

**S.C.A.M.I.**

Edition 2023

# INTERNAL AND EXTERNAL ROLLER BURNISHING TOOLS



## RULLATORI PER INTERNI ED ESTERNI



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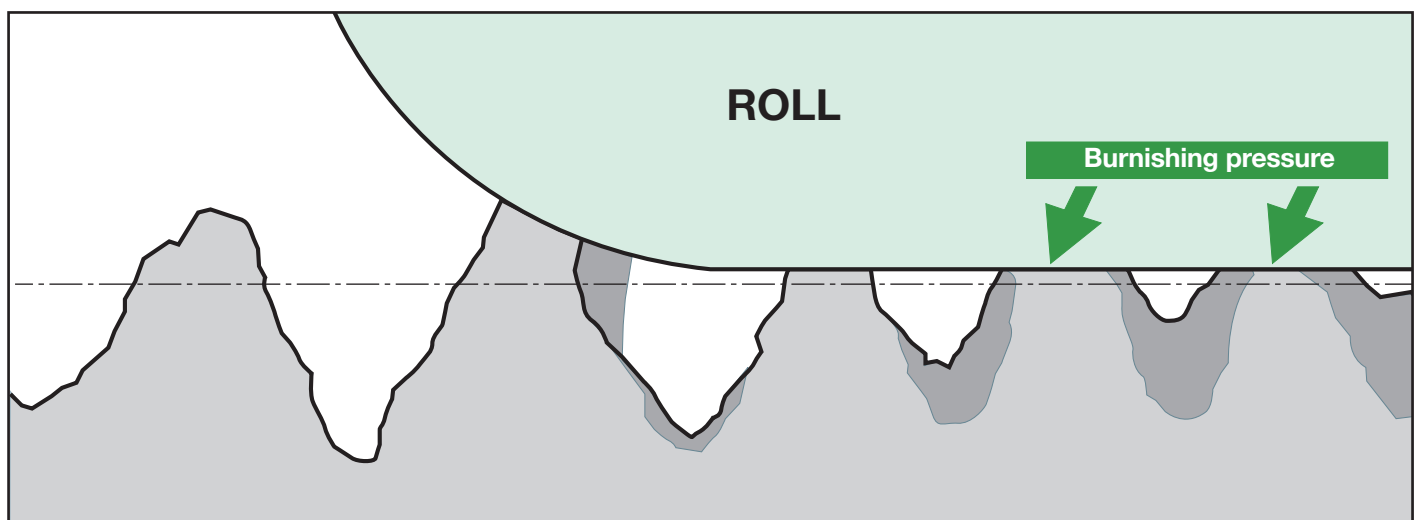
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# ROLLER BURNISHING

## THE PRINCIPLE OF ROLLER BURNISHING

Roller burnishing is a cold-working process which produces a fine surface finish by the planetary rotation of hardened rolls over a bored or turned metal surface. However, unlike cold rolling, which generally produces large sectional changes, roller burnishing involves cold-working on the surface of the workpiece to improve surface structure. In the burnishing process, the pressure generated by the rolls exceeds the yield point of the softer piece part surface at the point of contact.

The result is a small plastic deformation of the surface structure of the piece part. Since all machined surfaces consist of a series of peaks and valleys of irregular height and spacing, the plastic deformation created by roller burnishing is a displacement of the material in the peaks which cold flows under pressure into the valleys. In the process, tool marks and irregularities are rolled out. The result is a mirror like finish with a tough, work-hardened, wear and corrosion resistant surface.



## BENEFITS OF ROLLER BURNISHING

### Improved metallurgical properties

Burnishing cold works the metal of a machined part. Tool marks are rolled out. Grain structure is condensed and refined, and the compacted surface is smoother, harder and longer wearing than ground or honed surfaces. The rolling action also greatly reduces surface porosity and scratches which could hold reactive substances or contaminants. As a result, the corrosion resistance of burnished surfaces is higher than the open surfaces produced by grinding or honing. Depending on the type of material being burnished, surface hardness can be increased by as much as 10 points Rockwell C. This increase often eliminates the need for heat treatment as a means of improving wear resistance. Another metallurgical improvement stems from induced residual compressive stresses in the surface of the part as a result of plastic deformation in the roller burnishing operation. These compressive stresses greatly increase the strength properties and fatigue life of the part, because any forces on the part must overcome these residual stresses, as well as the tensile strength of the materials, before fatigue conditions occur.

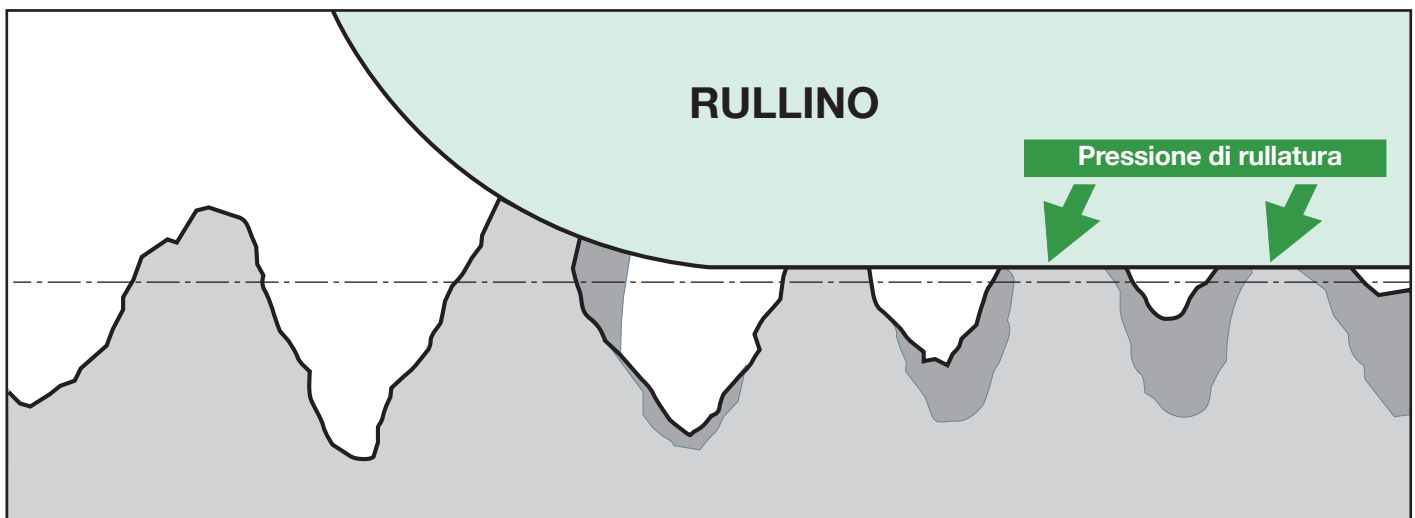
### Improved surface finish

Roller burnishing imparts a high finish to any machinable metal. Surfaces which are bored, reamed or turned to 125 micro inches or more can be finished to 4 micro inch CLA or less in one pass at feed rates of 125 to 300 mm/min.

Roller burnishing replaces grinding, honing, lapping and other expensive secondary operations.

## IL PRINCIPIO DELLA RULLATURA

La rullatura è un procedimento di lavorazione a freddo, senza asportazione di truciolo, che consente di ottenere una superfinitura superficiale. I rullini conici, forzati contro la superficie da rullare, generano una pressione che produce una deformazione plastica del materiale. Qualunque superficie lavorata con utensile ad asportazione di truciolo, vista in sezione con il dovuto ingrandimento, si presenta come una successione irregolare di creste, che danno luogo alla rugosità superficiale. La deformazione plastica prodotta dalla pressione dei rullini, consiste in un appiattimento delle creste con un movimento del materiale che va ad occupare il vuoto esistente tra due creste successive. In tal modo si ottiene una superficie lucida a "specchio" che presenta un aumento di durezza e densità.



## VANTAGGI DELLA RULLATURA

### Variazioni di struttura

La rullatura provoca una compressione plastica della superficie lavorata, che, oltre ad eliminare la rugosità della superficie, causa una variazione di struttura cambiando la forma e l'orientamento dei grani. Si ha una superficie lucida, compatta, indurita; ne deriva una maggior resistenza all'usura ed alla corrosione. L'aumento di durezza dipende dalle caratteristiche del materiale lavorato e dalla quantità di soprametallo rullato; comunque, con la rullatura, si possono ottenere aumenti della durezza superficiale pari ad una variazione di 10 punti HRC. Le superfici rullate resistono pertanto decisamente meglio, rispetto alle superfici rettificate, agli sforzi di rottura.

### Finitura superficiale

Il rullatore consente di ottenere una finitura superficiale speculare, su qualunque materiale lavorabile d'utensile. Una superficie lavorata d'utensile, con rugosità pari a 125 micropollici, viene finita con una rugosità di Ra 4 micropollici, con una sola passata; l'avanzamento varia da un minimo di 125 mm al minuto, ad un massimo di 300 mm.

