



**FORGET ABOUT  
SECONDARY OPS.**

**Roll to the finish with  
carbide roll tools for both  
ID and OD surfaces.**

# ID/OD CARBIDE ROLL BURNISHING TOOLS

CRB

Transform your turning center into a fine finishing machine.

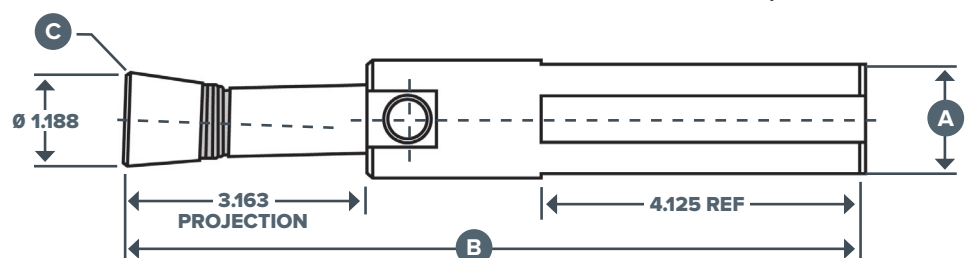


ID/OD BURNISHING

THE BORING BAR STYLE ID/OD TOOL IS USED ON TURNING MACHINES TO BURNISH INTERNAL AND EXTERNAL SURFACES, CREATING EXTREMELY FINE FINISHES IN MOST FERROUS AND NON-FERROUS MATERIALS.

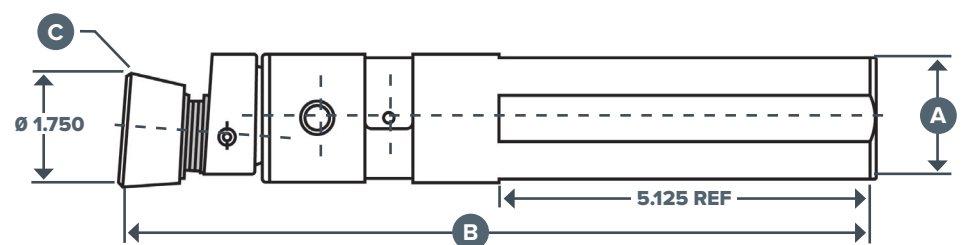
## S2289-00

Designed for burnishing parts with a bore diameter between 1.375" – 2.500" and to a depth of 3.000".



## S2320-00

Designed for burnishing parts with a bore diameter 2.375" and larger and to a depth of 8.000".





## STANDARD DIMENSIONS

	A	B	--	C
Tool Number	Shank Size	OAL	Effective Reach	Roll Radius
S2289-00	1.500"	9.500" (241.300mm)	3.100" (78.740mm)	0.032" (0.787mm)
S2289-00M	40mm	9.500" (241.300mm)	3.100" (78.740mm)	0.032" (0.787mm)
S2289A00	1.500"	9.500" (241.300mm)	3.100" (78.740mm)	0.093" (2.360mm)
S2289A00M	40mm	9.500" (241.300mm)	3.100" (78.740mm)	0.093" (2.360mm)
S2289B00	1.500"	9.500" (241.300mm)	3.100" (78.740mm)	0.062" (1.570mm)
S2289B00M	40mm	9.500" (241.300mm)	3.100" (78.740mm)	0.062" (1.570mm)
S2320-00	2.000"	12.000" (304.800mm)	6.000" (152.400mm)	0.032" (0.787mm)
S2320-00M	50mm	12.000" (304.800mm)	6.000" (152.400mm)	0.032" (0.787mm)
S2340-00	2.000"	12.000" (304.800mm)	6.000" (152.400mm)	0.093" (2.360mm)
S2340-00M	50mm	12.000" (304.800mm)	6.000" (152.400mm)	0.093" (2.360mm)
CB127-00	2.000"	12.000" (304.800mm)	6.000" (152.400mm)	0.062" (1.570mm)
CB127-00M	50mm	12.000" (304.800mm)	6.000" (152.400mm)	0.062" (1.570mm)
S2320A00	2.000"	18.000" (457.200mm)	12.000" (304.800mm)	0.032" (0.787mm)
S2320A00M	50mm	18.000" (457.200mm)	12.000" (304.800mm)	0.032" (0.787mm)
CB168-00	2.000"	18.000" (457.200mm)	12.000" (304.800mm)	0.062" (1.570mm)
CD168-00M	50mm	18.000" (457.200mm)	12.000" (304.800mm)	0.062" (1.570mm)
S2340A00	2.000"	18.000" (457.200mm)	12.000" (304.800mm)	0.093" (2.360mm)
S2340A00M	50mm	18.000" (457.200mm)	12.000" (304.800mm)	0.093" (2.360mm)

# ID/OD BURNISHING TOOLS

## OPERATING PROCEDURE

**PART PREPARATION:**

100/120 RMS

**FEED RATE:**

0.004"/0.008"

