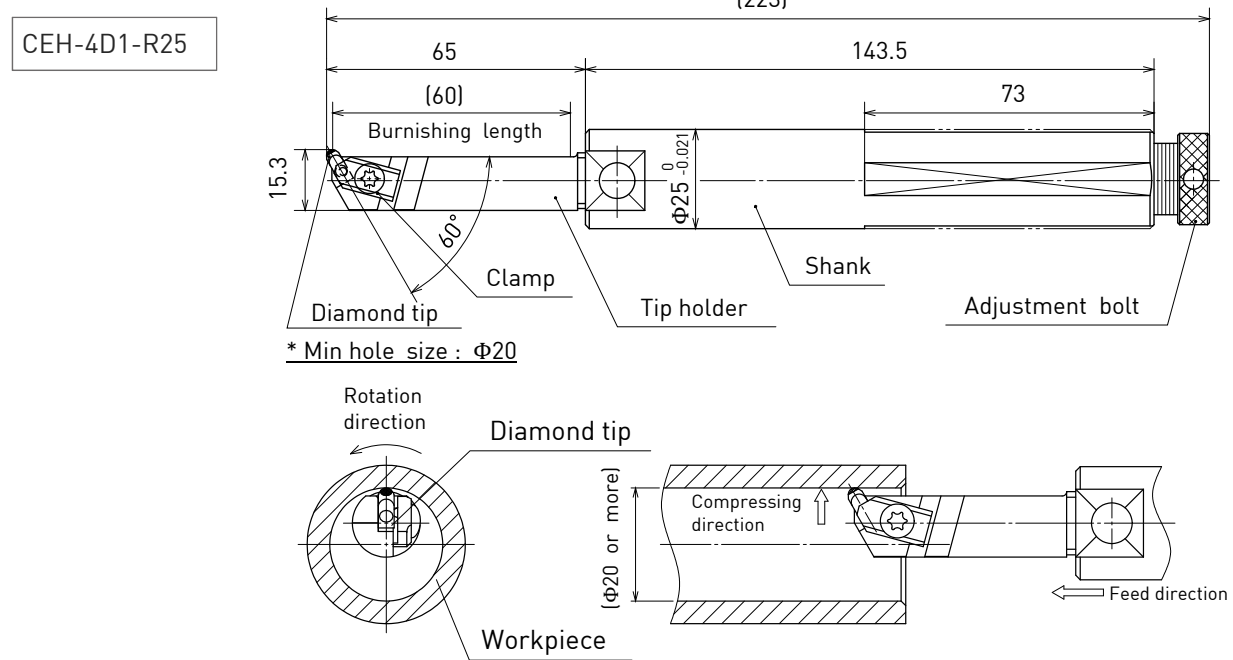


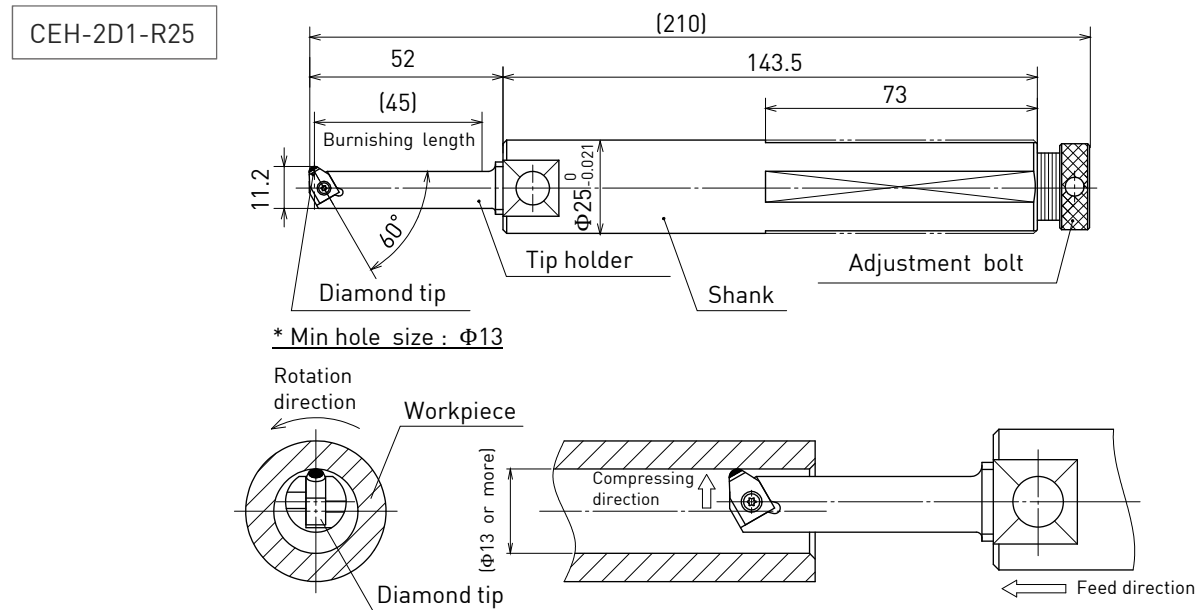
Diamond-tool Type

CAT'S EYE CEH Dimensional specification

Dimensional drawing (mm)



* Please set rotation direction of workpiece as shown in above figure.
(If using with reversed rotation, diamond tip may be come off.)



* Please set rotation direction of workpiece as shown in above figure.
(If using with reversed rotation, diamond tip may be come off.)

Tool specification

Tool model	Burnishing part	Min hole size (mm)	Shank size (mm)	Max burnishing length(mm)	Diamond tip model
CEH -4D1-R25	Inner surface	$\phi 20$	$\phi 25$	60	DT4D1
CEH -2D1-R25		$\phi 13$		45	DT2D1

Burnishing condition (Reference)

Tool model	Workpiece hardness (HRC)	Material	Peripheral speed (m/min)	Feed rate (mm/rev)	Pre-load (N)	Spring
CEH -4D1-R25	45	Alloy steel	50 - 200	0.05	170 - 280	Coil spring
	60				850 - 1100	Belleville spring
CEH -2D1-R25	45				140 - 230	Coil spring
	60				690 - 920	Belleville spring

* Burnishing conditions are reference only, and do not guarantee that they will achieve the customers' required values.

* Actual burnishing conditions vary depending on the material and conditions before burnishing, so these values should be used as a reference.