

# Compressive Type

## Superroll ST Overview

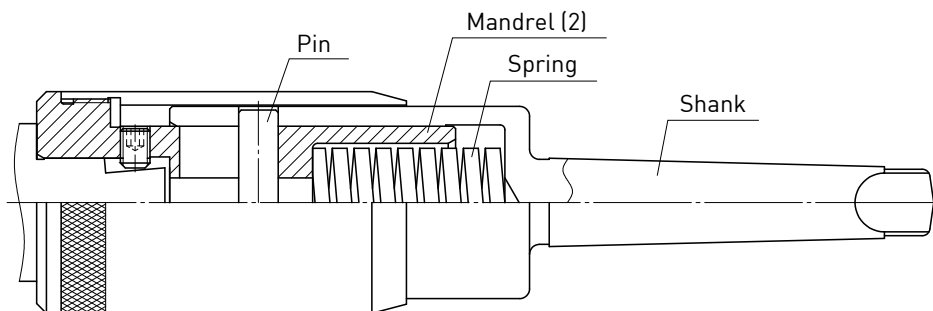
### Overview

Superroll ST is for burnishing inner taper surface, and is ideal for finishing surfaces that require sealing. This type has compression mechanism installed within Superroll.

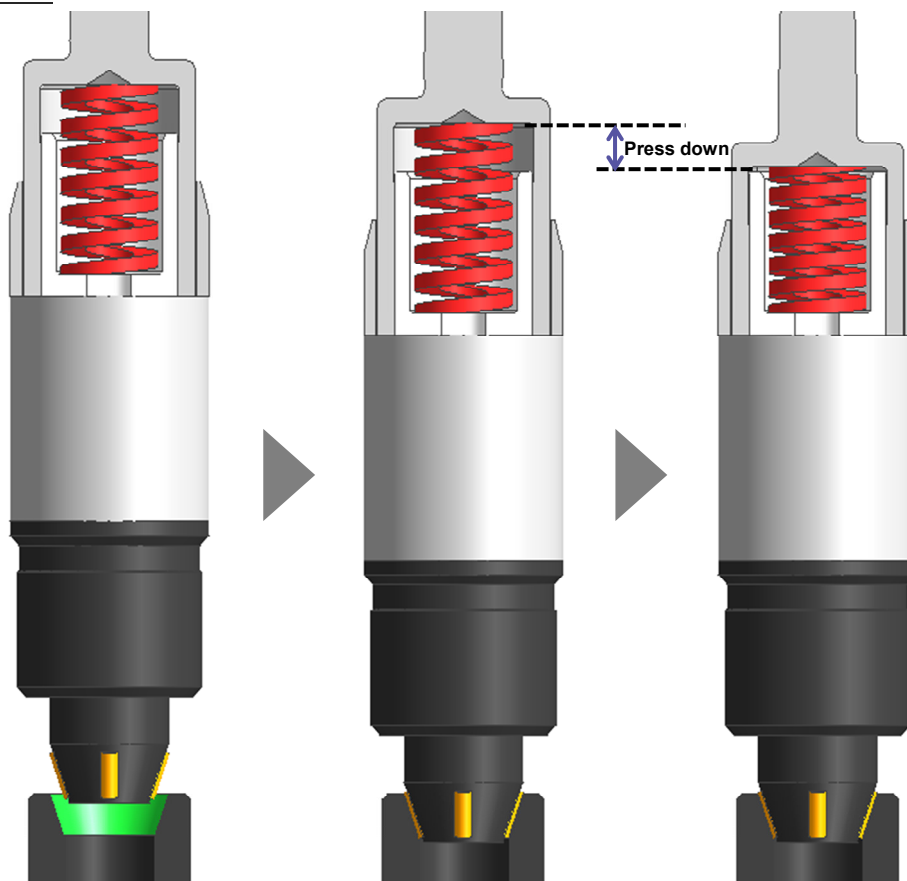
After rollers make contact with a workpiece, applies a pre-determined compression to Superroll ST by deflecting a spring, to generate a load required for burnishing.

Tool tip parts (Head assembly) are designed and made to suit the shape of customer's workpieces.

### Compression shank assembly mechanism



### Burnishing procedure



(1) Install Superroll ST to a driving unit.  
Next, align the center of a workpiece and Superroll ST.

(2) Operate Superroll ST in a normal rotation direction at a pre-determined speed, and make contact with rollers and a workpiece.

