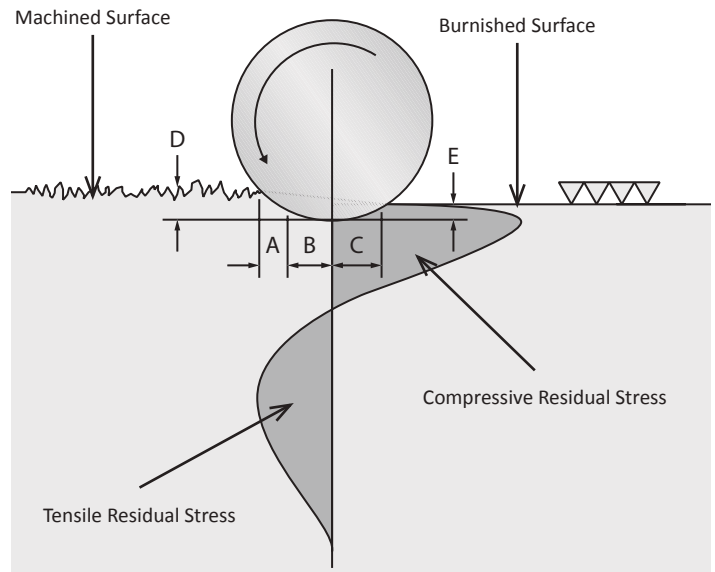
- Grain structure is condensed and refined.
- The compacted surface is **smoother, harder, and more wear resistant** than ground or honed surfaces.
- The process reduces surface porosity and also removes scratches that could hold reactive substances or contaminants. **This increases the corrosion resistance.**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

#### 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 pressurised depth.
- Once the material endures the maximum compressive strain (Section C), it starts relieving elastically (Section E) through the finishing zone.
- This leaves a smooth surface and a compressive residual stress of significant peak value.
- The stresses formed on the material during the compression decrease toward the center. These stresses reach approximately 1 mm below the surface. This increases the surface hardness.

#### Advantages of Roller Burnishing: Surface Finish

- Creates a high finish to any machinable metal.
- Surfaces that are bored, reamed, or turned to 3.2 Ra(μm) or more can be finished to 0.1 Ra(μm) 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.



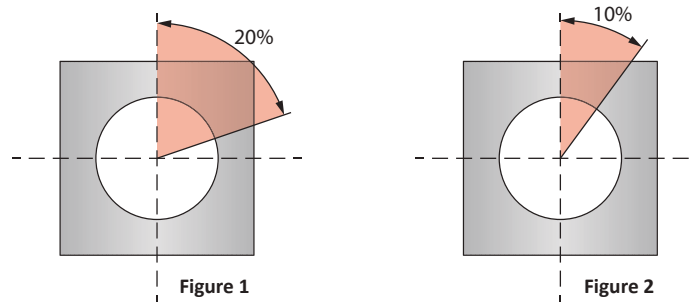
## Roller Burnishing Overview

### 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.

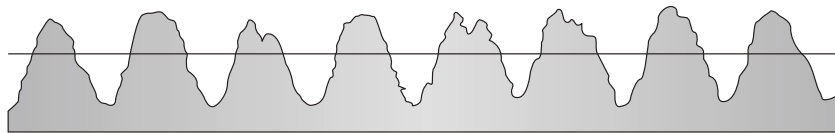


Figure 3

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).

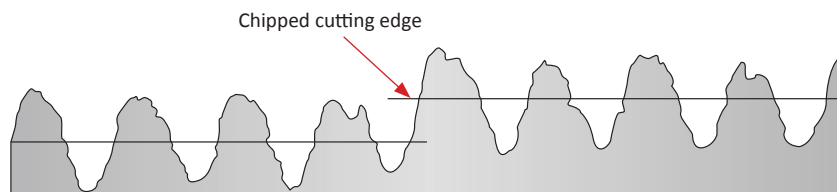


Figure 4

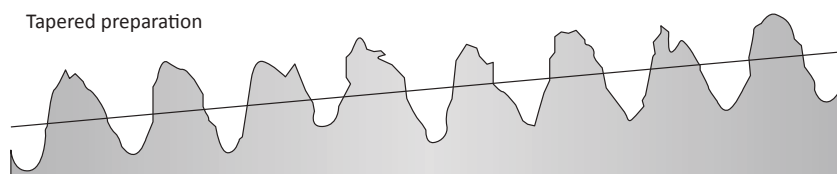


Figure 5



## Product Offering



**Through Hole Style**

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

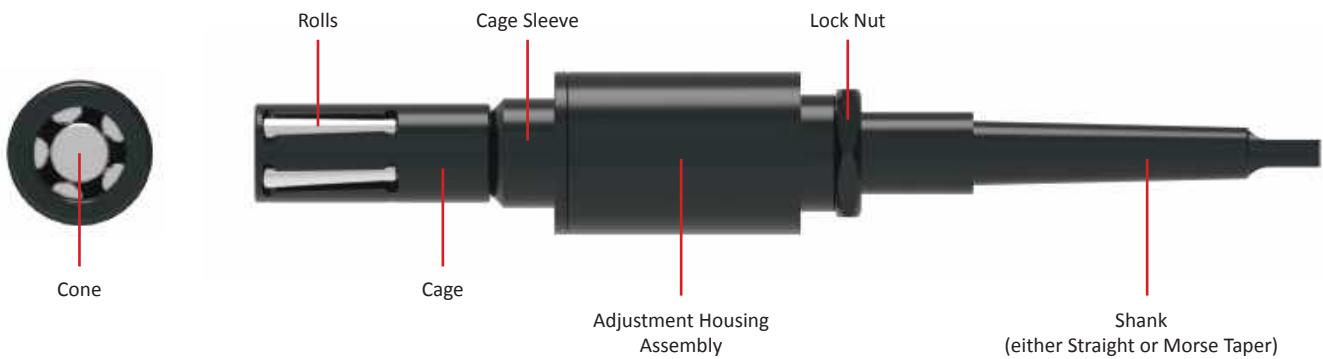


**Blind Hole Style**

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

### **Advantages** of the Roller Burnishing Tool

- ✔ **Provides accurate size control**  
 tolerances within 0.00127 mm (0.0005") or better (depending on variables such as material)
- ✔ **Produces fine surface finishes**  
 between 0.03 - 0.40  $\mu$ m
- ✔ **Increases surface hardness**  
 by 5 - 10% or more
- ✔ **Performs a much cleaner operation**  
 than honing or other abrasive finishing methods
- ✔ **Provides versatility**  
 because the operation can be performed on any rotating spindle
- ✔ **Eliminates the need for slower and costly finishing processes and secondary operations**  
 such as grinding, honing, lapping, etc.



#### **The Tool Components**

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

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

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

## Product Selection Guide

Series	Diameter Range (mm / inch)						Length				
	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	Short	Standard	Long	Unlimited
	0 - 1	1 - 2	2 - 3	3 - 4	4 - 5	5 - 6	6 - 7				
H* Mini	█							✓	✓		
H*	█							✓	✓	✓	
I	█							✓	✓	✓	
K	█							✓	✓	✓	
L		█						✓	✓	✓	
F		█									✓
M		█									✓
N		█									✓
O		█									✓
P			█								✓
Q			█								✓
R				█							✓
S					█						✓
T						█					✓
U							█				✓

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

### When to **ORDER UP**

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

**Example:**

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

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

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

**Product Nomenclature**

**Roller Burnishing Tools**

<b>RDK</b>	<b>H</b>	-	<b>2</b>	<b>1</b>	<b>0</b>	-	<b>00470</b>
1	2		3	4	5		6

<b>1. Type of Burnisher</b> <b>RDK</b> = Through holes <b>RSK</b> = Blind holes	<b>2. Series</b> <b>H</b> = H series <b>F</b> = F series <b>P</b> = P series <b>T</b> = T series <b>I</b> = I series <b>M</b> = M series <b>Q</b> = Q series <b>U</b> = U series <b>K</b> = K series <b>N</b> = N series <b>R</b> = R series <b>L</b> = L series <b>O</b> = O series <b>S</b> = S series	<b>3. Shank Type</b> <b>0</b> = Straight (mini) <b>1</b> = Straight <b>2</b> = Morse Taper
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<b>4. Length</b> <b>0</b> = Unlimited <b>1</b> = Short <b>2</b> = Standard <b>3</b> = Long	<b>5. Cage Style</b> <b>0</b> = Standard <b>2</b> = Mini	<b>6. Diameter</b> <b>Through Hole Tools</b> = Minimum diameter of burnishing range <b>Blind Hole Tools</b> = Diameter to burnish
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**Cone Reduction Factor (Blind Holes)**

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

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

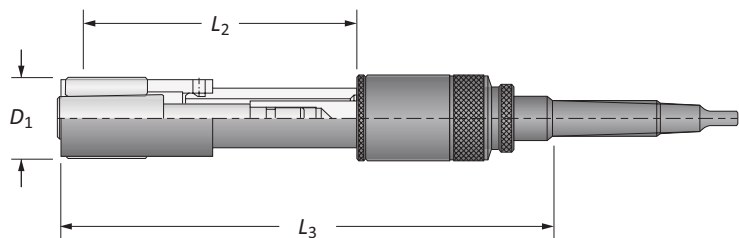
For through hole burnishing tools, the standard cone value "x" is 1. If the standard cone is used for blind hole burnishing, the only way it will not extend past the end of the rolls is to reduce the length of the cone. The required length reduction is dependent on the set diameter versus the minimum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

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

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

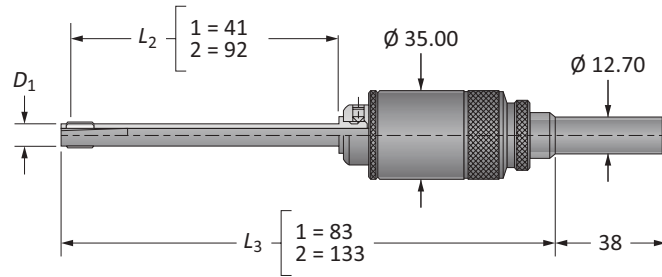
Symbol	Attribute
<b>D<sub>1</sub></b>	Diameter range
<b>L<sub>2</sub></b>	Burnishing length
<b>L<sub>3</sub></b>	Reference length





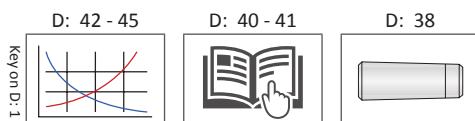
## Roller Burnishing Tools | Through Holes

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



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

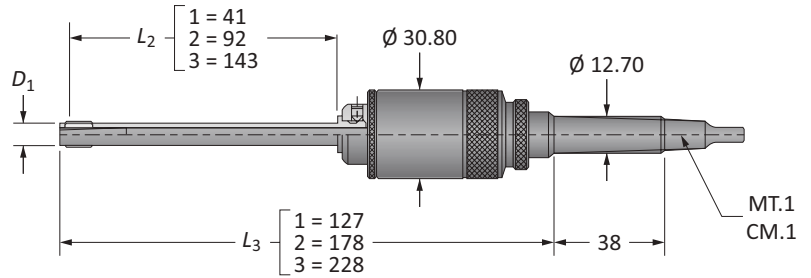
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.