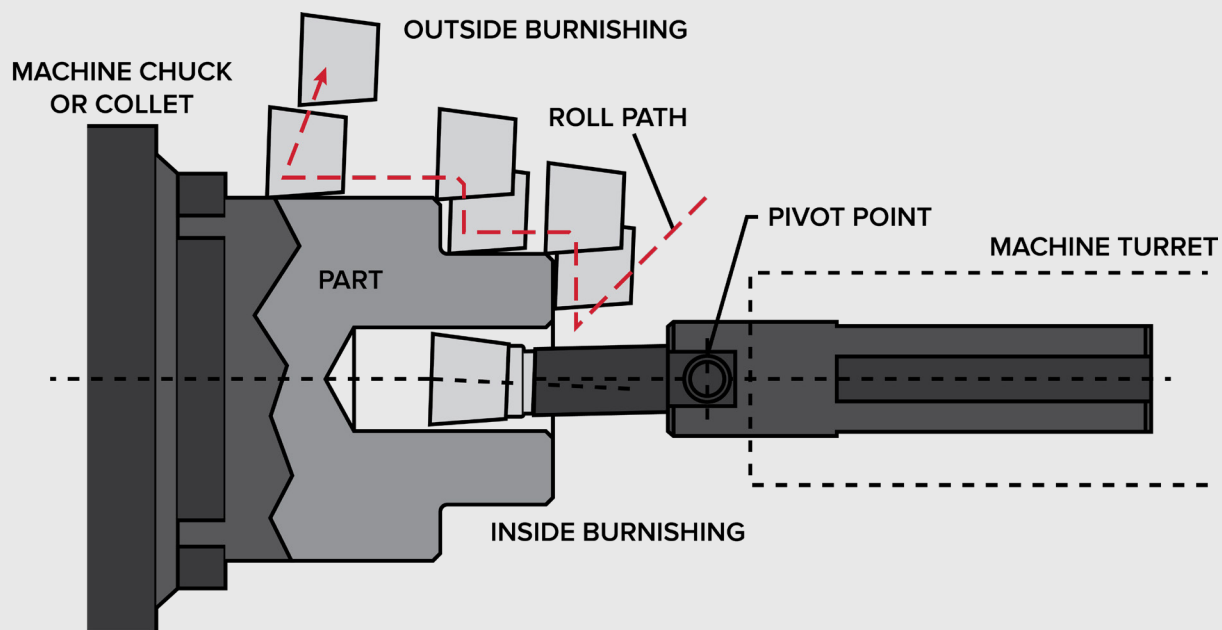
**SPEED:**

400 to 800 surface ft per min.  
(1200 Max)

**COOLANT REQUIRED:**

Water soluble or oil

Ensure bearings are sufficiently greased at all times.



# ID/OD BURNISHING APPLICATION

**Eliminate** grinding & polishing...

## THE JOB

**Part Material:**  
Stainless Steel

**Diameter:** 2.500"

**Length:** 1.500"

**Stock Allowance:**  
0.0005"/0.0010"

**Pre Burnish Surface  
Finish:**  
90 R<sub>a</sub>

## THE SOLUTION

**Tool Used:**  
S2320-00

**Speed:**  
400 SFM (611 RPM)

**Feed:**  
0.006" IPR

## THE RESULTS



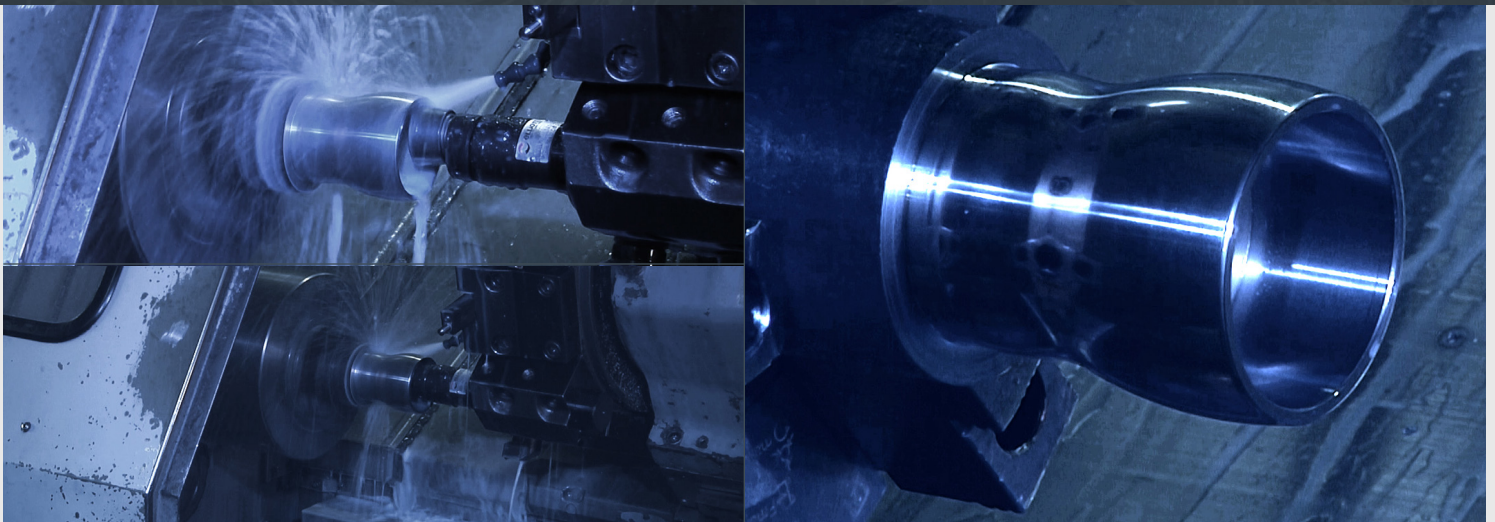
**Post Burnish  
Surface Finish:**

**6μR<sub>a</sub>**



**Cycle Time:**

**24.54SEC.**



...of **both ID & OD** surfaces.