L'impiego del rullatore elimina la necessità di altre operazioni di finitura, ben più costose.



# CODE DESCRIPTION OF THE COMPLETE ROLLER BURNISHING TOOL

**R D K H - 2 1 0 - 0 0 4, 7 0**

**A**

**B**

**C**

**D**

**E**

**F**

**A**

D = Roller burnishing tools for through holes  
S = Roller burnishing tools for blind holes

**B**

Burnishing tool series	H	=	Ø	4,70	12,77	mm
Burnishing tool series	I	=	Ø	12,64	16,85	mm
Burnishing tool series	K	=	Ø	16,60	24,74	mm
Burnishing tool series	L	=	Ø	24,54	31,16	mm
Burnishing tool series	F	=	Ø	24,54	31,16	mm
Burnishing tool series	M	=	Ø	30,85	35,86	mm
Burnishing tool series	N	=	Ø	35,61	46,97	mm
Burnishing tool series	O	=	Ø	46,71	56,49	mm
Burnishing tool series	P	=	Ø	56,23	69,19	mm
Burnishing tool series	Q	=	Ø	68,93	85,07	mm
Burnishing tool series	R	=	Ø	84,81	104,12	mm
Burnishing tool series	S	=	Ø	103,86	127,94	mm
Burnishing tool series	T	=	Ø	127,90	149,90	mm
Burnishing tool series	U	=	Ø	149,90	165,90	mm

**C**

1 = straight shank  
2 = morse taper shank  
3 = straight shank, through hole tools from diam.15,89 with 704 - 707 type rolls  
4 = MT. shank, through hole tools from diam.15,89 with 704 - 707 type rolls  
5 = straight shank, through hole tools from diam.18,19 with 706 type rolls  
6 = MT. shank, through hole tools from diam.18,19 with 706 type rolls

**D**

0 = unlimited series  
1 = short series  
2 = standard series  
3 = long series

**E**

0 = standard cage  
2 = cage for through holes without self-feed series - 012 -  
4 = cage for blind holes with self-feed series - 014 -

**F**

- Roller burnishing tools for through holes = minimum diameter of burnishing range
- Roller burnishing tools for blind holes = diameter to burnish



# IDENTIFICAZIONE CODICE DEL RULLATORE COMPLETO

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**R D K H - 2 1 0 - 0 0 4, 7 0**

**A**

**B**

**C**

**D**

**E**

**F**

**A**

D = Rullatore per esecuzione fori passanti  
S = Rullatore per esecuzione fori ciechi

**B**

Rullatore serie	H	=	Ø	4,70	12,77	mm
Rullatore serie	I	=	Ø	12,64	16,85	mm
Rullatore serie	K	=	Ø	16,60	24,74	mm
Rullatore serie	L	=	Ø	24,54	31,16	mm
Rullatore serie	F	=	Ø	24,54	31,16	mm
Rullatore serie	M	=	Ø	30,85	35,86	mm
Rullatore serie	N	=	Ø	35,61	46,97	mm
Rullatore serie	O	=	Ø	46,71	56,49	mm
Rullatore serie	P	=	Ø	56,23	69,19	mm
Rullatore serie	Q	=	Ø	68,93	85,07	mm
Rullatore serie	R	=	Ø	84,81	104,12	mm
Rullatore serie	S	=	Ø	103,86	127,94	mm
Rullatore serie	T	=	Ø	127,90	149,90	mm
Rullatore serie	U	=	Ø	149,90	165,90	mm

**C**

1 = attacco cilindrico  
2 = attacco cono morse  
3 = attacco cilindrico, rullatore fori passanti dal diam.15,89 con rullini tipo 704 - 707  
4 = attacco CM., rullatore fori passanti dal diam.15,89 con rullini tipo 704 - 707  
5 = attacco cilindrico, rullatore fori passanti dal diam.18,19 con rullini tipo 706  
6 = attacco CM., rullatore fori passanti dal diam.18,19 con rullini tipo 706

**D**

0 = serie illimitata  
1 = serie corta  
2 = serie standard  
3 = serie lunga

**E**

0 = gabbia standard  
2 = gabbia per fori passanti senza autoavanzamento serie - 012 -  
4 = gabbia per fori ciechi con autoavanzamento serie - 014 -

**F**

- Rullatore per esecuzione fori passanti = diametro minimo della gamma di rullatura
- Rullatore per esecuzione fori ciechi = diametro da rullare



# CODE DESCRIPTION OF THE INCREASED CONES

## FOR ROLLER BURNISHING TOOLS BLIND HOLES

### Method for the identification of number "x" contained in the code of the blind holes cones.

With blind hole burnishing, the cone must not extend past the end of the rolls, otherwise it risks the collision with the bottom of the hole. Each burnishing tool has an adjustment range of approximately 0,5 mm on diameter for tools below 12,7 mm and about 1 mm. for tools above 12,7 mm diameter.

For through hole burnishing tools, the standard cone value "x" is 1. If the standard cone is used for blind hole burnishing it will not extend past the end of the rolls only when the tool is set to the minimum value of the adjustment range. However, if the blind hole to be burnished is greater than the minimum diameter of the tool, then an increased diameter cone is required. With these applications the "x" value (always an integer number) will vary from 2 to 8.

#### CASE A - RULE FOR THE IDENTIFICATION OF THE INCREASED CONE (burnishing tools from Ø 5,89 to 12,77)

$$"x" = 1 + \frac{Z-Y}{0,05}$$

Z= diameter of the hole to be burnished

Y= minimum diameter setting of the burnishing tool in question (see tables on following pages).

As a consequence of the above mentioned calculation, the "x" value could culminate as a decimal figure.

This must be approximated to an integer value below or above if decimal figure is greater than 0,8 mm.

**Example:** Identification of the increased cone for a burnishing tool blind hole, short series

Z = diameter to be burnished 11,05 mm Y = minimum diameter setting 10,71 mm

$$"x" = 1 + \frac{11,05-10,71}{0,05} = 7,8 \text{ which is approximated at } "x" = 8$$

The correct cone is: **RSTH-038-10025**

#### CASE B - RULE FOR THE IDENTIFICATION OF THE INCREASED CONE (burnishing tools from Ø 12,64 to 127,94)

$$"x" = 1 + \frac{Z-Y}{0,1}$$

**Example:** Z = diameter to be burnished 17,76 mm Y = minimum diameter setting 17,40 mm

$$"x" = 1 + \frac{17,76-17,40}{0,1} = 4,6 \text{ which is approximated at } "x" = 4$$

The correct cone is: **RSTK-034-00044**

#### CASE C - RULE FOR THE IDENTIFICATION OF THE INCREASED CONE (burnishing tools from Ø 127,90 to 165,90)

$$"xx" = 31 + \frac{Z-Y}{0,1}$$

**Example:** Z = diameter to be burnished 148,2 mm Y = minimum diameter setting 147,9 mm

$$"xx" = 31 + \frac{148,2-147,9}{0,1} = 34$$

The correct cone is: **RSTT-034-01480**



# IDENTIFICAZIONE CODICE DELLE ASTE MAGGIORATE

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## PER RULLATORI PER FORI CIECHI

### Metodo per l'identificazione del numero "x" contenuto nel codice di ogni asta per fori ciechi.

Nei rullatori per fori ciechi, l'asta conica non deve sporgere oltre i rulli altrimenti si rischia la collisione al fondo del foro. Pertanto, per ogni rullatore per foro cieco va individuata l'asta corretta che non sporga. Ogni rullatore ha un campo di regolazione di circa 0,5 mm sul diametro per i rullatori di diametro inferiore a 12,7 mm e di circa 1 mm sul diametro per i rullatori al di sopra del diametro 12,7 mm. L'asta per la quale il valore "x" è uguale a 1 è quella normalmente utilizzata per i rullatori per fori passanti e, qualora venga utilizzata nel corrispondente rullatore per fori ciechi, non sporge rispetto ai rulli solamente se il rullatore è regolato al valore minimo del suo campo di regolazione. Qualora occorra rullare un foro cieco il cui diametro si colloca su un valore intermedio del campo di regolazione, bisogna allora necessariamente ricorrere ad un'asta maggiorata, per la quale il valore "x" (numero intero) varia tra i valori 2 e 8.

#### CASO A - CALCOLO PER L'IDENTIFICAZIONE DELL'ASTA MAGGIORATA (rullatori dal Ø 5,89 a 12,77)

$$"x" = 1 + \frac{Z-Y}{0,05}$$

Z = diametro del foro effettivamente da rullare

Y = diametro minimo del campo di regolazione del rullatore in oggetto (vedi tabelle nelle pagine seguenti).