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

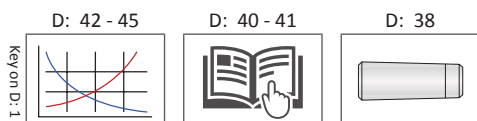
## Roller Burnishing Tools | Through Holes

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



$D_1$		$L$	Part No.		Spare Parts			Qty Rolls
Metric (mm)	Imperial (in)		Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone	Rolls	
4.70 - 4.90	0.1850 - 0.1929	1	RDKH-210-00470	RDKH-110-00470	RDCH-011-10012	RDTH-031-10012	RDRY-704-00062	3
4.70 - 4.90	0.1850 - 0.1929	2	RDKH-220-00470	RDKH-120-00470	RDCH-011-20012	RDTH-031-20012	RDRY-704-00062	3
4.70 - 4.90	0.1850 - 0.1929	3	RDKH-230-00470	RDKH-130-00470	RDCH-011-30012	RDTH-031-30012	RDRY-704-00062	3
4.87 - 5.17	0.1917 - 0.2035	1	RDKH-210-00487	RDKH-110-00487	RDCH-011-10011	RSTH-033-10012	RDRY-704-00062	3
4.87 - 5.17	0.1917 - 0.2035	2	RDKH-220-00487	RDKH-120-00487	RDCH-011-20011	RSTH-033-20012	RDRY-704-00062	3
4.87 - 5.17	0.1917 - 0.2035	3	RDKH-230-00487	RDKH-130-00487	RDCH-011-30011	RSTH-033-30012	RDRY-704-00062	3
5.07 - 5.59	0.1996 - 0.2200	1	RDKH-210-00507	RDKH-110-00507	RDCH-011-10013	RDTH-031-10013	RDRY-704-00062	5
5.07 - 5.59	0.1996 - 0.2200	2	RDKH-220-00507	RDKH-120-00507	RDCH-011-20013	RDTH-031-20013	RDRY-704-00062	5
5.07 - 5.59	0.1996 - 0.2200	3	RDKH-230-00507	RDKH-130-00507	RDCH-011-30013	RDTH-031-30013	RDRY-704-00062	5
5.49 - 5.99	0.2161 - 0.2358	1	RDKH-210-00549	RDKH-110-00549	RDCH-011-10014	RDTH-031-10013	RDRY-704-00070	5
5.49 - 5.99	0.2161 - 0.2358	2	RDKH-220-00549	RDKH-120-00549	RDCH-011-20014	RDTH-031-20013	RDRY-704-00070	5
5.49 - 5.99	0.2161 - 0.2358	3	RDKH-230-00549	RDKH-130-00549	RDCH-011-30014	RDTH-031-30013	RDRY-704-00070	5
5.89 - 6.41	0.2319 - 0.2524	1	RDKH-210-00589	RDKH-110-00589	RDCH-011-10015	RDTH-031-10015	RDRY-704-00070	5
5.89 - 6.41	0.2319 - 0.2524	2	RDKH-220-00589	RDKH-120-00589	RDCH-011-20015	RDTH-031-20015	RDRY-704-00070	5
5.89 - 6.41	0.2319 - 0.2524	3	RDKH-230-00589	RDKH-130-00589	RDCH-011-30015	RDTH-031-30015	RDRY-704-00070	5
6.31 - 6.81	0.2484 - 0.2681	1	RDKH-210-00631	RDKH-110-00631	RDCH-011-10016	RDTH-031-10015	RDRY-704-00078	5
6.31 - 6.81	0.2484 - 0.2681	2	RDKH-220-00631	RDKH-120-00631	RDCH-011-20016	RDTH-031-20015	RDRY-704-00078	5
6.31 - 6.81	0.2484 - 0.2681	3	RDKH-230-00631	RDKH-130-00631	RDCH-011-30016	RDTH-031-30015	RDRY-704-00078	5
6.71 - 7.21	0.2642 - 0.2839	1	RDKH-210-00671	RDKH-110-00671	RDCH-011-10017	RDTH-031-10017	RDRY-704-00078	5
6.71 - 7.21	0.2642 - 0.2839	2	RDKH-220-00671	RDKH-120-00671	RDCH-011-20017	RDTH-031-20017	RDRY-704-00078	5
6.71 - 7.21	0.2642 - 0.2839	3	RDKH-230-00671	RDKH-130-00671	RDCH-011-30017	RDTH-031-30017	RDRY-704-00078	5
7.12 - 7.62	0.2803 - 0.3000	1	RDKH-210-00712	RDKH-110-00712	RDCH-011-10018	RDTH-031-10017	RDRY-704-00086	5
7.12 - 7.62	0.2803 - 0.3000	2	RDKH-220-00712	RDKH-120-00712	RDCH-011-20018	RDTH-031-20017	RDRY-704-00086	5
7.12 - 7.62	0.2803 - 0.3000	3	RDKH-230-00712	RDKH-130-00712	RDCH-011-30018	RDTH-031-30017	RDRY-704-00086	5
7.48 - 7.98	0.2945 - 0.3142	1	RDKH-210-00748	RDKH-110-00748	RDCH-011-10019	RDTH-031-10019	RDRY-704-00086	5
7.48 - 7.98	0.2945 - 0.3142	2	RDKH-220-00748	RDKH-120-00748	RDCH-011-20019	RDTH-031-20019	RDRY-704-00086	5
7.48 - 7.98	0.2945 - 0.3142	3	RDKH-230-00748	RDKH-130-00748	RDCH-011-30019	RDTH-031-30019	RDRY-704-00086	5
7.88 - 8.38	0.3102 - 0.3299	1	RDKH-210-00788	RDKH-110-00788	RDCH-011-10020	RDTH-031-10019	RDRY-704-00093	5
7.88 - 8.38	0.3102 - 0.3299	2	RDKH-220-00788	RDKH-120-00788	RDCH-011-20020	RDTH-031-20019	RDRY-704-00093	5
7.88 - 8.38	0.3102 - 0.3299	3	RDKH-230-00788	RDKH-130-00788	RDCH-011-30020	RDTH-031-30019	RDRY-704-00093	5
8.28 - 8.79	0.3260 - 0.3461	1	RDKH-210-00828	RDKH-110-00828	RDCH-011-10021	RDTH-031-10021	RDRY-704-00093	5
8.28 - 8.79	0.3260 - 0.3461	2	RDKH-220-00828	RDKH-120-00828	RDCH-011-20021	RDTH-031-20021	RDRY-704-00093	5
8.28 - 8.79	0.3260 - 0.3461	3	RDKH-230-00828	RDKH-130-00828	RDCH-011-30021	RDTH-031-30021	RDRY-704-00093	5

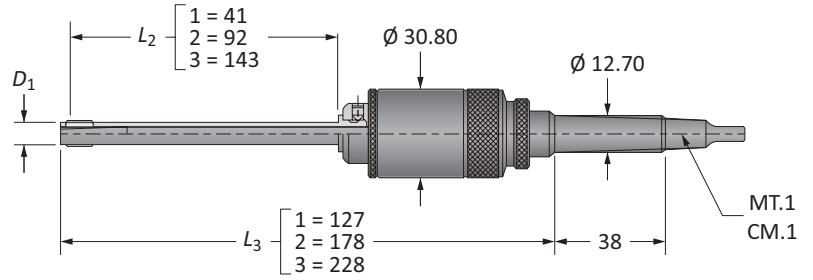
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Through Holes (continued)

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



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

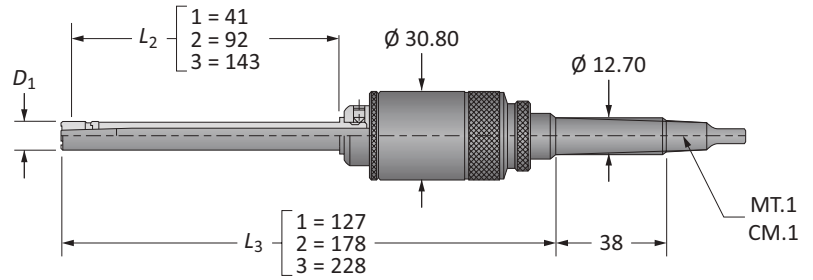
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.

D: 42 - 45      D: 40 - 41      D: 38

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

## Roller Burnishing Tools | Blind Holes

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

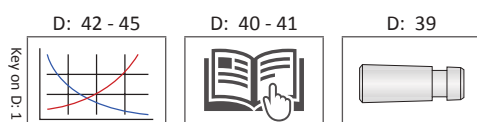


D <sub>1</sub>		L	Part No.*		Spare Parts			
Metric (mm)	Imperial (in)		Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	Qty Rolls
5.89 - 6.41	0.2319 - 0.2524	1	RSKH-210-xxxxx	RSKH-110-xxxxx	RSCH-015-10015	RSTH-03x-10012	RSRY-708-00086	3
5.89 - 6.41	0.2319 - 0.2524	2	RSKH-220-xxxxx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

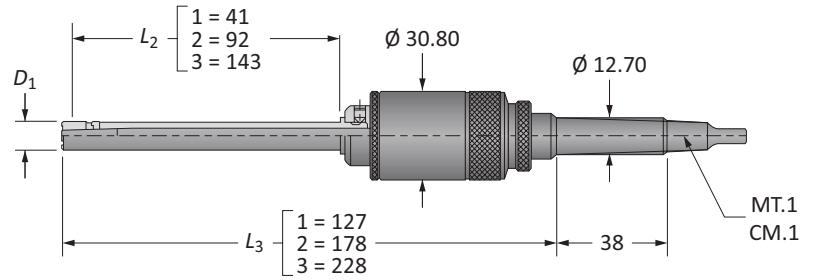
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





Roller Burnishing Tools | Blind Holes (continued)

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



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

Key on D: 1

D: 42 - 45

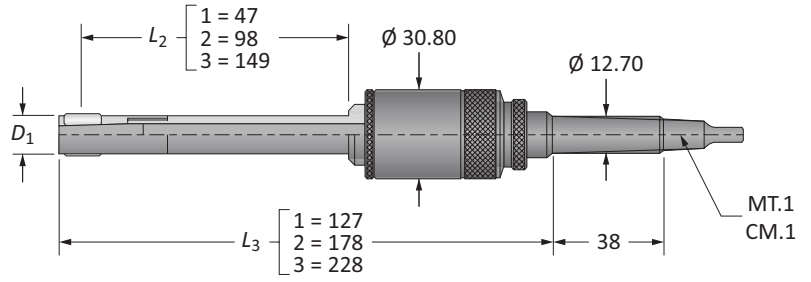
D: 40 - 41

D: 39

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

## Roller Burnishing Tools | Through Holes

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



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

A DRILLING

B BORING

C REAMING

D BURNISHING

F THREADING

X SPECIALS

Key on D: 1

D: 42 - 45

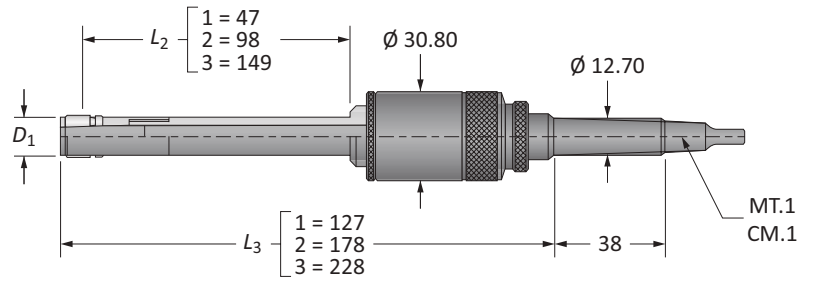
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



