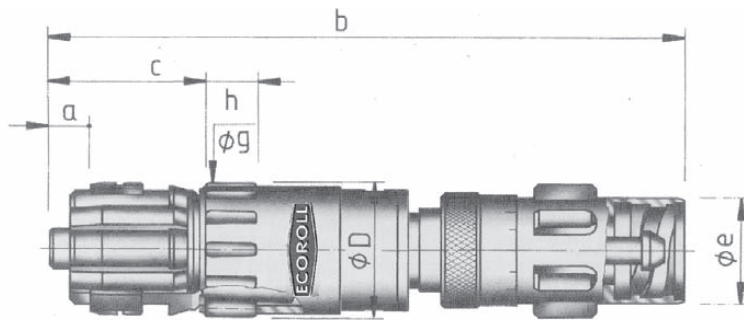


Combined Skive-Burnishing Tools

Technical Data

NOTE:

- The tool retainer is a BTA thread or an S-thread with a compressed air connection.
- Separate skiving and roller burnishing operations are recommended for diameters larger than 455 mm. Separate skiving heads are available in this range to improve circular form and/or machining allowance to less than 3 mm.
- All dimensions in mm



Tool type	Diameter range D	BTA boring bar ϕe	Skiving knives		Roller head			Main dimensions			
			Diameter Range	Cross-section	Range	Number of rollers	Roller $\phi g \times h$	a	b	c	
RDS11	$\geq 38 < 44$	33	Nominal $\phi \pm 0.04$	20 x 14	-0.05/-0.2	8	6 x 20	12	275	67	
RDS21.1	$\geq 44 < 50$	36		18 x 18	-0.05/+0.3			304	86		
RDS21.2	$\geq 50 < 55$ $\geq 55 < 60$	43						16	301	81	
RDSQ11	$\geq 38 < 44$	33	Nominal $\phi \pm 0.04$	20 x 18	-0.05/+0.2			12	275	67	
RDSQ21.1	$\geq 44 < 50$	36		18 x 18	-0.05/+0.3			304	86		
RDSQ21.2	$\geq 50 < 55$ $\geq 55 < 60$	43						16	301	81	
RDO34.1	$\geq 60 < 70$	47	$\geq 60 < 63$ $\geq 63 < 70$	50 x 17	-0.05/+0.3	12	8 x 25	110	430	200	
RDO34.2	$\geq 70 < 80$ $\geq 80 < 100$	56 68	$\geq 70 < 80$ $\geq 80 < 100$	50 x 18	-0.05/+0.5			14 x 35	120	482	207
RDO44.1	$\geq 100 < 120$	82	$\geq 100 < 120$						121	540	241
RDO44.2	$\geq 120 < 140$	106	$\geq 120 < 140$								
RDO54.1	$\geq 140 < 170$	118	$\geq 140 < 170$	60 x 24	16						
RDO54.2	$\geq 170 < 205$	142	$\geq 170 < 205$								
RDO64.1	$\geq 205 < 255$ $\geq 255 < 305$	178	$\geq 205 < 255$ $\geq 255 < 305$	60 x 32	20						
RDO64.2	$\geq 305 < 455$	226	$\geq 305 < 325$								
		*	$\geq 325 < 455$					136	641	326	

* Depends on existing boring bar

Recommend operating parameters

Tool type	Diameter range mm	Rippling problem?	Cutting speed m/min.	Feed mm/rev.	Motor capacity kW
RDSR / RDSQ	$\geq 38 < 60$	none	180	2	20
RDO2 (2 knives)	$\geq 60 < 400$	moderate	300	3	30 - 50
RDO3 (3 knives)	$\geq 60 < 400$			4	
RDO6 (6 knives)	$\geq 205 < 455$			substantial	6