Dal calcolo di cui sopra "x" sarà un valore con decimali dopo la virgola. Occorre approssimarlo al valore intero inferiore a meno che il decimale sia uguale o superiore 0,8, nel cui caso va approssimato al numero intero superiore.

**Esempio:** Identificazione dell'asta maggiorata per rullatore per fori ciechi, serie corta

Z = diametro da rullare 11,05 mm Y = diametro minimo del campo di regolazione 10,71 mm

$$"x" = 1 + \frac{11,05-10,71}{0,05} = 7,8 \text{ quindi approssimando: } "x" = 8$$

L'asta corretta da ordinare sarà pertanto: **RSTH-038-10025**

#### CASO B - CALCOLO PER L'IDENTIFICAZIONE DELL'ASTA MAGGIORATA (rullatori dal Ø 12,64 a 127,94)

$$"x" = 1 + \frac{Z-Y}{0,1}$$

**Esempio:** Z = diametro da rullare 17,76 mm Y = diametro minimo del campo di regolazione 17,40 mm

$$"x" = 1 + \frac{17,76-17,40}{0,1} = 4,6 \text{ quindi approssimando: } "x" = 4$$

L'asta corretta da ordinare sarà pertanto: **RSTK-034-00044**

#### CASO C - CALCOLO PER L'IDENTIFICAZIONE DELL'ASTA MAGGIORATA (rullatori dal Ø 127,90 a 165,90)

$$"xx" = 31 + \frac{Z-Y}{0,1}$$

**Esempio:** Z = diametro da rullare 148,2 mm Y = diametro minimo del campo di regolazione 147,9 mm

$$"xx" = 31 + \frac{148,2-147,9}{0,1} = 34 \text{ quindi } "x" = 34$$

L'asta corretta da ordinare sarà pertanto: **RSTT-034-01480**



# EXTRA SHORT ROLLER BURNISHING TOOLS - SERIES RDEF / RSEF

## RULLATORI EXTRACORTI - SERIE RDEF - RSEF

From diam. 3,95 to 16,85 mm

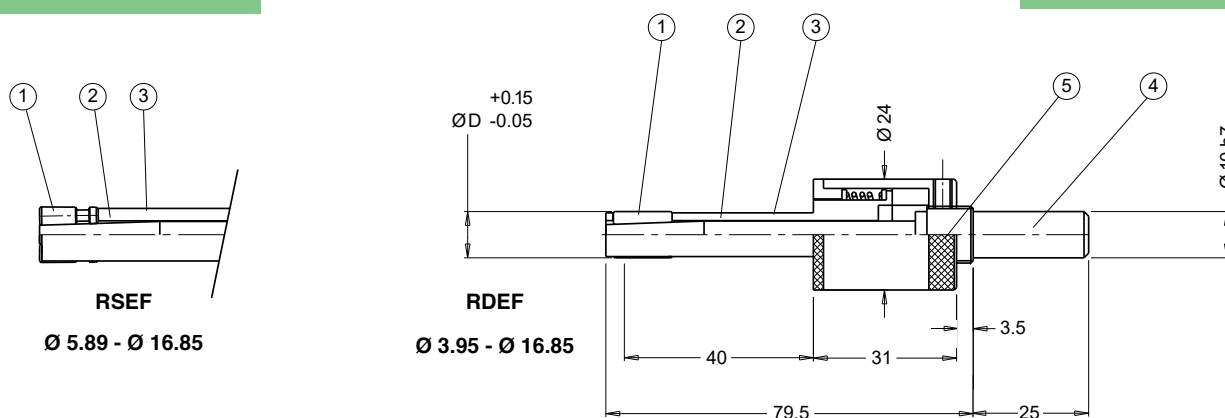
Da diam. 3,95 a 16,85 mm

**Series RDEF through holes**

**Serie RDEF per fori passanti**

**Series RSEF blind holes**

**Serie RSEF per fori ciechi**



Cylindrical Shank Attacco cilindrico pos. 4	Adjustment housing assembly Boccola di registrazione pos. 5	Cage for through holes Gabbia fori passanti pos.3	<b>B</b> Cage for blind holes Gabbia fori ciechi pos.3	<b>C</b> Cone Asta pos.2	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
RDEF-041-10250	RDEF-182-00000	RDEF-012-xxxx*	RSEF-015-xxxx*	**	**	**

Code of complete roller burnishing tools / Codice del rullatore completo:

- for blind holes / per fori ciechi RSEF-110-0xxxx\*
- for through holes / per fori passanti RDEF-100-0xxxx\*

\*0xxxx = Working diameter / Diametro da rullare

\*\* = to be established at the order / Da stabilire in fase d'ordine

From diam. 3,95 to 16,85 mm

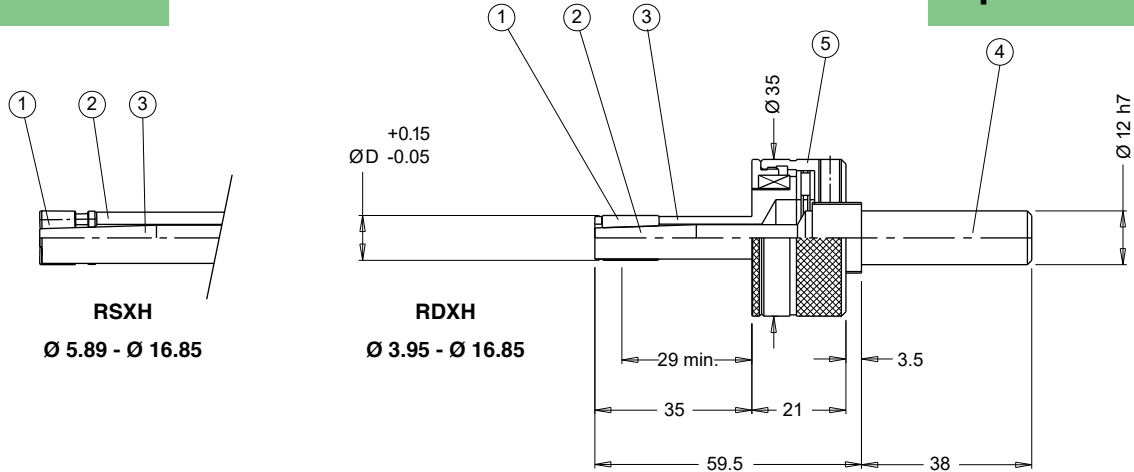
Da diam. 3,95 a 16,85 mm

**Series RDXH  
through holes**

**Serie RDXH per  
fori passanti**

**Series RSXH  
blind holes**

**Serie RSXH  
per fori ciechi**



Cylindrical Shank Attacco cilindrico pos. 4	Adjustment housing assembly Boccola di registrazione pos. 5	Cage for through holes Gabbia fori passanti pos.3	<b>B</b> Cage for blind holes Gabbia fori ciechi pos.3	Cone for through holes Asta fori passanti pos.2	<b>C</b> Cone for blind holes Asta fori ciechi pos.2	<b>D</b> Rolls Rullini pos.1	Rolls qty / Qtà rulli
RDXH-041-12380	RDXH-182-00000	RDXH-012-xxxxx*	RSXH-015-xxxxx*	RDXH-031-xxxxx*	RSXH-031-xxxxx*	**	**