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

Key on D: 1

D: 42 - 45

D: 40 - 41

D: 39

K

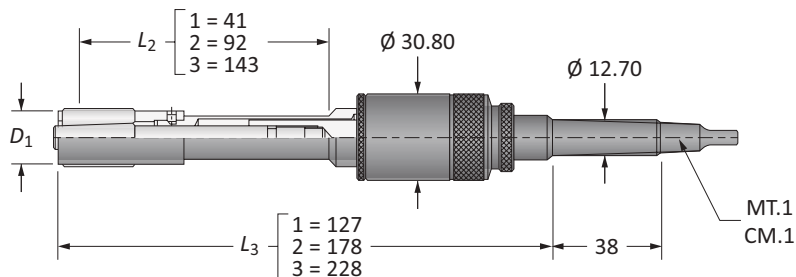

 BURNISHING | S.C.A.M.I.® Roller Burnishing Systems

## Roller Burnishing Tools | Through Holes

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

A

DRILLING

Technical drawing showing dimensions for the roller burnishing tool:

- Lengths:  $L_2$  (1 = 41, 2 = 92, 3 = 143) and  $L_3$  (1 = 127, 2 = 178, 3 = 228)
- Outer diameters:  $\varnothing 30.80$  and  $\varnothing 12.70$
- Tip diameter:  $\varnothing 12.70$
- Tip length: 38
- Material: MT.1 CM.1

B

BORING

$D_1$		$L$	Part No.		Spare Parts			Qty Rolls
Metric (mm)	Imperial (in)		Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone	Rolls	
16.60 - 17.61	0.6535 - 0.6933	1	RDKK-210-01660	RDKK-110-01660	RDCK-011-00042	RDTK-031-00042	RDRY-701-00187	5
16.60 - 17.61	0.6535 - 0.6933	2	RDKK-220-01660	RDKK-120-01660	RDCK-011-00042	RDTK-031-00042	RDRY-701-00187	5
16.60 - 17.61	0.6535 - 0.6933	3	RDKK-230-01660	RDKK-130-01660	RDCK-011-00042	RDTK-031-00042	RDRY-701-00187	5
17.40 - 18.39	0.6850 - 0.7240	1	RDKK-210-01740	RDKK-110-01740	RDCK-011-00044	RDTK-031-00044	RDRY-701-00187	5
17.40 - 18.39	0.6850 - 0.7240	2	RDKK-220-01740	RDKK-120-01740	RDCK-011-00044	RDTK-031-00044	RDRY-701-00187	5
17.40 - 18.39	0.6850 - 0.7240	3	RDKK-230-01740	RDKK-130-01740	RDCK-011-00044	RDTK-031-00044	RDRY-701-00187	5
18.19 - 19.18	0.7161 - 0.7551	1	RDKK-210-01819	RDKK-110-01819	RDCK-011-00046	RDTK-031-00042	RDRY-701-00218	5
18.19 - 19.18	0.7161 - 0.7551	2	RDKK-220-01819	RDKK-120-01819	RDCK-011-00046	RDTK-031-00042	RDRY-701-00218	5
18.19 - 19.18	0.7161 - 0.7551	3	RDKK-230-01819	RDKK-130-01819	RDCK-011-00046	RDTK-031-00042	RDRY-701-00218	5
18.96 - 19.99	0.7465 - 0.7870	1	RDKK-210-01896	RDKK-110-01896	RDCK-011-00048	RDTK-031-00044	RDRY-701-00218	5
18.96 - 19.99	0.7465 - 0.7870	2	RDKK-220-01896	RDKK-120-01896	RDCK-011-00048	RDTK-031-00044	RDRY-701-00218	5
18.96 - 19.99	0.7465 - 0.7870	3	RDKK-230-01896	RDKK-130-01896	RDCK-011-00048	RDTK-031-00044	RDRY-701-00218	5
19.74 - 20.77	0.7772 - 0.8177	1	RDKK-210-01974	RDKK-110-01974	RDCK-011-00050	RDTK-031-00050	RDRY-701-00218	5
19.74 - 20.77	0.7772 - 0.8177	2	RDKK-220-01974	RDKK-120-01974	RDCK-011-00050	RDTK-031-00050	RDRY-701-00218	5
19.74 - 20.77	0.7772 - 0.8177	3	RDKK-230-01974	RDKK-130-01974	RDCK-011-00050	RDTK-031-00050	RDRY-701-00218	5
20.52 - 21.57	0.8079 - 0.8492	1	RDKK-210-02052	RDKK-110-02052	RDCK-011-00052	RDTK-031-00052	RDRY-701-00218	5
20.52 - 21.57	0.8079 - 0.8492	2	RDKK-220-02052	RDKK-120-02052	RDCK-011-00052	RDTK-031-00052	RDRY-701-00218	5
20.52 - 21.57	0.8079 - 0.8492	3	RDKK-230-02052	RDKK-130-02052	RDCK-011-00052	RDTK-031-00052	RDRY-701-00218	5
21.31 - 22.35	0.8390 - 0.8799	1	RDKK-210-02131	RDKK-110-02131	RDCK-011-00054	RDTK-031-00054	RDRY-701-00218	5
21.31 - 22.35	0.8390 - 0.8799	2	RDKK-220-02131	RDKK-120-02131	RDCK-011-00054	RDTK-031-00054	RDRY-701-00218	5
21.31 - 22.35	0.8390 - 0.8799	3	RDKK-230-02131	RDKK-130-02131	RDCK-011-00054	RDTK-031-00054	RDRY-701-00218	5
22.13 - 23.16	0.8713 - 0.9118	1	RDKK-210-02213	RDKK-110-02213	RDCK-011-00056	RDTK-031-00050	RDRY-701-00265	5
22.13 - 23.16	0.8713 - 0.9118	2	RDKK-220-02213	RDKK-120-02213	RDCK-011-00056	RDTK-031-00050	RDRY-701-00265	5
22.13 - 23.16	0.8713 - 0.9118	3	RDKK-230-02213	RDKK-130-02213	RDCK-011-00056	RDTK-031-00050	RDRY-701-00265	5
22.91 - 23.96	0.9020 - 0.9433	1	RDKK-210-02291	RDKK-110-02291	RDCK-011-00058	RDTK-031-00052	RDRY-701-00265	5
22.91 - 23.96	0.9020 - 0.9433	2	RDKK-220-02291	RDKK-120-02291	RDCK-011-00058	RDTK-031-00052	RDRY-701-00265	5
22.91 - 23.96	0.9020 - 0.9433	3	RDKK-230-02291	RDKK-130-02291	RDCK-011-00058	RDTK-031-00052	RDRY-701-00265	5
23.70 - 24.74	0.9331 - 0.9740	1	RDKK-210-02370	RDKK-110-02370	RDCK-011-00060	RDTK-031-00054	RDRY-701-00265	5
23.70 - 24.74	0.9331 - 0.9740	2	RDKK-220-02370	RDKK-120-02370	RDCK-011-00060	RDTK-031-00054	RDRY-701-00265	5
23.70 - 24.74	0.9331 - 0.9740	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.

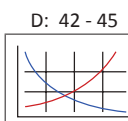
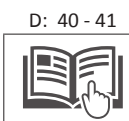
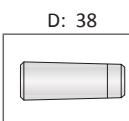
F

THREADING

X

SPECIALS

Key on D: 1

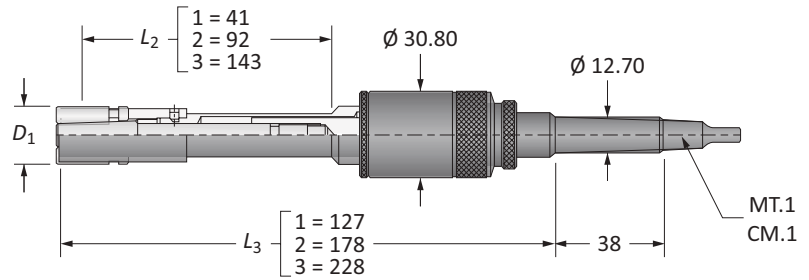
D: 14

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Roller Burnishing Tools | Blind Holes

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



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

Key on D: 1

D: 42 - 45

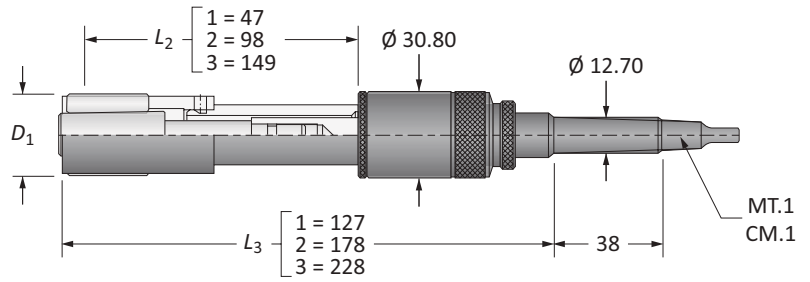
D: 40 - 41

D: 39

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

## Roller Burnishing Tools | Through Holes

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



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

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

Key on D: 1

D: 42 - 45

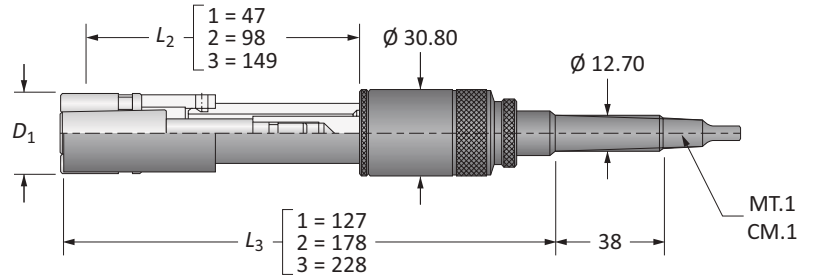
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



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

Key on D: 1

D: 42 - 45

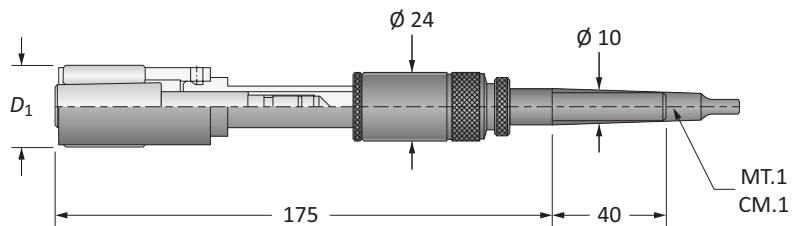
D: 40 - 41

D: 39

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

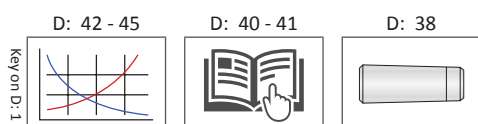
## Roller Burnishing Tools | Through Holes

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



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

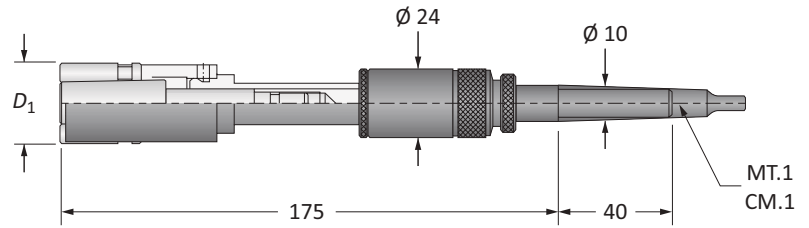
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



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

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher Ø 27.00 mm with MT.1 shank: RSKF-200-02700).

