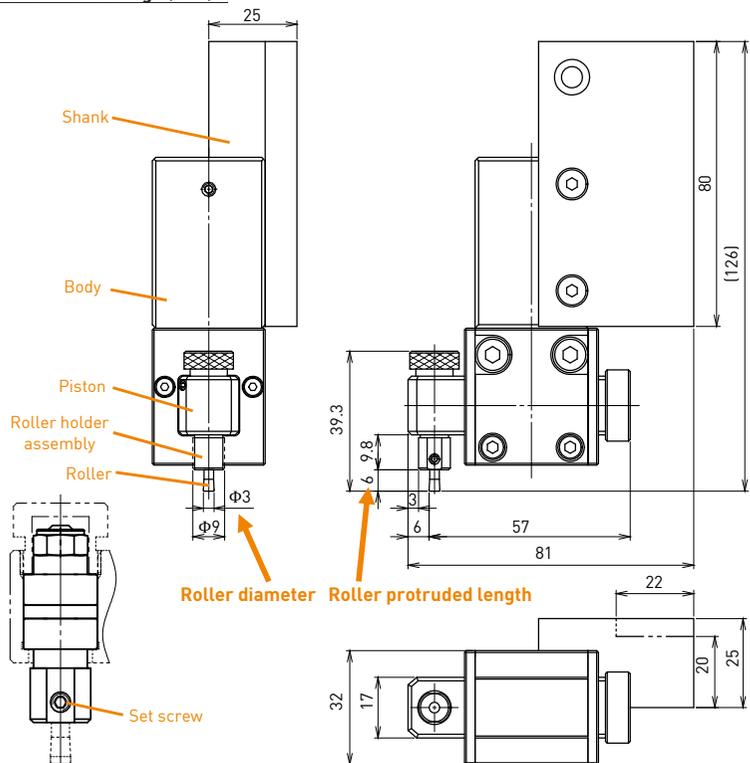


# Single Roller Type

## Superroll SR3Z (For outer groove side surface)

Dimensional drawing (mm)



### Roller holder assembly

#### Standard

Tool model	Shank		Consumable items	
	Size	Shape	Roller	Roller holder assembly
SR3ZR-S20	□20	—	ZR350	SRZRHA
SR3ZR-S25	□25	— · —		

\* While Superoll SR3Z is assembled with right-handed when it is shipped, it is possible to change to left-handed by just changing shank direction.  
For requests to special specification, contact your nearest sales office by using the catalog inquiry sheet, or use the inquiry form on the homepage.

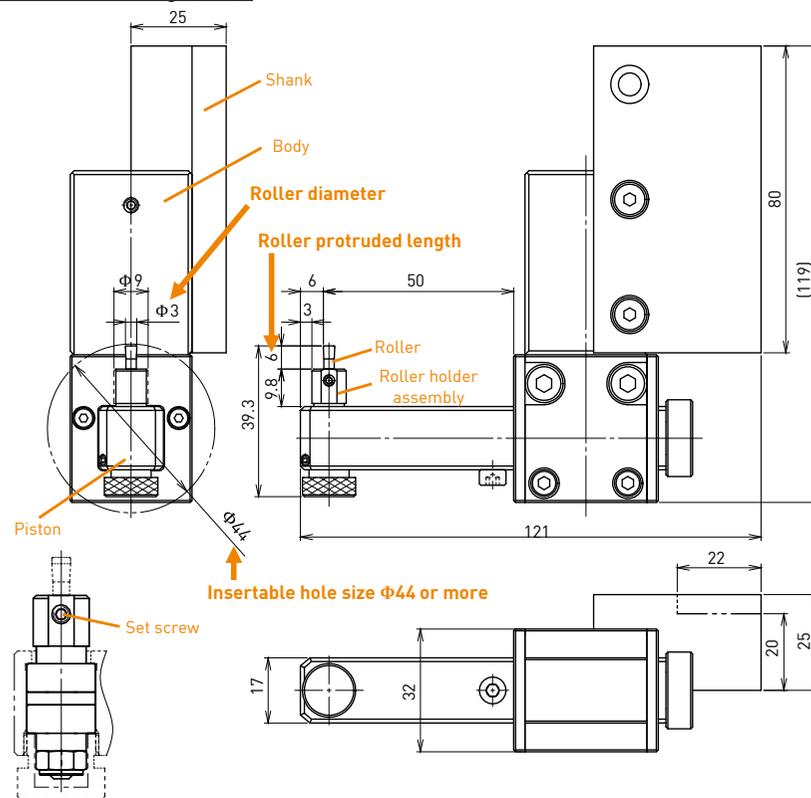
### Roller size & Burnishing conditions (Reference)

	Roller size (mm)	Groove size (mm)		Burnishing conditions (Reference)						
				Pre-load (N)				Feed rate (mm/rev)	Peripheral speed (m/min)	Compression (mm)
				Steel HRC20 or more	Steel HRC20-40	Dicast	Aluminum Copper			
Special	φ 1.7 x 6L	2.2 or more	5 or less	30 - 100	80 - 250	30 - 100	10 - 60	0.05 - 0.2	10 - 50	0.1 - 0.2
Standard	φ 3 x 6L	3.6 or more	5.5 or less	50 - 120	100 - 300	50 - 120	20 - 80			
Special	φ 3 x 9.5L	3.6 or more	9 or less							

\* 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.  
\* For requests to Roller size which is shown in above table, contact your nearest sales office by using the catalog inquiry sheet, or use the inquiry form on the homepage.  
\* If the compression amount exceeds over 0.2mm, the set screw of Roller holder Assembly may loosen and rollers may be dropped off.

## Superroll SR3ZH (For inner groove side surface)

Dimensional drawing (mm)



### Roller holder assembly

#### Representative specification

Tool model	Shank		Consumable items	
	Size	Shape	Roller	Roller holder assembly
SR3ZH45LR-S20	□20	—	ZR350	SRZRHA
SR3ZH45LR-S25	□25	— · —		

\* There is no standard type and every type is special type for Superoll SR3ZH as of November 2020.  
\* While Superoll SR3ZH is assembled with right-handed when its shipped, it is possible to change it to left-handed by just changing Shank direction.  
\* Component parts of Superoll SR3ZH other than Piston are the same as Superoll SR3Z(For outer grooving side surface).