**Codice del rullatore completo:**

- for blind holes / per fori ciechi

RSXH-100-0xxxx

\* for through holes / per fori passanti

RDXH-100-0xxxx\*

\*0xxxx = Working diameter / Diametro da rullare

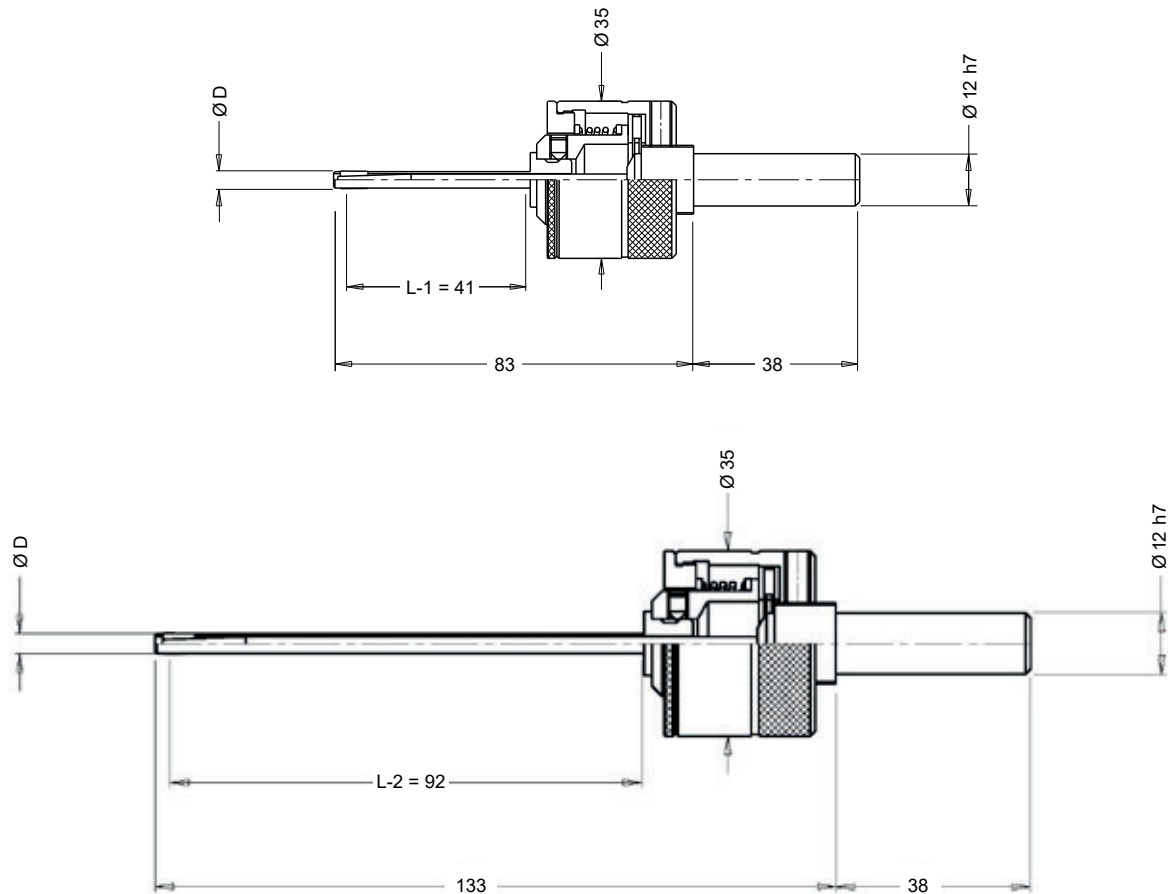
\*\* = to be established at the order / Da stabilire in fase d'ordine



# MINI ROLLER BURNISHING TOOLS SERIES RDKH - THROUGH HOLES RULLATORI MINI - SERIE RDKH - FORI PASSANTI

From diam. 3,95 to 16,85 mm

Da diam. 3,95 a 4,75 mm



Adjustment range Campo di regolazione Ø min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tools with straight shank Rullatore con attacco cilindrico
3,95 - 4,15	1	RDKH-012-00395
	2	RDKH-022-00395
4,16 - 4,35	1	RDKH-012-00416
	2	RDKH-022-00416
4,36 - 4,55	1	RDKH-012-00436
	2	RDKH-022-00436
4,56 - 4,75	1	RDKH-012-00456
	2	RDKH-022-00456



**New Version!** The previous versions RDKH 112 122 and 212 222 will no longer be available

**Nuova Versione!** Le precedenti versioni dei rullatori serie mini RDKH 112 122 e 212 222 non saranno più disponibili.

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi

**A + B + C + D**

**A** = basic assembly (which includes MT or straight shank / **corpo base** (comprensivo di attacco CM. o cilindrico))

**B** = cage / gabbia **C** = cone / asta **D** = set of rolls / serie di rullini

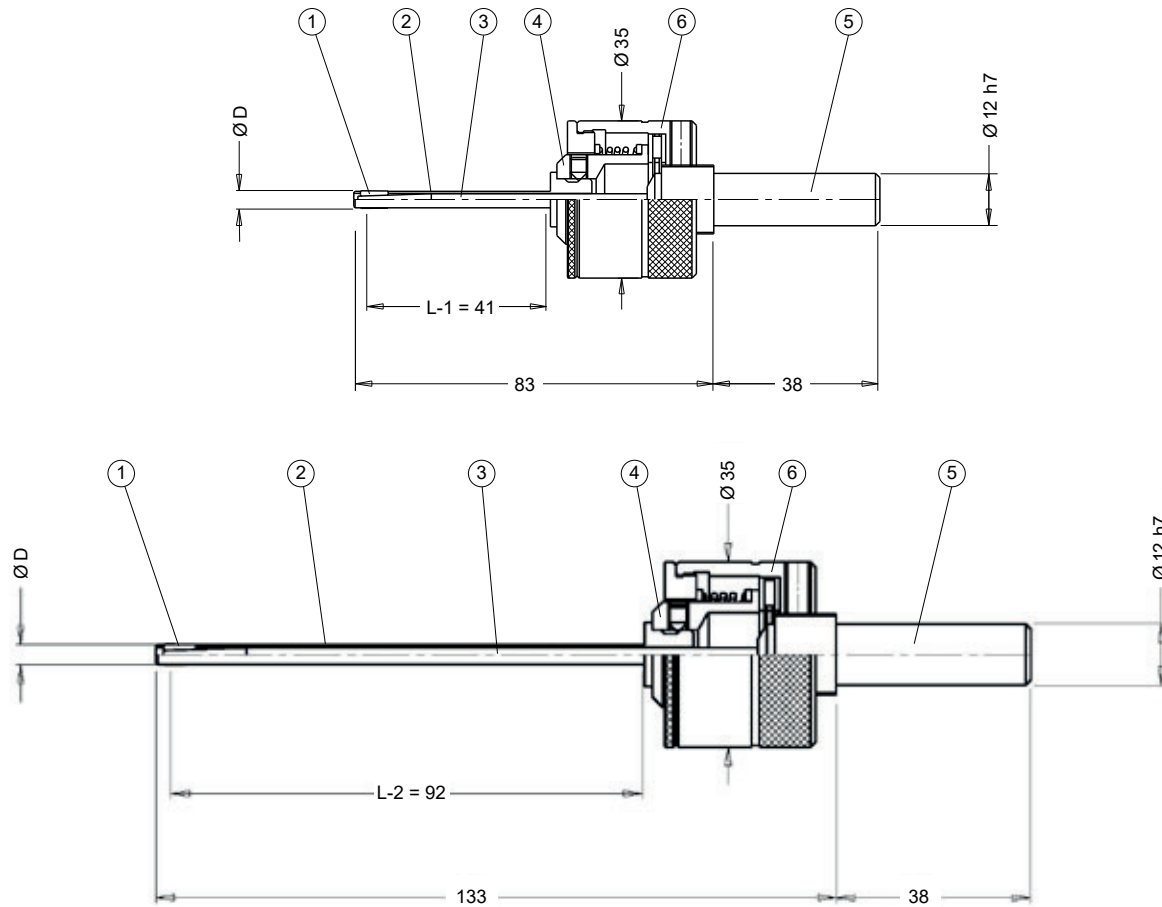
SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

# SPARE PARTS - MINI SERIES RDKH

## RICAMBI SERIE RDKH - MINI

From diam. 3,95 to 16,85 mm

Da diam. 3,95 a 4,75 mm



Adjustment range Campo di regolazione Ø min. max.	Burnishing length / Lunghezza rollatura	Straight shank Attacco cilindrico pos. 5	Adjustment housing assembly Boccola di registrazione pos. 6	Cage sleeve Guidagabbia pos.4	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rullini pos.1	Rolls qty / Qtà rulli
3,95 - 4,15	1 2	RDXH-041-01200	RDGH-182-18581	RDXH-071-00000	RDCH-012-10005	RDTH-031-10012	RDRY-704-00047	3
					RDCH-012-20005	RDTH-031-20012		
4,16 - 4,35	1 2				RDCH-012-10006	RDTH-035-10012		
					RDCH-012-20006	RDTH-035-20012		
4,36 - 4,55	1 2				RDCH-012-10007	RDTH-031-10013		
					RDCH-012-20007	RDTH-031-20013		
4,56 - 4,75	1 2				RDCH-012-10008	RDTH-035-10013		
					RDCH-012-20008	RDTH-035-20013		

**A** Basic assembly with straight shank / Corpo base con attacco cilindrico

pos.4+5+6

RDXH-120-00000



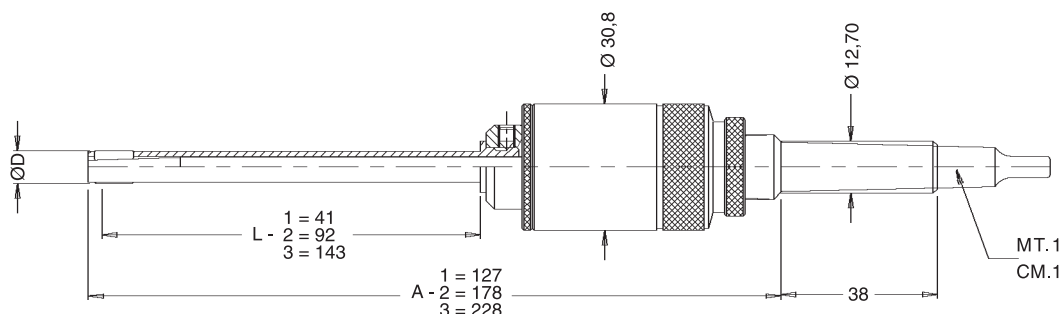
# ROLLER BURNISHING TOOLS

## SERIES RDKH - THROUGH HOLES

## RULLATORI SERIE RDKH - FORI PASSANTI

From diam. 4,70 to 12,77 mm

Da diam. 4,70 a 12,77 mm



NB - To order the tool with the Ø 12 cylindrical shank, add "/12" to the rollercode

