



COGSDILL TOOL

products, inc.

APPLICATION *news*

DATE May 26, 2005

NUMBER CAN2-05

FOR MORE INFORMATION CONTACT
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Universal™ Burnishing Tool Offers Versatility to Burnish Multiple O.D. Surfaces

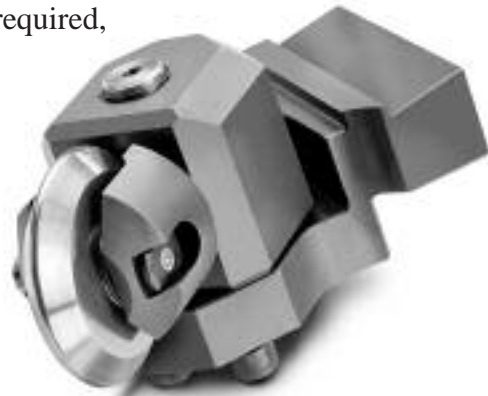
Achieves finish better than required, with faster production

A JOB SHOP WAS SEEKING A BETTER FINISHING SOLUTION for their cylinder sleeves. They were using a finishing insert fed at the slow rate of .002 IPR (0.05mm/rev), followed by a polishing process, in order to achieve a finish requirement of 16 microinch (0.4 micrometer) Ra or better.

Cogsdill recommended burnishing as a faster and more effective way to obtain the required finish. The customer had a number of different piece parts within a family of parts; the use of standard O.D. burnishing tools would be costly. They wanted to burnish all of them with one tool. Cogsdill had the solution: the UBT-T Universal™ burnishing tool. This versatile tool can burnish shafts, faces, tapers, contours, and large I.D.s. It is offered in right-hand and left-hand models, with adjustable roll orientation.

The customer achieved finishes better than required, while reducing their production time and associated costs.

Refer to our catalog on “Burnishing Tools and Machines” for more information on our complete line of tools for roller burnishing, diamond burnishing, and single-roll burnishing, and machines for burnishing external cylindrical surfaces of any length.



UBT-T indexable turning holder-style burnishing tool
(Left-hand tool shown)

— See reverse side for machining data —

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Machining data

Machine type: CNC lathe

Material: Steel (1144)

Spindle speed: 1637 RPM

Feed rate: .004 IPR (0.10mm/rev)

Cycle time: 1 minute, 22 seconds

Coolant: Water soluble

Size required: 1.750 in. (44.45mm)

Size achieved: As required

Finish required: 16 microinches (0.4 micrometer) Ra or better

Finish achieved: 8 to 10 microinches (0.2 to 0.25 micrometers) Ra or better