

Superoll SH · SB Burnishing conditions

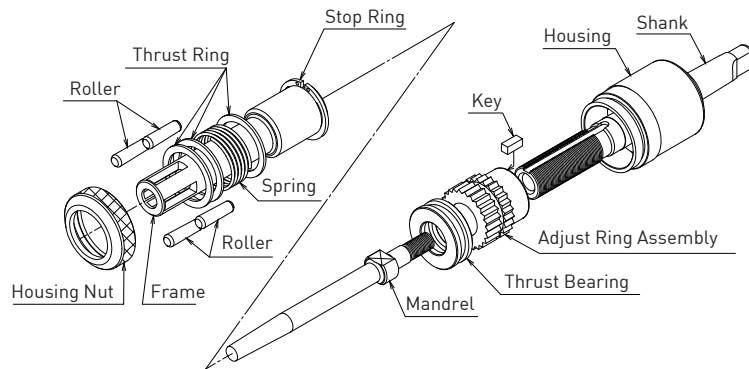
Burnishing conditions chart (Reference)

Hole diameter (mm)	Rotation speed (min ⁻¹)	Feed rate (mm/rev)	Burnishing value (μm)	Torque (N·m)	Thrust (kN)
4.5 - 7.6	900 - 1,800	0.1 - 0.3	Steel : 10 - 30 Aluminum : 10 - 20	0.3 - 2.5	0.1 - 0.8
8 - 14.5	800 - 1,200	0.1 - 0.4	Steel : 20 - 40 Aluminum : 15 - 30	0.5 - 5	0.2 - 1.8
15 - 19	700 - 1,000	0.2 - 0.5	Steel : 20 - 40 Aluminum : 15 - 30	1 - 8	1 - 2.4
20 - 24	600 - 800	0.3 - 0.6	Steel : 20 - 40 Aluminum : 15 - 30	1.5 - 12	0.6 - 3
25 - 44	500 - 700	0.3 - 1.0	Steel : 30 - 60 Aluminum : 20 - 40	2.5 - 25	1 - 8
45 - 74	300 - 500	0.5 - 1.5	Steel : 30 - 70 Aluminum : 20 - 50	5 - 50	2 - 12
75 - 99	200 - 350	0.6 - 1.8	Steel : 40 - 80 Aluminum : 30 - 70	9 - 80	3 - 15
100 - 139	100 - 250	0.8 - 2.5	Steel : 50 - 100 Aluminum : 40 - 80	18 - 140	4.5 - 25
140 - 200	80 - 150	1.2 - 3.0	Steel : 50 - 100 Aluminum : 50 - 90	30 - 250	6 - 35

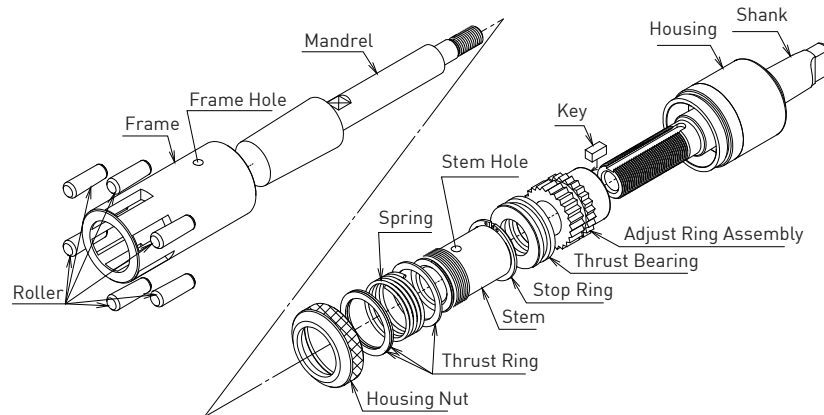
* Burnishing conditions are reference only, and do not guarantee that they will achieve the customers' required values.
* Actual burnishing conditions vary depending on the material and conditions before burnishing, so these values should be used as a reference.

Parts name

SH (SB) 1450 or less



SH (SB) 1500 - 3400



SH (SB) 3500 or more