\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page 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

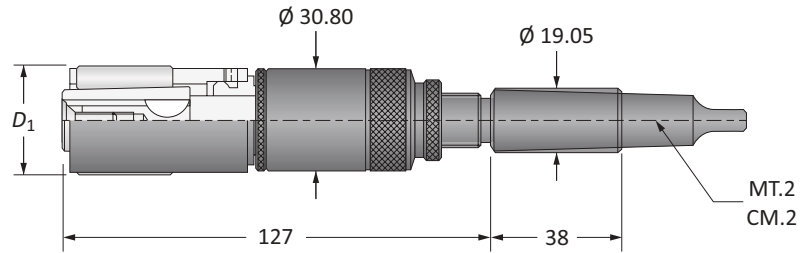
D: 39

Key on D: 1

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

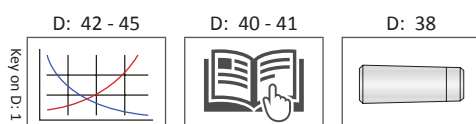
## Roller Burnishing Tools | Through Holes

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



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

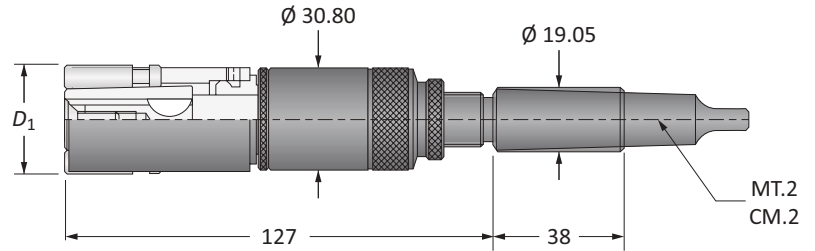
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



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

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher 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.

Key on D: 1

D: 42 - 45

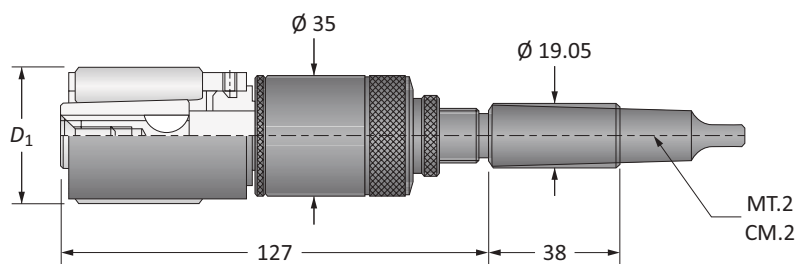
D: 40 - 41

D: 39

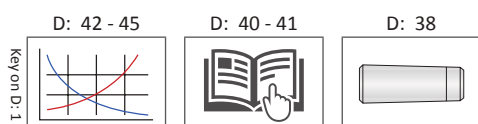


## Roller Burnishing Tools | Through Holes

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



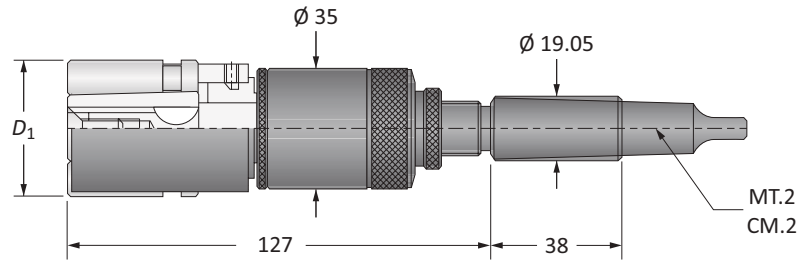
$D_1$		Part No.		Spare Parts			
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone	Rolls	Qty Rolls
35.61 - 36.66	1.4020 - 1.4433	RDKN-200-03561	RDKN-100-03561	RDCN-011-00090	RDTN-031-00090	RDRY-701-00312	7
36.40 - 37.44	1.4331 - 1.4740	RDKN-200-03640	RDKN-100-03640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

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



## Roller Burnishing Tools | Blind Holes

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



D <sub>1</sub>		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	Qty Rolls
35.61 - 36.66	1.4020 - 1.4433	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00090	RSTN-03x-00090	RSRY-708-00312	5
36.40 - 37.44	1.4331 - 1.4740	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00092	RSTN-03x-00092	RSRY-708-00312	5
37.18 - 38.23	1.4638 - 1.5051	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00094	RSTN-03x-00094	RSRY-708-00312	5
38.00 - 39.04	1.4961 - 1.5370	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00096	RSTN-03x-00096	RSRY-708-00312	5
38.79 - 39.82	1.5272 - 1.5677	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00098	RSTM-03x-00080	RSRY-708-00406	5
39.57 - 40.62	1.5579 - 1.5992	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00100	RSTM-03x-00082	RSRY-708-00406	5
40.36 - 41.40	1.5890 - 1.6299	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00102	RSTN-03x-00090	RSRY-708-00406	5
41.18 - 42.21	1.6213 - 1.6618	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00104	RSTN-03x-00092	RSRY-708-00406	5
41.96 - 43.01	1.6520 - 1.6933	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00106	RSTN-03x-00094	RSRY-708-00406	5
42.75 - 43.79	1.6831 - 1.7240	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00108	RSTM-03x-00082	RSRY-708-00468	5
43.53 - 44.58	1.7138 - 1.7551	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00110	RSTN-03x-00090	RSRY-708-00468	5
44.35 - 45.39	1.7461 - 1.7870	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00112	RSTN-03x-00092	RSRY-708-00468	5
45.14 - 46.17	1.7772 - 1.8177	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00114	RSTN-03x-00094	RSRY-708-00468	5
45.92 - 46.97	1.8079 - 1.8492	RSKN-200-xxxxx	RSKN-100-xxxxx	RSCN-015-00116	RSTN-03x-00096	RSRY-708-00468	5

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher 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.

D: 42 - 45

D: 40 - 41

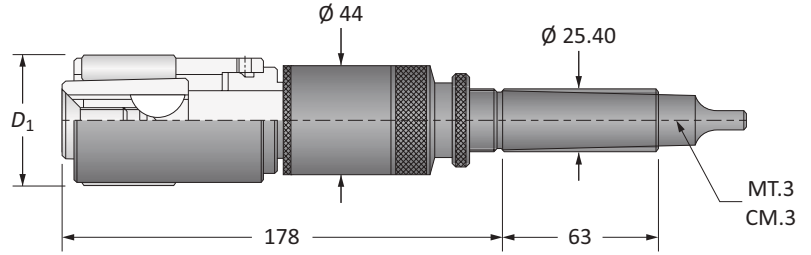
D: 39

Key on D: 1

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

## Roller Burnishing Tools | Through Holes

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



### Through Holes

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

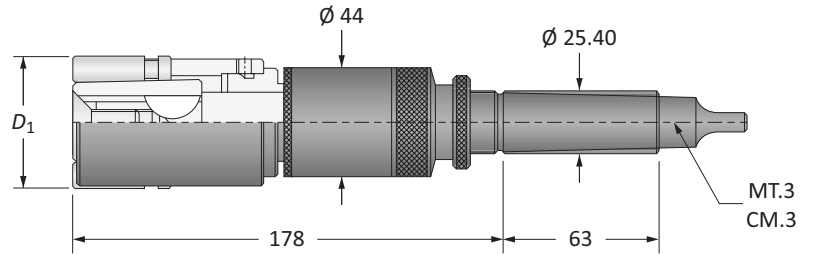
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



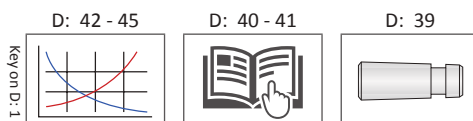
### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	Qty Rolls
46.71 - 47.75	1.8390 - 1.8799	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00118	RSTO-03x-00118	RSRY-708-00312	7
47.53 - 48.56	1.8713 - 1.9118	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00120	RSTO-03x-00120	RSRY-708-00312	7
48.31 - 49.36	1.9020 - 1.9433	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00122	RSTO-03x-00122	RSRY-708-00312	7
49.10 - 50.14	1.9331 - 1.9740	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00124	RSTO-03x-00124	RSRY-708-00312	7
49.88 - 50.93	1.9638 - 2.0051	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00126	RSTO-03x-00126	RSRY-708-00312	7
50.70 - 51.74	1.9961 - 2.0370	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00128	RSTO-03x-00128	RSRY-708-00312	7
51.49 - 52.53	2.0272 - 2.0681	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00130	RSTO-03x-00118	RSRY-708-00406	7
52.27 - 53.32	2.0579 - 2.0992	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00132	RSTO-03x-00120	RSRY-708-00406	7
53.06 - 54.10	2.0890 - 2.1299	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00134	RSTO-03x-00122	RSRY-708-00406	7
53.87 - 54.91	2.1209 - 2.1618	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00136	RSTO-03x-00124	RSRY-708-00406	7
54.66 - 55.71	2.1520 - 2.1933	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00138	RSTO-03x-00126	RSRY-708-00406	7
55.45 - 56.49	2.1831 - 2.2240	RSKO-200-xxxxx	RSKO-100-xxxxx	RSCO-015-00140	RSTO-03x-00128	RSRY-708-00406	7

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

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

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



P

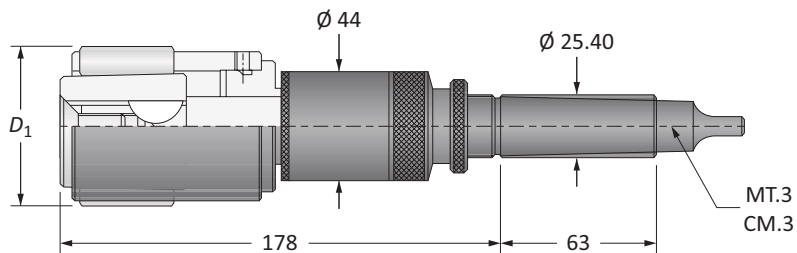

 BURNISHING | S.C.A.M.I.® Roller Burnishing Systems

## Roller Burnishing Tools | Through Holes

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

A

DRILLING

Technical drawing showing dimensions:  $\text{D}_1$ ,  $\text{Ø} 44$ ,  $\text{Ø} 25.40$ , 178, 63, MT.3, CM.3.