(3) After making contact with a workpiece, apply a pre-determined compression and dwell.

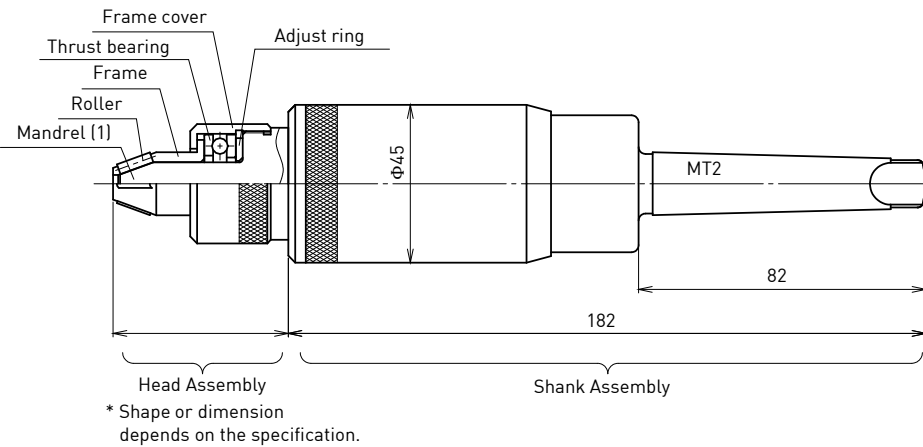
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## Superroll ST Overview

### Exterior view

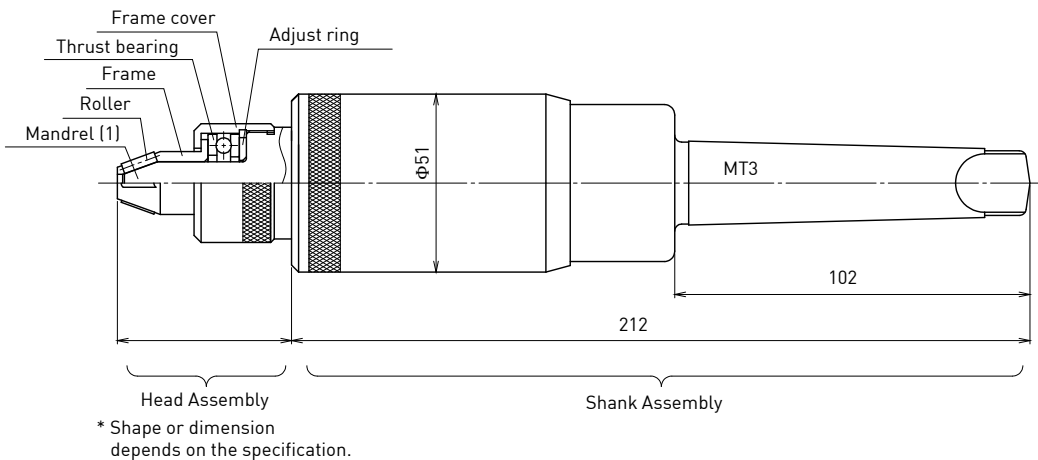
Tool tips parts (Head assembly) are designed and made to suit a shape of customer's workpieces. Two types of shank assembly are available to suit a required load for burnishing. The optimum specifications will be proposed according to the workpiece shape and material.

#### Tool size $\phi 45$ type



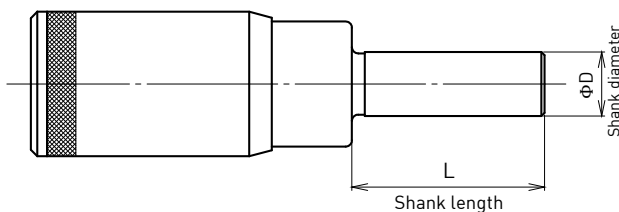
Tool size	Spring (Max load)
$\phi 45$	190N
	390N
	700N
	1.4kN
	2.3kN
	3.4kN
$\phi 51$	4.0kN
	5.9kN

#### Tool size $\phi 51$ type



### Straight shank type

Straight shanks are also available as special shank if necessary. Select from the Recommended straight shank sizes in the chart below. For requests for shank sizes not included in the chart, contact your nearest sales office by using the catalog inquiry sheet, or use the inquiry form on our website.



Tool size	Recommended straight shank size		
$\phi 45$	$\phi 20 \times 60L$	$\phi 25 \times 60L$	
$\phi 51$			$\phi 32 \times 70L$