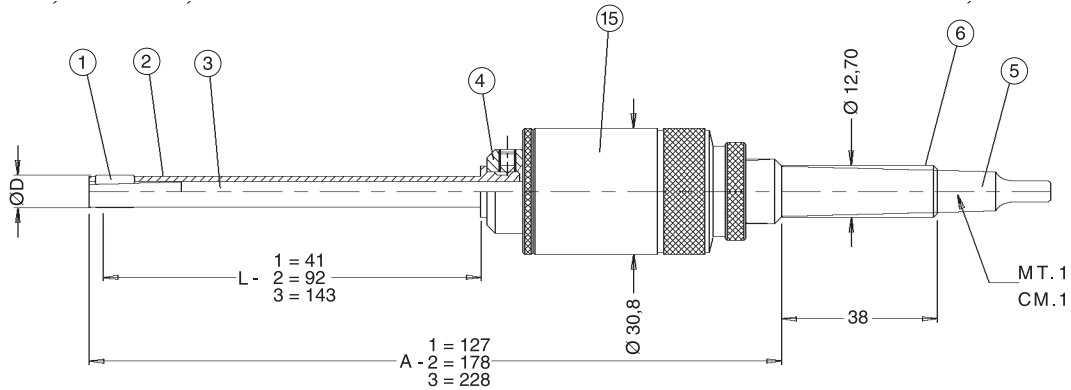
N.B. Per ordinare l'utensile con l'attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
4,70 - 4,90	1	RDKH-210-00470	RDKH-110-00470	8,66 - 9,16	1	RDKH-210-00866	RDKH-110-00866
	2	RDKH-220-00470	RDKH-120-00470		2	RDKH-220-00866	RDKH-120-00866
	3	RDKH-230-00470	RDKH-130-00470		3	RDKH-230-00866	RDKH-130-00866
4,87 - 5,17	1	RDKH-210-00487	RDKH-110-00487	9,06 - 9,57	1	RDKH-210-00906	RDKH-110-00906
	2	RDKH-220-00487	RDKH-120-00487		2	RDKH-220-00906	RDKH-120-00906
	3	RDKH-230-00487	RDKH-130-00487		3	RDKH-230-00906	RDKH-130-00906
5,07 - 5,59	1	RDKH-210-00507	RDKH-110-00507	9,48 - 9,99	1	RDKH-210-00948	RDKH-110-00948
	2	RDKH-220-00507	RDKH-120-00507		2	RDKH-220-00948	RDKH-120-00948
	3	RDKH-230-00507	RDKH-130-00507		3	RDKH-230-00948	RDKH-130-00948
5,49 - 5,99	1	RDKH-210-00549	RDKH-110-00549	9,91 - 10,42	1	RDKH-210-00991	RDKH-110-00991
	2	RDKH-220-00549	RDKH-120-00549		2	RDKH-220-00991	RDKH-120-00991
	3	RDKH-230-00549	RDKH-130-00549		3	RDKH-230-00991	RDKH-130-00991
5,89 - 6,41	1	RDKH-210-00589	RDKH-110-00589	10,29 - 10,80	1	RDKH-210-01029	RDKH-110-01029
	2	RDKH-220-00589	RDKH-120-00589		2	RDKH-220-01029	RDKH-120-01029
	3	RDKH-230-00589	RDKH-130-00589		3	RDKH-230-01029	RDKH-130-01029
6,31 - 6,81	1	RDKH-210-00631	RDKH-110-00631	10,71 - 11,21	1	RDKH-210-01071	RDKH-110-01071
	2	RDKH-220-00631	RDKH-120-00631		2	RDKH-220-01071	RDKH-120-01071
	3	RDKH-230-00631	RDKH-130-00631		3	RDKH-230-01071	RDKH-130-01071
6,71 - 7,21	1	RDKH-210-00671	RDKH-110-00671	11,11 - 11,61	1	RDKH-210-01111	RDKH-110-01111
	2	RDKH-220-00671	RDKH-120-00671		2	RDKH-220-01111	RDKH-120-01111
	3	RDKH-230-00671	RDKH-130-00671		3	RDKH-230-01111	RDKH-130-01111
7,12 - 7,62	1	RDKH-210-00712	RDKH-110-00712	11,46 - 11,96	1	RDKH-210-01146	RDKH-110-01146
	2	RDKH-220-00712	RDKH-120-00712		2	RDKH-220-01146	RDKH-120-01146
	3	RDKH-230-00712	RDKH-130-00712		3	RDKH-230-01146	RDKH-130-01146
7,48 - 7,98	1	RDKH-210-00748	RDKH-110-00748	11,89 - 12,39	1	RDKH-210-01189	RDKH-110-01189
	2	RDKH-220-00748	RDKH-120-00748		2	RDKH-220-01189	RDKH-120-01189
	3	RDKH-230-00748	RDKH-130-00748		3	RDKH-230-01189	RDKH-130-01189
7,88 - 8,38	1	RDKH-210-00788	RDKH-110-00788	12,27 - 12,77	1	RDKH-210-01227	RDKH-110-01227
	2	RDKH-220-00788	RDKH-120-00788		2	RDKH-220-01227	RDKH-120-01227
	3	RDKH-230-00788	RDKH-130-00788		3	RDKH-230-01227	RDKH-130-01227
8,28 - 8,79	1	RDKH-210-00828	RDKH-110-00828				
	2	RDKH-220-00828	RDKH-120-00828				
	3	RDKH-230-00828	RDKH-130-00828				

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D****A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulliSEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

From diam. 4,70 to 12,77 mm

Da diam. 4,70 a 12,77 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
4,70 - 4,90	1	RDCH-011-10012	RDTH-031-10012	RDRY-704-00062	3
	2	RDCH-011-20012	RDTH-031-20012		
	3	RDCH-011-30012	RDTH-031-30012		
4,87 - 5,17	1	RDCH-011-10011	RSTH-033-10012	RDRY-704-00062	5
	2	RDCH-011-20011	RSTH-033-20012		
	3	RDCH-011-30011	RSTH-033-30012		
5,07 - 5,59	1	RDCH-011-10013	RDTH-031-10013	RDRY-704-00070	5
	2	RDCH-011-20013	RDTH-031-20013		
	3	RDCH-011-30013	RDTH-031-30013		
5,49 - 5,99	1	RDCH-011-10014	RDTH-031-10013	RDRY-704-00070	5
	2	RDCH-011-20014	RDTH-031-20013		
	3	RDCH-011-30014	RDTH-031-30013		
5,89 - 6,41	1	RDCH-011-10015	RDTH-031-10015	RDRY-704-00070	5
	2	RDCH-011-20015	RDTH-031-20015		
	3	RDCH-011-30015	RDTH-031-30015		
6,31 - 6,81	1	RDCH-011-10016	RDTH-031-10015	RDRY-704-00078	5
	2	RDCH-011-20016	RDTH-031-20015		
	3	RDCH-011-30016	RDTH-031-30015		
6,71 - 7,21	1	RDCH-011-10017	RDTH-031-10017	RDRY-704-00078	5
	2	RDCH-011-20017	RDTH-031-20017		
	3	RDCH-011-30017	RDTH-031-30017		
7,12 - 7,62	1	RDCH-011-10018	RDTH-031-10017	RDRY-704-00086	5
	2	RDCH-011-20018	RDTH-031-20017		
	3	RDCH-011-30018	RDTH-031-30017		
7,48 - 7,98	1	RDCH-011-10019	RDTH-031-10019	RDRY-704-00086	5
	2	RDCH-011-20019	RDTH-031-20019		
	3	RDCH-011-30019	RDTH-031-30019		
7,88 - 8,38	1	RDCH-011-10020	RDTH-031-10019	RDRY-704-00093	5
	2	RDCH-011-20020	RDTH-031-20019		
	3	RDCH-011-30020	RDTH-031-30019		
8,28 - 8,79	1	RDCH-011-10021	RDTH-031-10021	RDRY-704-00093	5
	2	RDCH-011-20021	RDTH-031-20021		
	3	RDCH-011-30021	RDTH-031-30021		