B

BORING

### Through Holes

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

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

D

BURNISHING

F

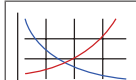
THREADING

X


SPECIALS

Key on D: 1


D: 42 - 45



D: 40 - 41



D: 38



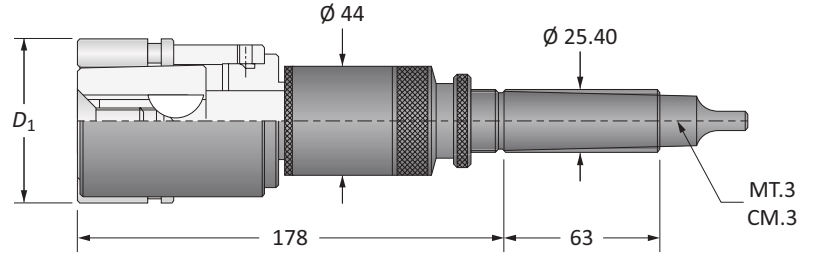
D: 26

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## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	Qty Rolls
56.23 - 57.28	2.2138 - 2.2551	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00142	RSTP-03x-00142	RSRY-708-00406	7
57.05 - 58.09	2.2461 - 2.2870	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00144	RSTP-03x-00144	RSRY-708-00406	7
57.84 - 58.87	2.2772 - 2.3177	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00146	RSTP-03x-00146	RSRY-708-00406	7
58.62 - 59.67	2.3079 - 2.3492	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00148	RSTP-03x-00148	RSRY-708-00406	7
59.41 - 60.45	2.3390 - 2.3799	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00150	RSTP-03x-00142	RSRY-708-00468	7
60.23 - 61.26	2.3713 - 2.4118	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00152	RSTP-03x-00144	RSRY-708-00468	7
61.01 - 62.06	2.4020 - 2.4433	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00154	RSTP-03x-00146	RSRY-708-00468	7
61.80 - 62.84	2.4330 - 2.4740	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00156	RSTP-03x-00148	RSRY-708-00468	7
62.58 - 63.63	2.4638 - 2.5051	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00158	RSTP-03x-00158	RSRY-708-00468	7
63.40 - 64.44	2.4961 - 2.5370	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00160	RSTP-03x-00160	RSRY-708-00468	7
64.19 - 65.22	2.5272 - 2.5677	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00162	RSTP-03x-00162	RSRY-708-00468	7
64.97 - 66.02	2.5579 - 2.5992	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00164	RSTP-03x-00164	RSRY-708-00468	7
65.76 - 66.80	2.5890 - 2.6299	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00166	RSTP-03x-00158	RSRY-708-00531	7
66.58 - 67.61	2.6213 - 2.6618	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00168	RSTP-03x-00160	RSRY-708-00531	7
67.36 - 68.41	2.6520 - 2.6933	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00170	RSTP-03x-00162	RSRY-708-00531	7
68.15 - 69.19	2.6830 - 2.7240	RSKP-200-xxxxx	RSKP-100-xxxxx	RSCP-015-00172	RSTP-03x-00164	RSRY-708-00531	7

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

\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page 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

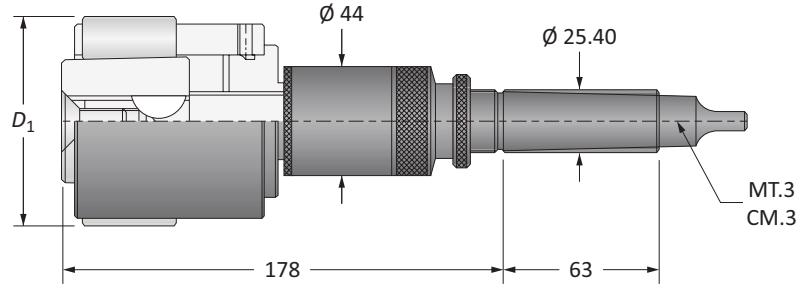
D: 39

Key on D: 1

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

## Roller Burnishing Tools | Through Holes

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



### Through Holes

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

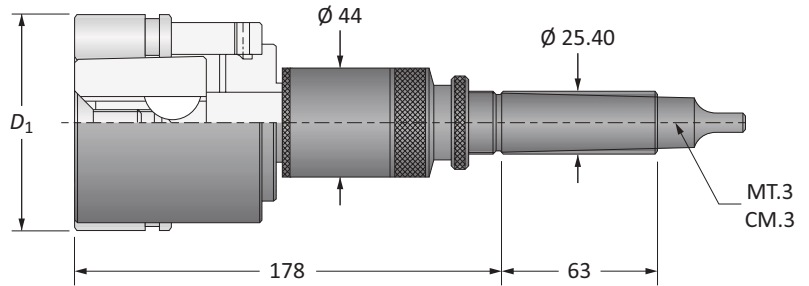
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts			
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	Qty Rolls
68.93 - 69.98	2.7138 - 2.7551	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00174	RSTQ-03x-00174	RSRY-708-00531	7
69.75 - 70.79	2.7461 - 2.7870	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00176	RSTQ-03x-00176	RSRY-708-00531	7
70.54 - 71.57	2.7772 - 2.8177	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00178	RSTQ-03x-00178	RSRY-708-00531	7
71.32 - 72.40	2.8079 - 2.8504	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00180	RSTQ-03x-00180	RSRY-708-00531	7
72.11 - 73.15	2.8390 - 2.8799	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00182	RSTQ-03x-00182	RSRY-708-00531	7
72.93 - 73.96	2.8713 - 2.9118	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00184	RSTQ-03x-00184	RSRY-708-00531	7
73.71 - 74.75	2.9020 - 2.9429	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00186	RSTQ-03x-00174	RSRY-708-00625	7
74.50 - 75.54	2.9331 - 2.9740	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00188	RSTQ-03x-00176	RSRY-708-00625	7
75.28 - 76.33	2.9638 - 3.0051	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00190	RSTQ-03x-00178	RSRY-708-00625	7
76.10 - 77.14	2.9961 - 3.0370	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00192	RSTQ-03x-00180	RSRY-708-00625	7
76.89 - 77.93	3.0272 - 3.0681	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00194	RSTQ-03x-00182	RSRY-708-00625	7
77.67 - 78.72	3.0579 - 3.0992	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00196	RSTQ-03x-00184	RSRY-708-00625	7
78.46 - 79.50	3.0890 - 3.1299	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00198	RSTQ-03x-00198	RSRY-708-00625	7
79.27 - 80.31	3.1209 - 3.1618	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00200	RSTQ-03x-00200	RSRY-708-00625	7
80.06 - 81.11	3.1520 - 3.1933	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00202	RSTQ-03x-00202	RSRY-708-00625	7
80.85 - 81.89	3.1831 - 3.2240	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00204	RSTQ-03x-00204	RSRY-708-00625	7
81.63 - 82.68	3.2138 - 3.2551	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00206	RSTQ-03x-00198	RSRY-708-00687	7
82.45 - 83.49	3.2461 - 3.2870	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00208	RSTQ-03x-00200	RSRY-708-00687	7
83.24 - 84.27	3.2772 - 3.3177	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00210	RSTQ-03x-00202	RSRY-708-00687	7
84.02 - 85.07	3.3079 - 3.3492	RSKQ-200-xxxxx	RSKQ-100-xxxxx	RSCQ-015-00212	RSTQ-03x-00204	RSRY-708-00687	7

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

\*\*x = A number that will vary from 2 to 8 depending upon the exact diameter to be burnished. See page 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

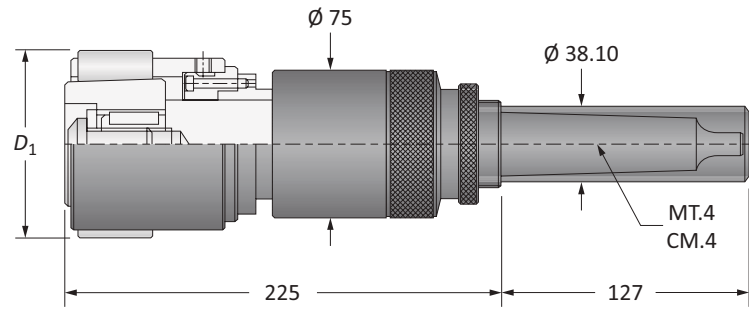
D: 40 - 41

D: 39

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

## Roller Burnishing Tools | Through Holes

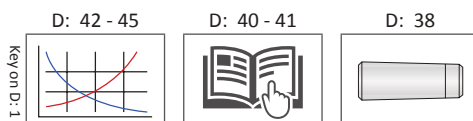
R Series | Diameter Range: 84.81 mm - 104.12 mm (3.3390" - 4.0992")



### Through Holes

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

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

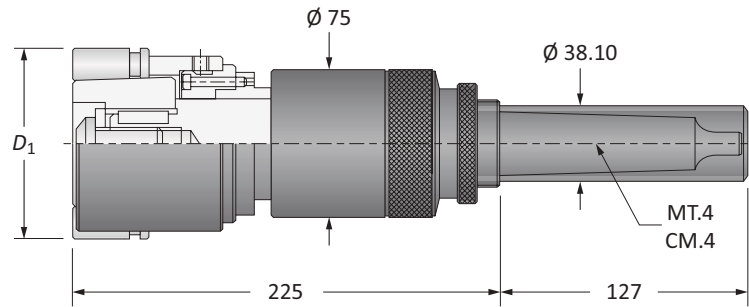


Key on D: 1



## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts				Qty Rolls
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls		
84.81 - 85.85	3.3390 - 3.3799	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00214	RSTR-073-0000x	RSRY-708-00468	9	
85.63 - 86.66	3.3713 - 3.4118	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00216	RSTR-074-0000x	RSRY-708-00468	9	
86.41 - 87.45	3.4020 - 3.4429	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00218	RSTR-071-0000x	RSRY-708-00531	9	
87.20 - 88.24	3.4331 - 3.4740	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00220	RSTR-072-0000x	RSRY-708-00531	9	
87.99 - 89.03	3.4642 - 3.5051	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00222	RSTR-073-0000x	RSRY-708-00531	9	
88.79 - 89.84	3.4957 - 3.5370	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00224	RSTR-074-0000x	RSRY-708-00531	9	
89.59 - 90.63	3.5272 - 3.5681	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00226	RSTR-075-0000x	RSRY-708-00531	9	
90.37 - 91.42	3.5579 - 3.5992	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00228	RSTR-076-0000x	RSRY-708-00531	9	
91.16 - 92.20	3.5890 - 3.6299	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00230	RSTR-071-0000x	RSRY-708-00625	9	
91.97 - 93.02	3.6209 - 3.6622	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00232	RSTR-072-0000x	RSRY-708-00625	9	
92.76 - 93.80	3.6520 - 3.6929	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00234	RSTR-073-0000x	RSRY-708-00625	9	
93.55 - 94.59	3.6831 - 3.7240	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00236	RSTR-074-0000x	RSRY-708-00625	9	
94.34 - 95.38	3.7142 - 3.7551	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00238	RSTR-075-0000x	RSRY-708-00625	9	
95.15 - 96.19	3.7461 - 3.7870	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00240	RSTR-076-0000x	RSRY-708-00625	9	
95.94 - 96.98	3.7772 - 3.8181	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00242	RSTR-077-0000x	RSRY-708-00625	9	
96.72 - 97.77	3.8079 - 3.8492	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00244	RSTR-078-0000x	RSRY-708-00625	9	
97.51 - 98.55	3.8390 - 3.8799	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00246	RSTR-075-0000x	RSRY-708-00687	9	
98.32 - 99.37	3.8709 - 3.9122	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00248	RSTR-076-0000x	RSRY-708-00687	9	
99.11 - 100.15	3.9020 - 3.9429	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00250	RSTR-077-0000x	RSRY-708-00687	9	
99.90 - 100.94	3.9331 - 3.9740	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00252	RSTR-078-0000x	RSRY-708-00687	9	
100.69 - 101.73	3.9642 - 4.0051	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00254	RSTR-079-0000x	RSRY-708-00687	9	
101.50 - 102.54	3.9961 - 4.0370	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00256	RSTR-080-0000x	RSRY-708-00687	9	
102.29 - 103.33	4.0272 - 4.0681	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00258	RSTR-081-0000x	RSRY-708-00687	9	
103.07 - 104.12	4.0579 - 4.0992	RSKR-200-xxxxx	RSKR-100-xxxxx	RSCR-015-00260	RSTR-082-0000x	RSRY-708-00687	9	

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher 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.

