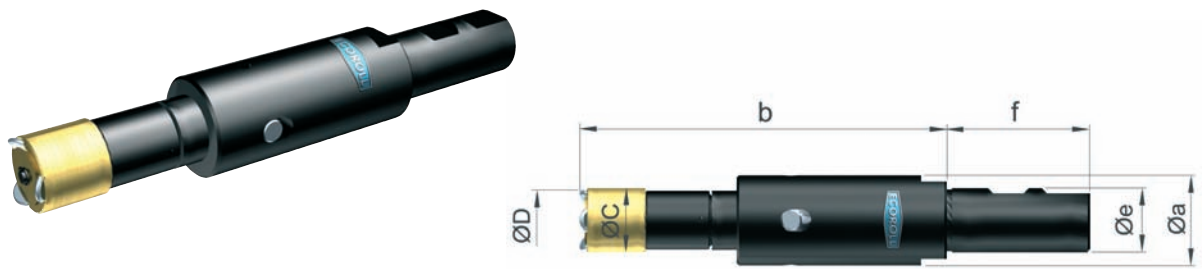
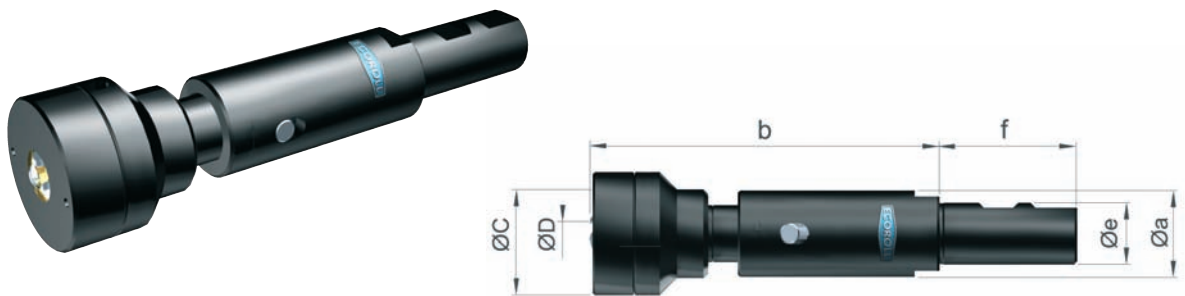


Type RH Tool Applications: Internal surfaces (fillets)



Type RHA Tool Applications: External surfaces (chamfers)



Features

- Deep rolling with the plunge-in process
- For use with CNC-controlled or conventional lathes
- Complete processing in one setting
- Either right- or left-hand operation
- Rotates in either direction
- Suspended rollers for even force distribution independent of production tolerances

Advantages

Deep rolling combines the following three physical effects:

- Induces deep residual compressive stresses which increase a component's fatigue strength (especially important during cyclic loading)
- Increases the surface layer's material strength through controlled cold working
- Improves surface finish, thus greatly reducing surface flaws where cracks can initiate

Further advantages:

- Cost effective: deep rolling can take place in one setting on a standard machining tool right after the cutting process.
- No set up time, just tool change
- No transport costs
- Low energy consumption

Basic tool design

Type RH and RHA deep rolling tools consist of a tool body and roller head.

Tool body

- Four different sizes available (S1 through S4)
- Standard shank: Morse taper or cylindrical shank, other mounting systems by request
- Equipped with a disc spring assembly
- Spring layers specifically designed and arranged for each machining task

Roller head

- Specially designed per workpiece dimensions
- Mounted onto the tool body

Parameters

- Maximum rolling force: 40 kN
- Maximum machining radius: 4.0 mm
- Maximum yield strength: 1400 N/mm²
- Machining diameter (RH): > 17 mm
- Machining diameter (RHA): > 4 mm

Main dimensions (mm)					Shank Ø d (mm)
a	b	c	b ₁	x	
26-65	depends upon workpiece				≥ 25