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
8,66 - 9,16	1	RDCH-011-10022	RDTH-031-10019	RDRY-704-00109	5
	2	RDCH-011-20022	RDTH-031-20019		
	3	RDCH-011-30022	RDTH-031-30019		
9,06 - 9,57	1	RDCH-011-10023	RDTH-031-10021	RDRY-704-00109	5
	2	RDCH-011-20023	RDTH-031-20021		
	3	RDCH-011-30023	RDTH-031-30021		
9,48 - 9,99	1	RDCH-011-10024	RDTH-031-10024	RDRY-704-00109	5
	2	RDCH-011-20024	RDTH-031-20024		
	3	RDCH-011-30024	RDTH-031-30024		
9,91 - 10,42	1	RDCH-011-10025	RDTH-031-10025	RDRY-704-00125	5
	2	RDCH-011-20025	RDTH-031-20025		
	3	RDCH-011-30025	RDTH-031-30025		
10,29 - 10,80	1	RDCH-011-10026	RDTH-031-10024	RDRY-704-00125	5
	2	RDCH-011-20026	RDTH-031-20024		
	3	RDCH-011-30026	RDTH-031-30024		
10,71 - 11,21	1	RDCH-011-10027	RDTH-031-10025	RDRY-704-00125	5
	2	RDCH-011-20027	RDTH-031-20025		
	3	RDCH-011-30027	RDTH-031-30025		
11,11 - 11,61	1	RDCH-011-10028	RDTH-031-10028	RDRY-704-00148	5
	2	RDCH-011-20028	RDTH-031-20028		
	3	RDCH-011-30028	RDTH-031-30028		
11,46 - 11,96	1	RDCH-011-10029	RDTH-031-10024	RDRY-704-00148	5
	2	RDCH-011-20029	RDTH-031-20024		
	3	RDCH-011-30029	RDTH-031-30024		
11,89 - 12,39	1	RDCH-011-10030	RDTH-031-10025	RDRY-704-00148	5
	2	RDCH-011-20030	RDTH-031-20025		
	3	RDCH-011-30030	RDTH-031-30025		
12,27 - 12,77	1	RDCH-011-10031	RDTH-031-10028	RDRY-704-00148	5
	2	RDCH-011-20031	RDTH-031-20028		
	3	RDCH-011-30031	RDTH-031-30028		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWH-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWH-120-00000
	MT. shank / Attacco CM	pos.5	RDSH-042-10000
	Straight shank / Attacco cilindrico	pos.6	RDSH-041-10000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-10000
	Cage sleeve / Guidagabbia	pos.4	RDAH-071-00000



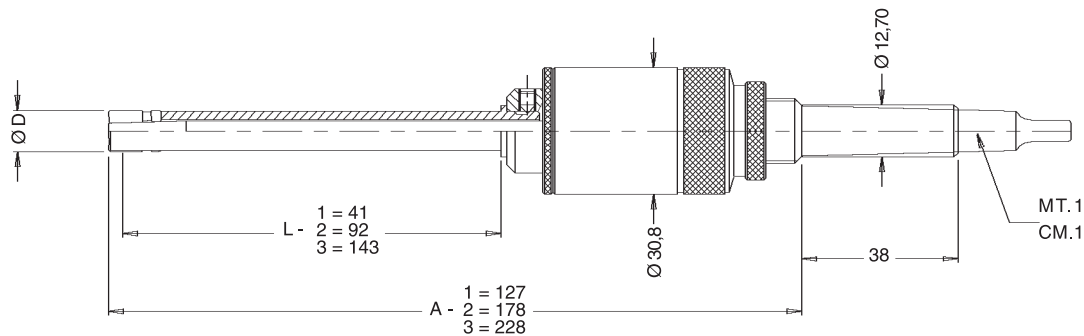
# ROLLER BURNISHING TOOLS

## RSKH - BLIND HOLES

### RULLATORI SERIE RSKH - FORI CIECHI

From diam. 5,89 to 12,77 mm

Da diam. 5,89 a 12,77 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
5,89 - 6,41	1	RSKH-210-xxxxx	RSKH-110-xxxxx	9,48 - 9,99	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
6,31 - 6,81	1	RSKH-210-xxxxx	RSKH-110-xxxxx	9,91 - 10,42	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
6,71 - 7,21	1	RSKH-210-xxxxx	RSKH-110-xxxxx	10,29 - 10,80	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
7,12 - 7,62	1	RSKH-210-xxxxx	RSKH-110-xxxxx	10,71 - 11,21	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
7,48 - 7,98	1	RSKH-210-xxxxx	RSKH-110-xxxxx	11,11 - 11,61	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
7,88 - 8,38	1	RSKH-210-xxxxx	RSKH-110-xxxxx	11,46 - 11,96	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
8,28 - 8,79	1	RSKH-210-xxxxx	RSKH-110-xxxxx	11,89 - 12,39	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
8,66 - 9,16	1	RSKH-210-xxxxx	RSKH-110-xxxxx	12,27 - 12,77	1	RSKH-210-xxxxx	RSKH-110-xxxxx
	2	RSKH-220-xxxxx	RSKH-120-xxxxx		2	RSKH-220-xxxxx	RSKH-120-xxxxx
	3	RSKH-230-xxxxx	RSKH-130-xxxxx		3	RSKH-230-xxxxx	RSKH-130-xxxxx
9,06 - 9,57	1	RSKH-210-xxxxx	RSKH-110-xxxxx				
	2	RSKH-220-xxxxx	RSKH-120-xxxxx				
	3	RSKH-230-xxxxx	RSKH-130-xxxxx				

xxxxx = Indicate to 2 metric decimal places the size to be burnished.

e.g. Short series Roller burnishing tool Ø 10,25 mm with MT.1 shank: RSKH-210-01025

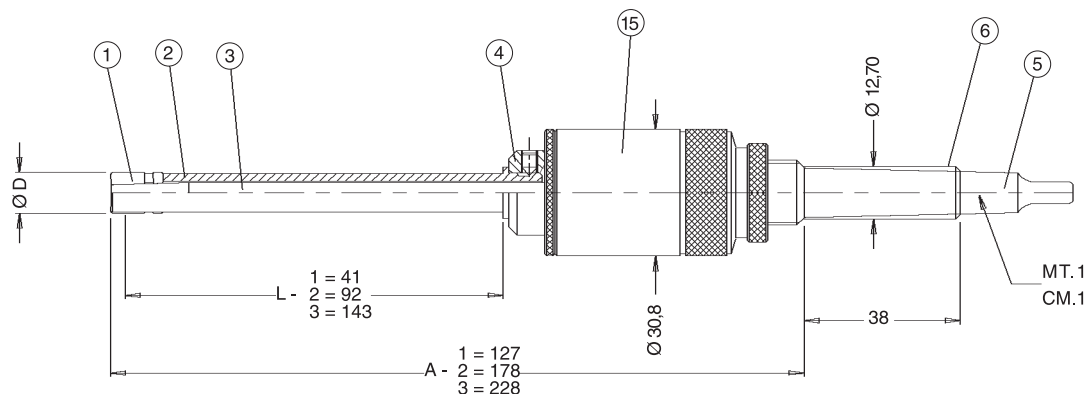
Numerazione che indica il diametro da rullare in centesimi

es. Rullatore Ø 10,25 attacco CM.1, serie corta: RSKH-210-01025

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D****A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulliSEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

From diam. 5,89 to 12,77 mm

Da diam. 5,89 a 12,77 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
5,89 - 6,41	1	RSCH-015-10015	RSTH-03x-10012	RSRY-708-00086	3
	2	RSCH-015-20015	RSTH-03x-20012		
	3	RSCH-015-30015	RSTH-03x-30012		
6,31 - 6,81	1	RSCH-015-10016	RSTH-03x-10013		
	2	RSCH-015-20016	RSTH-03x-20013		
	3	RSCH-015-30016	RSTH-03x-30013		
6,71 - 7,21	1	RSCH-015-10017	RSTH-03x-10015		
	2	RSCH-015-20017	RSTH-03x-20015		
	3	RSCH-015-30017	RSTH-03x-30015		
7,12 - 7,62	1	RSCH-015-10018	RSTH-03x-10017		
	2	RSCH-015-20018	RSTH-03x-20017		
	3	RSCH-015-30018	RSTH-03x-30017		
7,48 - 7,98	1	RSCH-015-10019	RSTH-03x-10019		
	2	RSCH-015-20019	RSTH-03x-20019		
	3	RSCH-015-30019	RSTH-03x-30019		
7,88 - 8,38	1	RSCH-015-10020	RSTH-03x-10021		
	2	RSCH-015-20020	RSTH-03x-20021		
	3	RSCH-015-30020	RSTH-03x-30021		
8,28 - 8,79	1	RSCH-015-10021	RSTH-03x-10024		
	2	RSCH-015-20021	RSTH-03x-20024		
	3	RSCH-015-30021	RSTH-03x-30024		
8,66 - 9,16	1	RSCH-015-10022	RSTH-03x-10015	RSRY-708-00125	
	2	RSCH-015-20022	RSTH-03x-20015		
	3	RSCH-015-30022	RSTH-03x-30015		
9,06 - 9,57	1	RSCH-015-10023	RSTH-03x-10017		
	2	RSCH-015-20023	RSTH-03x-20017		
	3	RSCH-015-30023	RSTH-03x-30017		