Key on D: 1

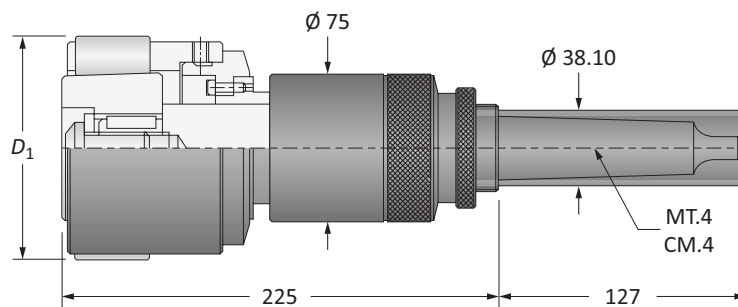
D: 42 - 45

D: 40 - 41

D: 39

## Roller Burnishing Tools | Through Holes

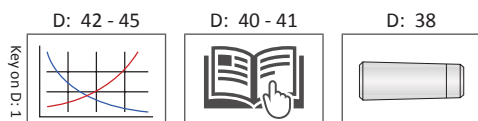
S Series | Diameter Range: 103.86 mm - 127.94 mm (4.0890" - 5.0370")



### Through Holes

D <sub>1</sub>		Part No.		Spare Parts			Qty Rolls
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone	Rolls	
103.86 - 104.90	4.0890 - 4.1299	RDKS-200-10386	RDKS-100-10386	RDCS-011-00262	RDTS-083-00001	RDRY-701-00687	9
104.67 - 105.75	4.1209 - 4.1634	RDKS-200-10467	RDKS-100-10467	RDCS-011-00264	RDTS-084-00001	RDRY-701-00687	9
105.46 - 106.50	4.1520 - 4.1929	RDKS-200-10546	RDKS-100-10546	RDCS-011-00266	RDTS-085-00001	RDRY-701-00687	9
106.25 - 107.29	4.1831 - 4.2240	RDKS-200-10625	RDKS-100-10625	RDCS-011-00268	RDTS-086-00001	RDRY-701-00687	9
107.04 - 108.08	4.2142 - 4.2551	RDKS-200-10704	RDKS-100-10704	RDCS-011-00270	RDTS-087-00001	RDRY-701-00687	9
107.85 - 108.89	4.2461 - 4.2870	RDKS-200-10785	RDKS-100-10785	RDCS-011-00272	RDTS-088-00001	RDRY-701-00687	9
108.64 - 109.68	4.2772 - 4.3181	RDKS-200-10864	RDKS-100-10864	RDCS-011-00274	RDTS-089-00001	RDRY-701-00687	9
109.42 - 110.47	4.3079 - 4.3492	RDKS-200-10942	RDKS-100-10942	RDCS-011-00276	RDTS-090-00001	RDRY-701-00687	9
110.21 - 111.25	4.3390 - 4.3799	RDKS-200-11021	RDKS-100-11021	RDCS-011-00278	RDTS-083-00001	RDRY-701-00812	9
111.02 - 112.07	4.3709 - 4.4122	RDKS-200-11102	RDKS-100-11102	RDCS-011-00280	RDTS-084-00001	RDRY-701-00812	9
111.81 - 112.85	4.4020 - 4.4429	RDKS-200-11181	RDKS-100-11181	RDCS-011-00282	RDTS-085-00001	RDRY-701-00812	9
112.60 - 113.64	4.4331 - 4.4740	RDKS-200-11260	RDKS-100-11260	RDCS-011-00284	RDTS-086-00001	RDRY-701-00812	9
113.34 - 114.43	4.4622 - 4.5051	RDKS-200-11334	RDKS-100-11334	RDCS-011-00286	RDTS-087-00001	RDRY-701-00812	9
114.20 - 115.24	4.4961 - 4.5370	RDKS-200-11420	RDKS-100-11420	RDCS-011-00288	RDTS-088-00001	RDRY-701-00812	9
114.99 - 116.03	4.5272 - 4.5681	RDKS-200-11499	RDKS-100-11499	RDCS-011-00290	RDTS-089-00001	RDRY-701-00812	9
115.77 - 116.82	4.5579 - 4.5992	RDKS-200-11577	RDKS-100-11577	RDCS-011-00292	RDTS-090-00001	RDRY-701-00812	9
116.56 - 117.60	4.5890 - 4.6299	RDKS-200-11656	RDKS-100-11656	RDCS-011-00294	RDTS-091-00001	RDRY-701-00812	9
117.37 - 118.42	4.6209 - 4.6622	RDKS-200-11737	RDKS-100-11737	RDCS-011-00296	RDTS-092-00001	RDRY-701-00812	9
118.16 - 119.20	4.6520 - 4.6929	RDKS-200-11816	RDKS-100-11816	RDCS-011-00298	RDTS-093-00001	RDRY-701-00812	9
118.95 - 119.99	4.6831 - 4.7240	RDKS-200-11895	RDKS-100-11895	RDCS-011-00300	RDTS-094-00001	RDRY-701-00812	9
119.74 - 120.78	4.7142 - 4.7551	RDKS-200-11974	RDKS-100-11974	RDCS-011-00302	RDTS-095-00001	RDRY-701-00812	9
120.55 - 121.59	4.7461 - 4.7870	RDKS-200-12055	RDKS-100-12055	RDCS-011-00304	RDTS-096-00001	RDRY-701-00812	9
121.34 - 122.38	4.7772 - 4.8181	RDKS-200-12134	RDKS-100-12134	RDCS-011-00306	RDTS-097-00001	RDRY-701-00812	9
122.12 - 123.17	4.8079 - 4.8492	RDKS-200-12212	RDKS-100-12212	RDCS-011-00308	RDTS-098-00001	RDRY-701-00812	9
122.91 - 123.95	4.8390 - 4.8799	RDKS-200-12291	RDKS-100-12291	RDCS-011-00310	RDTS-099-00001	RDRY-701-00812	9
123.72 - 124.77	4.8709 - 4.9122	RDKS-200-12372	RDKS-100-12372	RDCS-011-00312	RDTS-100-00001	RDRY-701-00812	9
124.51 - 125.55	4.9020 - 4.9429	RDKS-200-12451	RDKS-100-12451	RDCS-011-01245	RDTS-031-01245	RDRY-701-00812	9
125.30 - 126.34	4.9331 - 4.9740	RDKS-200-12530	RDKS-100-12530	RDCS-011-01255	RDTS-031-01255	RDRY-701-00812	9
126.09 - 127.13	4.9642 - 5.0051	RDKS-200-12609	RDKS-100-12609	RDCS-011-01265	RDTS-031-01265	RDRY-701-00812	9
126.90 - 127.94	4.9961 - 5.0370	RDKS-200-12690	RDKS-100-12690	RDCS-011-01275	RDTS-031-01275	RDRY-701-00812	9

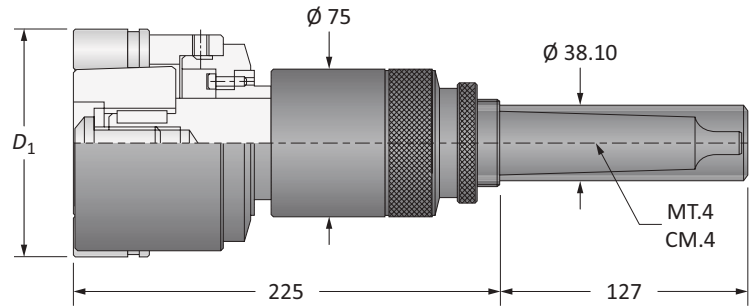
**NOTE:** Each roller burnishing tool comes assembled complete with cage, cone, and rolls.





## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts				Qty Rolls
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls		
103.86 - 104.90	4.0890 - 4.1299	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00262	RSTS-083-0000x	RSRY-708-00687	9	
104.67 - 105.75	4.1209 - 4.1634	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00264	RSTS-084-0000x	RSRY-708-00687	9	
105.46 - 106.50	4.1520 - 4.1929	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00266	RSTS-085-0000x	RSRY-708-00687	9	
106.25 - 107.29	4.1831 - 4.2240	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00268	RSTS-086-0000x	RSRY-708-00687	9	
107.04 - 108.08	4.2142 - 4.2551	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00270	RSTS-087-0000x	RSRY-708-00687	9	
107.85 - 108.89	4.2461 - 4.2870	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00272	RSTS-088-0000x	RSRY-708-00687	9	
108.64 - 109.68	4.2772 - 4.3181	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00274	RSTS-089-0000x	RSRY-708-00687	9	
109.42 - 110.47	4.3079 - 4.3492	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00276	RSTS-090-0000x	RSRY-708-00687	9	
110.21 - 111.25	4.3390 - 4.3799	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00278	RSTS-083-0000x	RSRY-708-00812	9	
111.02 - 112.07	4.3709 - 4.4122	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00280	RSTS-084-0000x	RSRY-708-00812	9	
111.81 - 112.85	4.4020 - 4.4429	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00282	RSTS-085-0000x	RSRY-708-00812	9	
112.60 - 113.64	4.4331 - 4.4740	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00284	RSTS-086-0000x	RSRY-708-00812	9	
113.34 - 114.43	4.4622 - 4.5051	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00286	RSTS-087-0000x	RSRY-708-00812	9	
114.20 - 115.24	4.4961 - 4.5370	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00288	RSTS-088-0000x	RSRY-708-00812	9	
114.99 - 116.03	4.5272 - 4.5681	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00290	RSTS-089-0000x	RSRY-708-00812	9	
115.77 - 116.82	4.5579 - 4.5992	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00292	RSTS-090-0000x	RSRY-708-00812	9	
116.56 - 117.60	4.5890 - 4.6299	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00294	RSTS-091-0000x	RSRY-708-00812	9	
117.37 - 118.42	4.6209 - 4.6622	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00296	RSTS-092-0000x	RSRY-708-00812	9	
118.16 - 119.20	4.6520 - 4.6929	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00298	RSTS-093-0000x	RSRY-708-00812	9	
118.95 - 119.99	4.6831 - 4.7240	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00300	RSTS-094-0000x	RSRY-708-00812	9	
119.74 - 120.78	4.7142 - 4.7551	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00302	RSTS-095-0000x	RSRY-708-00812	9	
120.55 - 121.59	4.7461 - 4.7870	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00304	RSTS-096-0000x	RSRY-708-00812	9	
121.34 - 122.38	4.7772 - 4.8181	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00306	RSTS-097-0000x	RSRY-708-00812	9	
122.12 - 123.17	4.8079 - 4.8492	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00308	RSTS-098-0000x	RSRY-708-00812	9	
122.91 - 123.95	4.8390 - 4.8799	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00310	RSTS-099-0000x	RSRY-708-00812	9	
123.72 - 124.77	4.8709 - 4.9122	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-00312	RSTS-100-0000x	RSRY-708-00812	9	
124.51 - 125.55	4.9020 - 4.9429	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01245	RSTS-03x-01245	RSRY-708-00812	9	
125.30 - 126.34	4.9331 - 4.9740	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01255	RSTS-03x-01255	RSRY-708-00812	9	
126.09 - 127.13	4.9642 - 5.0051	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01265	RSTS-03x-01265	RSRY-708-00812	9	
126.90 - 127.94	4.9961 - 5.0370	RSKS-200-xxxxx	RSKS-100-xxxxx	RSCS-015-01275	RSTS-03x-01275	RSRY-708-00812	9	

