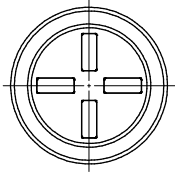


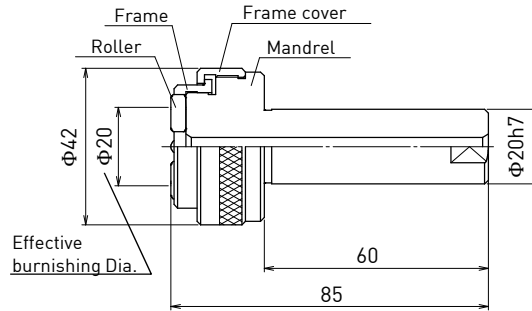
Superoll SFP selection chart

Dimensional drawing (mm)

[SFP20-S20]

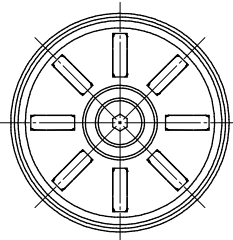


Number of Rollers:4

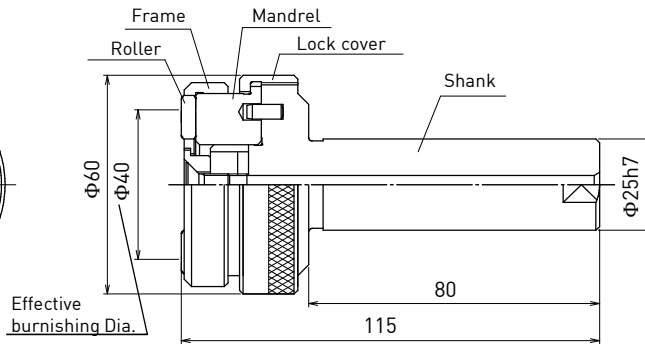


Part Name	Part No.
Rollers (one set of 4)	SFP20S20R
Mandrel	SFP20S20M

[SFP40-S25]

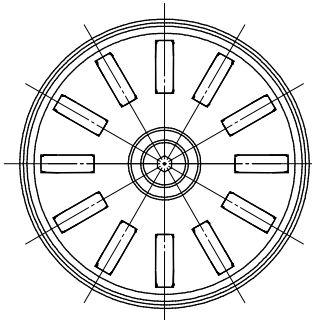


Number of Rollers:8

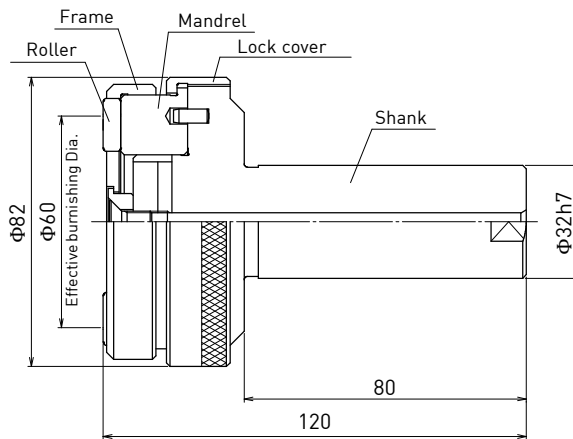


Part Name	Part No.
Rollers (one set of 8)	SFP40S25R
Mandrel	SFP40S25M

[SFP60-S32]



Number of Rollers:12



Part Name	Part No.
Rollers (one set of 12)	SFP60S32R
Mandrel	SFP60S32M

How to use Superoll SFP

- (1) Attach Superoll SFP to a driving unit such as machining center or milling center.
- (2) Set the Z axis of the driving unit correctly so that the amount of rollers compression is appropriate.
- (3) In the same way as face milling, move Superoll SFP horizontally while rotating it to press a workpiece surface.

[Precautions]

- Ensure that a workpiece flatness is within 0.02 mm before burnishing with Superoll SFP.
- Burnishing is available within the range of Effective burnishing diameter.
(Burnishing is not available on the outer side of the Effective burnishing diameter)

Burnishing conditions (Reference)

Tool model	Rotation speed (min ⁻¹)	Feed rate (mm/rev)	Compression (mm)	Required Thrust (N)	Weight (kg)
SFP20-S20	900-3,000	0.1-0.5	0.02-0.04	3,000	0.4
SFP40-S25	500-1,600	0.2-0.7	0.02-0.05	6,000	1.0
SFP60-S32	300-1,000	0.3-1.4	0.02-0.05	8,000	2.0

- * 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.
- * Please check the allowable tool weight for your driving machine before using the tool.