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
9,48 - 9,99	1	RSCH-015-10024	RSTH-03x-10019	RSRY-708-00125	3
	2	RSCH-015-20024	RSTH-03x-20019		
	3	RSCH-015-30024	RSTH-03x-30019		
9,91 - 10,42	1	RSCH-015-10025	RSTH-03x-10021		
	2	RSCH-015-20025	RSTH-03x-20021		
	3	RSCH-015-30025	RSTH-03x-30021		
10,29 - 10,80	1	RSCH-015-10026	RSTH-03x-10024		
	2	RSCH-015-20026	RSTH-03x-20024		
	3	RSCH-015-30026	RSTH-03x-30024		
10,71 - 11,21	1	RSCH-015-10027	RSTH-03x-10025		
	2	RSCH-015-20027	RSTH-03x-20025		
	3	RSCH-015-30027	RSTH-03x-30025		
11,11 - 11,61	1	RSCH-015-10028	RSTH-03x-10028		
	2	RSCH-015-20028	RSTH-03x-20028		
	3	RSCH-015-30028	RSTH-03x-30028		
11,46 - 11,96	1	RSCH-015-10029	RSTH-03x-10021	RSRY-708-00156	
	2	RSCH-015-20029	RSTH-03x-20021		
	3	RSCH-015-30029	RSTH-03x-30021		
11,89 - 12,39	1	RSCH-015-10030	RSTH-03x-10024		
	2	RSCH-015-20030	RSTH-03x-20024		
	3	RSCH-015-30030	RSTH-03x-30024		
12,27 - 12,77	1	RSCH-015-10031	RSTH-03x-10025		
	2	RSCH-015-20031	RSTH-03x-20025		
	3	RSCH-015-30031	RSTH-03x-30025		

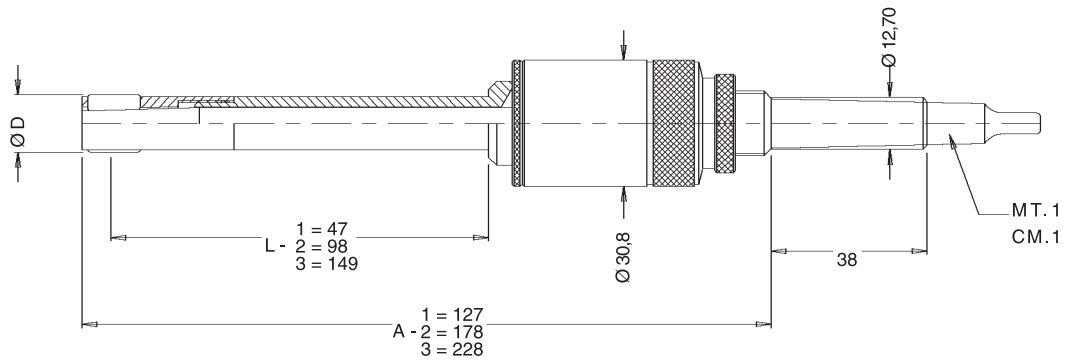
-x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWH-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWH-120-00000
	MT. shank / Attacco CM	pos.5	RDSH-042-10000
	Straight shank / Attacco cilindrico	pos.6	RDSH-041-10000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-10000
	Cage sleeve / Guidagabbia	pos.4	RDAH-071-00000

# ROLLER BURNISHING TOOLS SERIES RDKI - THROUGH HOLES RULLATORI SERIE RDKI - FORI PASSANTI

From diam. 12,64 to 16,85 mm

Da diam. 12,64 a 16,85 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
12,64 - 13,50	1	RDKI-210-01264	RDKI-110-01264
	2	RDKI-220-01264	RDKI-120-01264
	3	RDKI-230-01264	RDKI-130-01264
13,45 - 14,45	1	RDKI-210-01345	RDKI-110-01345
	2	RDKI-220-01345	RDKI-120-01345
	3	RDKI-230-01345	RDKI-130-01345
14,25 - 15,25	1	RDKI-210-01425	RDKI-110-01425
	2	RDKI-220-01425	RDKI-120-01425
	3	RDKI-230-01425	RDKI-130-01425
15,05 - 16,05	1	RDKI-210-01505	RDKI-110-01505
	2	RDKI-220-01505	RDKI-120-01505
	3	RDKI-230-01505	RDKI-130-01505
15,85 - 16,85	1	RDKI-210-01585	RDKI-110-01585
	2	RDKI-220-01585	RDKI-120-01585
	3	RDKI-230-01585	RDKI-130-01585

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

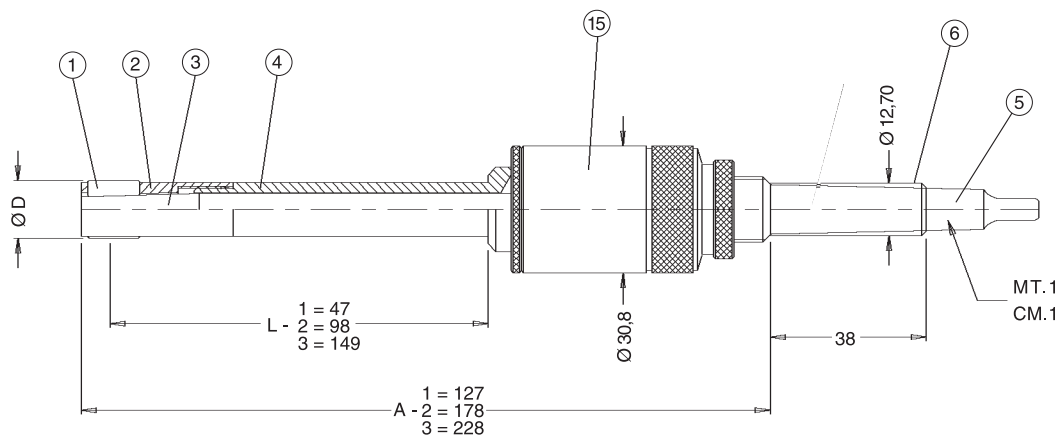
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO



From diam. 12,64 to 16,85 mm

Da diam. 12,64 a 16,85 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	<b>A</b> Basic assembly with Morse Taper shank Corpo base con attacco Cono Morse pos. 4+5+15	<b>A</b> Basic assembly with straight shank Corpo base con attacco cilindrico pos. 4+6+15	Cage sleeve Guidagabbia pos.4	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
12,64 - 13,50	1 2 3	RDWI-211-00000 RDWI-221-00000 RDWI-231-00000	RDWI-111-00000 RDWI-121-00000 RDWI-131-00000	RDAI-077-10000 RDAI-077-20000 RDAI-077-30000	RDCI-400-00500	RDTI-031-10032 RDTI-031-20032 RDTI-031-30032	RDRY-704-00156	5
13,45 - 14,45	1 2 3	RDWI-212-00000 RDWI-222-00000 RDWI-232-00000	RDWI-112-00000 RDWI-122-00000 RDWI-132-00000	RDAI-078-10000 RDAI-078-20000 RDAI-078-30000	RDCI-400-00531	RDTI-031-10034 RDTI-031-20034 RDTI-031-30034	RDRY-704-00172	
14,25 - 15,25					RDCI-400-00562			
15,05 - 16,05	1 2 3	RDWI-213-00000 RDWI-223-00000 RDWI-233-00000	RDWI-113-00000 RDWI-123-00000 RDWI-133-00000	RDAI-079-10000 RDAI-079-20000 RDAI-079-30000	RDCI-400-00593	RDTI-031-10038 RDTI-031-20038 RDTI-031-30038	RDRY-701-00187	
15,85 - 16,85					RDCI-400-00625			

Morse Taper shank / Attacco Cono Morse	pos.5	RDSH-042-10000
Straight shank / Attacco cilindrico	pos.6	RDSH-041-10000
Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-00000