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

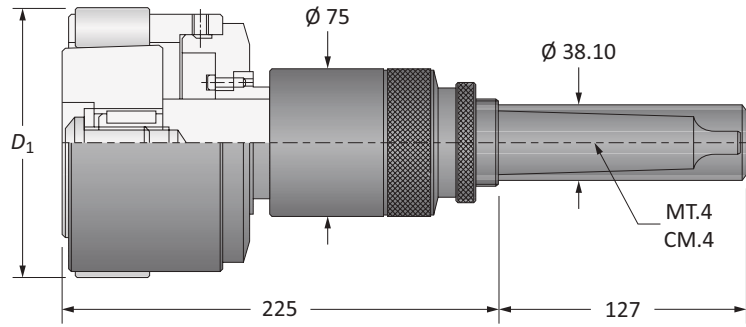
D: 39

Key on D: 1

**Roller Burnishing Tools | Through Holes**

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

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



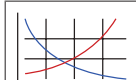
**Through Holes**

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


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

Key on D: 1


D: 42 - 45



D: 40 - 41



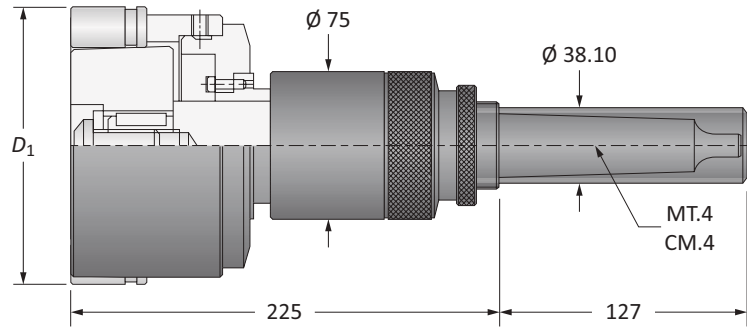
D: 38





## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts			Qty Rolls
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	
127.90 - 128.90	5.0354 - 5.0748	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01280	RSTT-0xx-01280	RSRY-708-00812	11
128.90 - 129.90	5.0748 - 5.1142	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01290	RSTT-0xx-01290	RSRY-708-00812	11
129.90 - 130.90	5.1142 - 5.1535	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01300	RSTT-0xx-01300	RSRY-708-00812	11
130.90 - 131.90	5.1535 - 5.1929	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01310	RSTT-0xx-01310	RSRY-708-00812	11
131.90 - 132.90	5.1929 - 5.2323	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01320	RSTT-0xx-01320	RSRY-708-00812	11
132.90 - 133.90	5.2323 - 5.2717	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01330	RSTT-0xx-01330	RSRY-708-00812	11
133.90 - 134.90	5.2717 - 5.3110	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01340	RSTT-0xx-01340	RSRY-708-00812	11
134.90 - 135.90	5.3110 - 5.3504	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01350	RSTT-0xx-01350	RSRY-708-00812	11
135.90 - 136.90	5.3504 - 5.3898	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01360	RSTT-0xx-01360	RSRY-708-00812	11
136.90 - 137.90	5.3898 - 5.4291	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01370	RSTT-0xx-01370	RSRY-708-00812	11
137.90 - 138.90	5.4291 - 5.4685	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01380	RSTT-0xx-01380	RSRY-708-00812	11
138.90 - 139.90	5.4685 - 5.5079	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01390	RSTT-0xx-01390	RSRY-708-00812	11
139.90 - 140.90	5.5079 - 5.5472	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01400	RSTT-0xx-01400	RSRY-708-00812	11
140.90 - 141.90	5.5472 - 5.5866	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01410	RSTT-0xx-01410	RSRY-708-00812	11
141.60 - 142.90	5.5866 - 5.6260	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01420	RSTT-0xx-01420	RSRY-708-00812	11
142.90 - 143.90	5.6260 - 5.6654	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01430	RSTT-0xx-01430	RSRY-708-00812	11
143.90 - 144.90	5.6654 - 5.7047	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01440	RSTT-0xx-01440	RSRY-708-00812	11
144.90 - 145.90	5.7047 - 5.7441	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01450	RSTT-0xx-01450	RSRY-708-00812	11
145.90 - 146.90	5.7441 - 5.7835	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01460	RSTT-0xx-01460	RSRY-708-00812	11
146.90 - 147.90	5.7835 - 5.8228	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01470	RSTT-0xx-01470	RSRY-708-00812	11
147.90 - 148.90	5.8228 - 5.8622	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01480	RSTT-0xx-01480	RSRY-708-00812	11
148.90 - 149.90	5.8622 - 5.9016	RSKT-200-xxxxx	RSKT-100-xxxxx	RSCT-015-01490	RSTT-0xx-01490	RSRY-708-00812	11

\*xxxxx = Indicate to 2 metric decimal places the size to be burnished (e.g. roller burnisher 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.

Key on D: 1

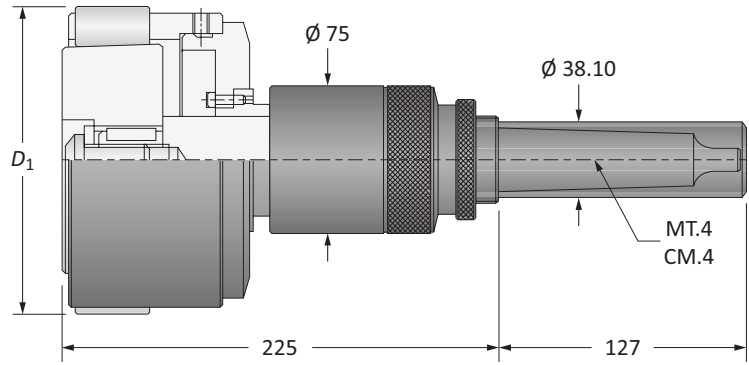
D: 42 - 45

D: 40 - 41

D: 39

## Roller Burnishing Tools | Through Holes

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



### Through Holes

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

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

Key on D: 1

D: 42 - 45

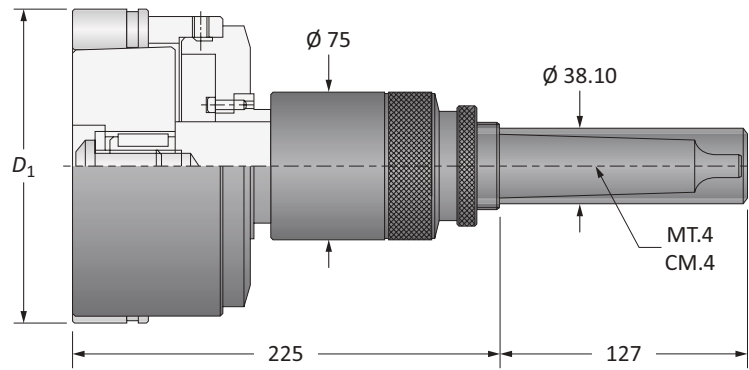
D: 40 - 41

D: 38



## Roller Burnishing Tools | Blind Holes

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



### Blind Holes

D <sub>1</sub>		Part No.*		Spare Parts			Qty Rolls
Metric (mm)	Imperial (in)	Assembly with Morse Taper Shank	Assembly with Straight Shank	Cage	Cone**	Rolls	
149.90 - 150.90	5.9016 - 5.9409	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01500	RSTU-0xx-01500	RSRY-708-00812	13
150.90 - 151.90	5.9409 - 5.9803	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01510	RSTU-0xx-01510	RSRY-708-00812	13
151.90 - 152.90	5.9803 - 6.0197	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01520	RSTU-0xx-01520	RSRY-708-00812	13
152.90 - 153.90	6.0197 - 6.0591	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01530	RSTU-0xx-01530	RSRY-708-00812	13
153.90 - 154.90	6.0591 - 6.0984	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01540	RSTU-0xx-01540	RSRY-708-00812	13
154.90 - 155.90	6.0984 - 6.1378	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01550	RSTU-0xx-01550	RSRY-708-00812	13
155.90 - 156.90	6.1378 - 6.1772	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01560	RSTU-0xx-01560	RSRY-708-00812	13
156.90 - 157.90	6.1772 - 6.2165	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01570	RSTU-0xx-01570	RSRY-708-00812	13
157.90 - 158.90	6.2165 - 6.2559	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01580	RSTU-0xx-01580	RSRY-708-00812	13
158.90 - 159.90	6.2559 - 6.2953	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01590	RSTU-0xx-01590	RSRY-708-00812	13
159.90 - 160.90	6.2953 - 6.3346	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01600	RSTU-0xx-01600	RSRY-708-00812	13
160.90 - 161.90	6.3346 - 6.3740	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01610	RSTU-0xx-01610	RSRY-708-00812	13
161.90 - 162.90	6.3740 - 6.4134	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01620	RSTU-0xx-01620	RSRY-708-00812	13
162.90 - 163.90	6.4134 - 6.4528	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01630	RSTU-0xx-01630	RSRY-708-00812	13
163.90 - 164.90	6.4528 - 6.4921	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01640	RSTU-0xx-01640	RSRY-708-00812	13
164.90 - 165.90	6.4921 - 6.5315	RSKU-200-xxxxx	RSKU-100-xxxxx	RSCU-015-01650	RSTU-0xx-01650	RSRY-708-00812	13

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

Key on D: 1

D: 42 - 45

D: 40 - 41

D: 39

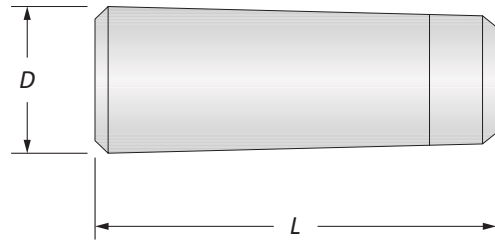
U  
 A DRILLING  
 B BORING  
 C REAMING  
 D BURNISHING  
 E THREADING  
 X SPECIALS

