

Roller burnishing tools

For outside roller burnishing of parts for power steering.

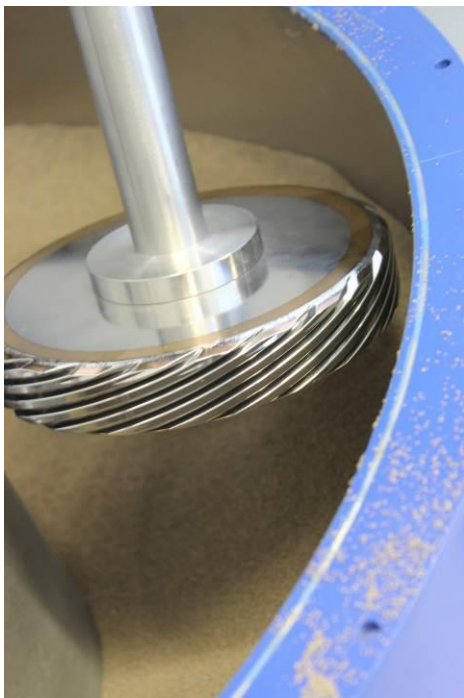
Task (a)

Burnishing / smoothing of functional surfaces to improve the surface of the final products.

Process

Angle B: 17°
Total travel: 150mm
Media: H4/400
Process time: 20 min.

Angle C: 18°
Speed of holders: 4 rpm
Speed of process container: 100 rpm



Work piece during process



Result



Ra before processing: 0.37µm
Ra after processing: 0.12-0.16µm
(Measurement done by customer)

Processing resulted in a visibly improved surface of the customer's spindles.

Task (b)

Polishing (droplet removal) after coating

Process

Angle B:	17°	Angle C:	18°
Total travel:	150mm	Speed of holders:	4 rpm
Media:	H4/400	Speed of process container:	100 rpm
Process time:	5 min.		

After processing



Before processing

By polishing after coating, an even better surface quality at the final products (spindles) will be achieved.