## Rolls

### Through Holes

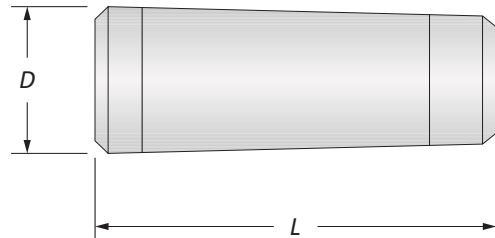
#### Rolls 704 and 707

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



#### Rolls 701

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



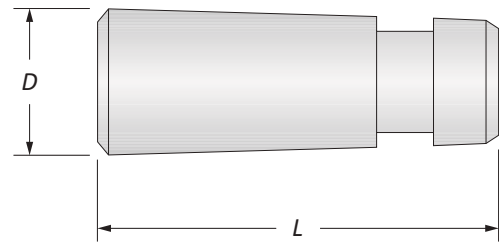
A DRILLING  
B BORING  
C REAMING  
D BURNISHING  
E THREADING  
X SPECIALS

## Rolls

### Blind Holes

#### Rolls 708

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



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

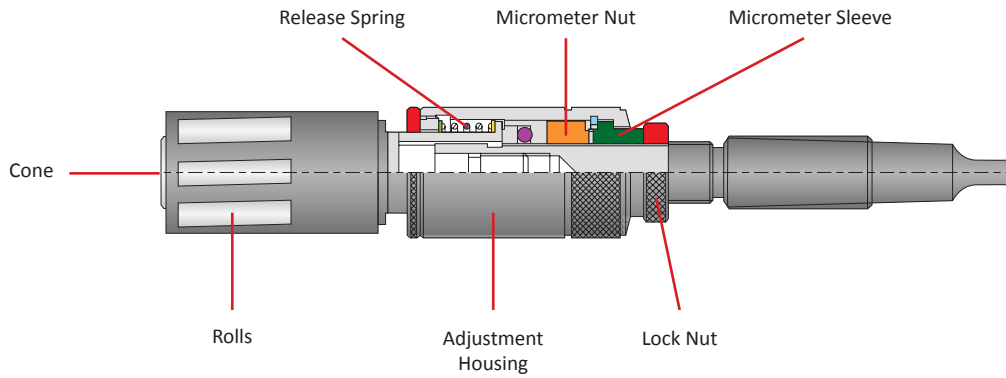
E

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

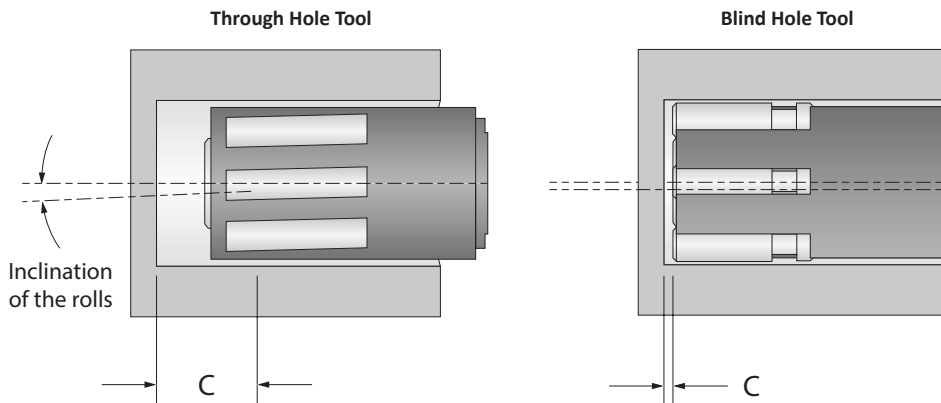


Figure 2

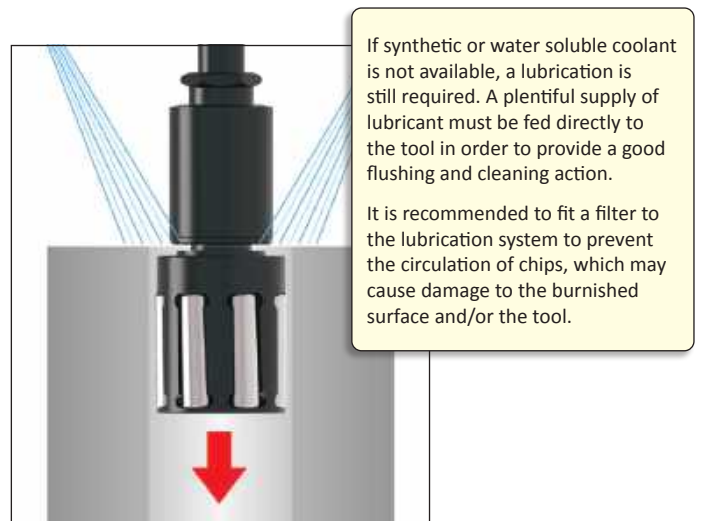
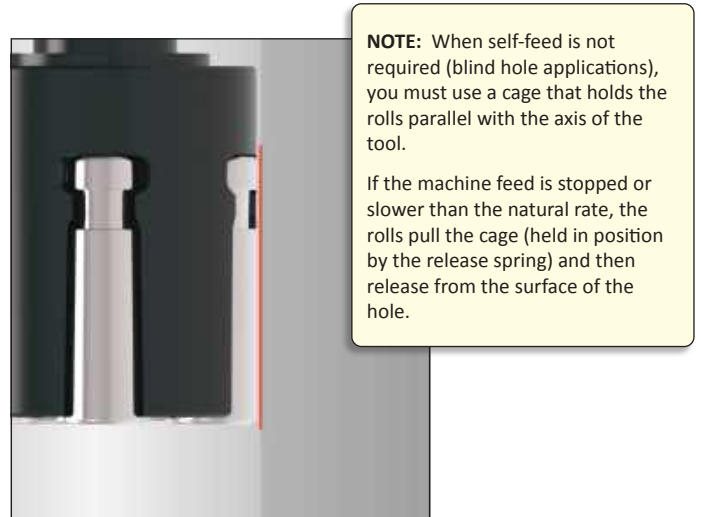
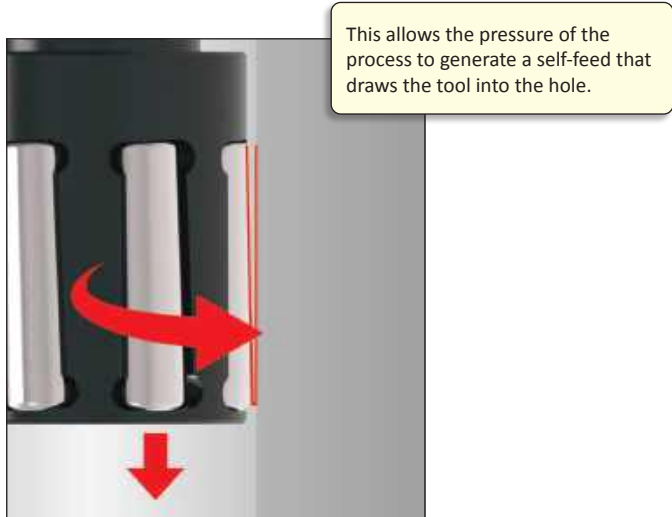
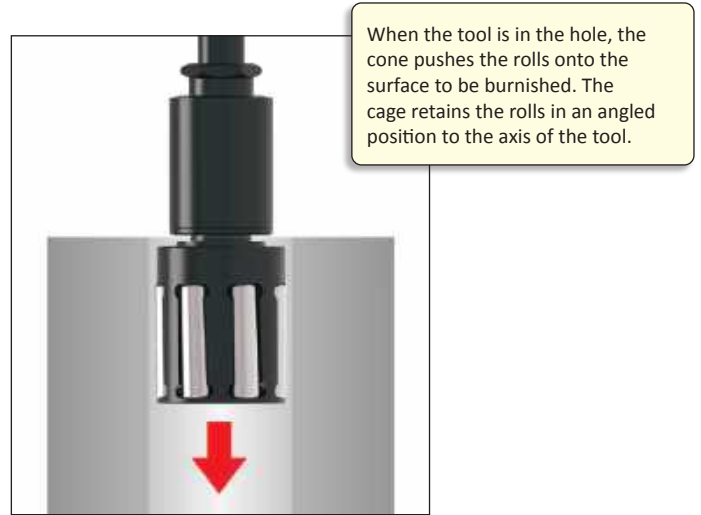


Larger Diameter = Extruded Cone = Decreased Clearance

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

## How it Works

### Roller Burnishing Tools





## 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	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 250	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 275	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, 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
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		180 - 375	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Structural Steel A36, A285, A516, etc.	125 - 180	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	180 - 350	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07	
	200 - 250	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07	
S	High-Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	15 - 45	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Titanium Alloy	140 - 310	15 - 45	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
M	Stainless Steel 400 Series 416, 420, etc.	135 - 350	22 - 60	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	22 - 60	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
K	Grey Cast Iron, Ductile Iron, Spheroidal Cast Iron (Pearlitic)	< 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
		> 200	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Spheroidal Cast Iron (Ferritic)	260 - 320	22 - 90	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
N	Copper and Alloys Brass	< 500	45 - 105	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Bronze	< 180	45 - 105	0.13 - 0.51	0.36 - 0.94	0.81 - 2.18	1.78 - 3.07
	Bronze Phosphorous						
	Aluminium and Alloys	< 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

**IMPORTANT:** The speeds and feeds listed on these pages are a general starting point for all applications. Factory technical assistance is also available for specific applications through our Application Engineering department. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

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

\*Stock value is on diameter.

**IMPORTANT:** The speeds and feeds listed on these pages are a general starting point for all applications. Factory technical assistance is also available for specific applications through our Application Engineering department. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

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



## 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 1118, 1215, 12L14, etc.	100 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 250	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 275	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, 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 4140, 5140, 8640, etc.	125 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 375	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Structural Steel A36, A285, A516, etc.	125 - 180	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		180 - 350	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Tool Steel H-13, H-21, A-4, 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 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 416, 420, etc.	135 - 350	75 - 200	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	75 - 200	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
K	Grey Cast Iron, Ductile Iron, Spheroidal Cast Iron (Pearlitic)	< 200	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
		> 200	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
	Spheroidal Cast Iron (Ferritic)	260 - 320	75 - 300	0.005 - 0.020	0.014 - 0.037	0.032 - 0.086	0.070 - 0.121
N	Copper and Alloys Brass	< 500	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						
	Aluminium 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	Free-Machining Steel 1118, 1215, 12L14, etc.	100 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 250	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Low-Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 275	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Medium-Carbon Steel 1030, 1040, 1050, 1527, 1140, 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
	Alloy Steel 4140, 5140, 8640, etc.	125 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
		180 - 375	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	High-Strength Alloy 4340, 4330V, 300M, etc.	240 - 450	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Structural Steel A36, A285, A516, etc.	125 - 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	180 - 350	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014	
Tool Steel H-13, H-21, A-4, 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	High-Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Titanium Alloy	140 - 310	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
M	Stainless Steel 400 Series 416, 420, etc.	135 - 350	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
K	Grey Cast Iron, Ductile Iron, Spheroidal Cast Iron (Pearlitic)	< 200	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
		> 200	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
	Spheroidal Cast Iron (Ferritic)	260 - 320	0.0004 - 0.0007	0.0005 - 0.0007	0.0005 - 0.0010	0.0008 - 0.0014
N	Copper and Alloys Brass	< 500	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Bronze Bronze Phosphorous	< 180	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020
	Aluminium and Alloys	< 150	0.0004 - 0.0007	0.0007 - 0.0016	0.0010 - 0.0018	0.0012 - 0.0020

\*Stock value is on diameter.

**IMPORTANT:** The speeds and feeds listed on these pages are a general starting point for all applications. Factory technical assistance is also available for specific applications through our Application Engineering department. *email: [engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)*

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

# Boring, Reaming & Roller Burnishing Guaranteed Application Form

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

## CONTACT DETAILS

Trial P.O. No.\* ..... Date\* ..... Proposed Test Date\* .....  
 Favoured Distributor\* ..... Distributor Contact\* .....  
 Customer Name\* ..... Industry ..... Contact Name\* .....

**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: _____ mm/in	Tolerance: _____	Material: _____ (4150, A36, cast iron, etc.)
Pre-existing Diameter: _____ mm/in	Depth of Cut: _____ mm/in	Hardness: _____ (Rc, BHN, Kg)
Required Finish: _____ μm	<input type="checkbox"/> Blind <input type="checkbox"/> Through Hole	State: _____ (Casting, hot rolled, forging)

## MACHINE INFORMATION

Machine Type: _____ (Lathe, screw machine, machine center, etc.)	Builder: _____ (Haas, Mori Seiki, etc.)	Model #: _____
Shank Required: _____ (DIN50, Morse taper, etc.)		Power: _____ KW/HP
Rigidity: <input type="checkbox"/> Excellent <input type="checkbox"/> Good <input type="checkbox"/> Poor	Orientation: <input type="checkbox"/> Vertical <input type="checkbox"/> Horizontal	Tool Rotating: <input type="checkbox"/> Yes <input type="checkbox"/> No
		Thrust: _____ kN
		Max RPM: _____ RPM

## COOLANT INFORMATION

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

## REQUESTED TOOLING

QTY	Item Number

QTY	Item Number

QTY	Item Number

### FOR OFFICE USE ONLY

Application Engineer:

Number:

Status:

[engineering.eu@alliedmachine.com](mailto:engineering.eu@alliedmachine.com)

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**ALLIED MACHINE  
& ENGINEERING**

**WOHLHAUPTER®**

Holemaking Solutions for Today's Manufacturing

## Warranty Information



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AMPC-D\_EU-EN  
Publish Date: May 2025