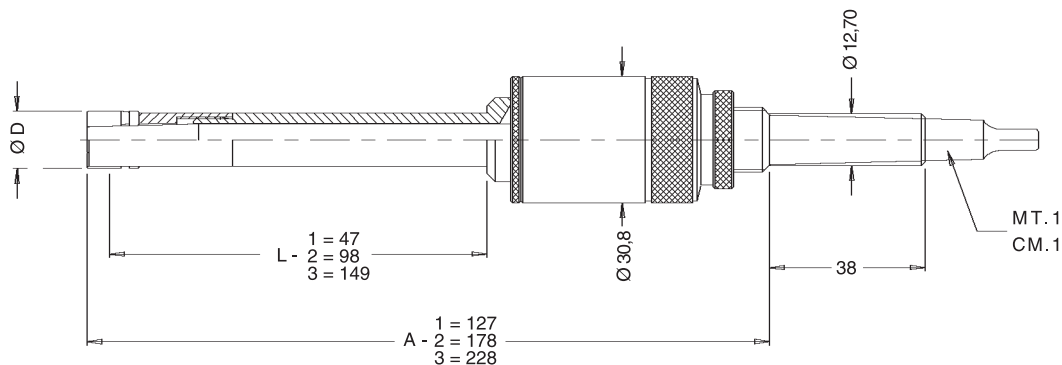
# ROLLER BURNISHING TOOLS

## RSKI - BLIND HOLES

### RULLATORI SERIE RSKI - FORI CIECHI

From diam. 12,64 to 16,85 mm

Da diam. 12,64 a 16,85 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code  
 N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank	Roller burnishing tool with straight shank
		Rullatore con attacco Cono Morse	Rullatore con attacco cilindrico
12,64 - 13,50	1	RSKI-210-xxxxx	RSKI-110-xxxxx
	2	RSKI-220-xxxxx	RSKI-120-xxxxx
	3	RSKI-230-xxxxx	RSKI-130-xxxxx
13,45 - 14,45	1	RSKI-210-xxxxx	RSKI-110-xxxxx
	2	RSKI-220-xxxxx	RSKI-120-xxxxx
	3	RSKI-230-xxxxx	RSKI-130-xxxxx
14,25 - 15,25	1	RSKI-210-xxxxx	RSKI-110-xxxxx
	2	RSKI-220-xxxxx	RSKI-120-xxxxx
	3	RSKI-230-xxxxx	RSKI-130-xxxxx
15,05 - 16,05	1	RSKI-210-xxxxx	RSKI-110-xxxxx
	2	RSKI-220-xxxxx	RSKI-120-xxxxx
	3	RSKI-230-xxxxx	RSKI-130-xxxxx
15,85 - 16,85	1	RSKI-210-xxxxx	RSKI-110-xxxxx
	2	RSKI-220-xxxxx	RSKI-120-xxxxx
	3	RSKI-230-xxxxx	RSKI-130-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
 e.g. Long series Roller burnishing tool Ø 14 mm with MT.1 shank: RSKI-230-01400

Numerazione che indica il diametro da rullare in centesimi  
 es. Rullatore Ø 14 attacco CM.1, serie lunga: RSKI-230-01400

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

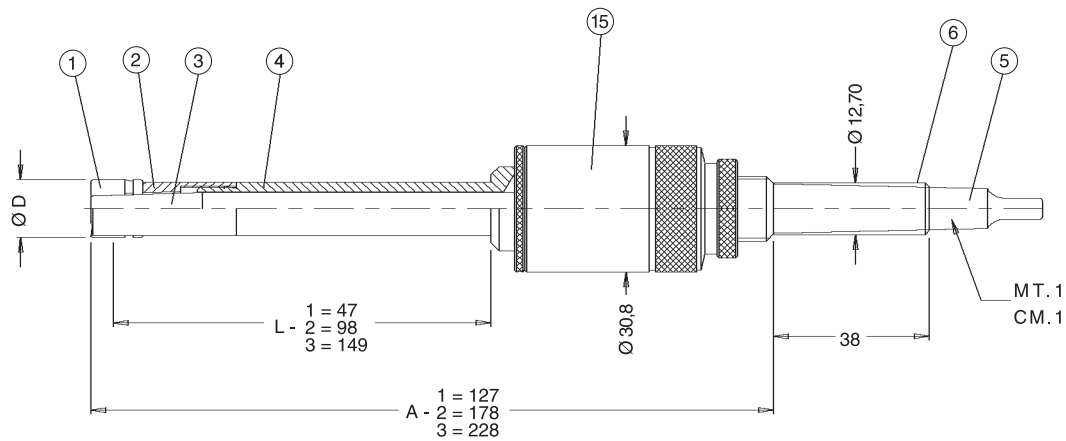
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
 THE OTHER SIDE  
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 A FIANCO

From diam. 12,64 to 16,85 mm

Da diam. 12,64 a 16,85 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	A		Cage sleeve Guidagabbia pos.4	B		C		D		Rolls qty / Qtà rulli
		Basic assembly with Morse Taper shank Corpo base con attacco Cono Morse pos. 4+5+15	Basic assembly with straight shank Corpo base con attacco cilindrico pos. 4+6+15		Cage Gabbia pos.2	Cone Asta pos.3	Rolls Rulli pos.1				
12,64 - 13,50	1	RDWI-211-00000	RDWI-111-00000	RDAI-077-10000	RSCI-400-00500	RSTI-03x-10032 RSTI-03x-20032 RSTI-03x-30032	RSRY-708-00156			5	
	2	RDWI-221-00000	RDWI-121-00000	RDAI-077-20000							
	3	RDWI-231-00000	RDWI-131-00000	RDAI-077-30000							
13,45 - 14,45	1	RDWI-212-00000	RDWI-112-00000	RDAI-078-10000	RSCI-400-00531	RSTI-03x-10034 RSTI-03x-20034 RSTI-03x-30034					
	2	RDWI-222-00000	RDWI-122-00000	RDAI-078-20000							
14,25 - 15,25	3	RDWI-232-00000	RDWI-132-00000	RDAI-078-30000	RSCI-400-00562						
15,05 - 16,05	1	RDWI-213-00000	RDWI-113-00000	RDAI-079-10000	RSCI-400-00593	RSTI-03x-10038 RSTI-03x-20038 RSTI-03x-30038	RSRY-708-00172				
	2	RDWI-223-00000	RDWI-123-00000	RDAI-079-20000							
15,85 - 16,85	3	RDWI-233-00000	RDWI-133-00000	RDAI-079-30000	RSCI-400-00625						

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

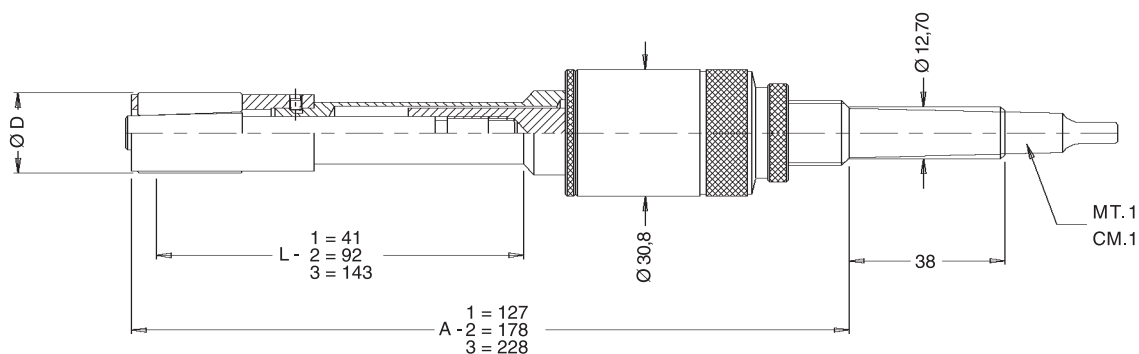
Morse Taper shank / Attacco Cono Morse	pos.5	RDSH-042-10000
Straight shank / Attacco cilindrico	pos.6	RDSH-041-10000
Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-00000



# ROLLER BURNISHING TOOLS SERIES RDKK - THROUGH HOLES RULLATORI SERIE RDKK - FORI PASSANTI

From diam. 16,60 to 24,74 mm

Da diam. 16,60 a 24,74 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
16,60 - 17,61	1	RDKK-210-01660	RDKK-110-01660
	2	RDKK-220-01660	RDKK-120-01660
	3	RDKK-230-01660	RDKK-130-01660
17,40 - 18,39	1	RDKK-210-01740	RDKK-110-01740
	2	RDKK-220-01740	RDKK-120-01740
	3	RDKK-230-01740	RDKK-130-01740
18,19 - 19,18	1	RDKK-210-01819	RDKK-110-01819
	2	RDKK-220-01819	RDKK-120-01819
	3	RDKK-230-01819	RDKK-130-01819
18,96 - 19,99	1	RDKK-210-01896	RDKK-110-01896
	2	RDKK-220-01896	RDKK-120-01896
	3	RDKK-230-01896	RDKK-130-01896
19,74 - 20,77	1	RDKK-210-01974	RDKK-110-01974
	2	RDKK-220-01974	RDKK-120-01974
	3	RDKK-230-01974	RDKK-130-01974
20,52 - 21,57	1	RDKK-210-02052	RDKK-110-02052
	2	RDKK-220-02052	RDKK-120-02052
	3	RDKK-230-02052	RDKK-130-02052
21,31 - 22,35	1	RDKK-210-02131	RDKK-110-02131
	2	RDKK-220-02131	RDKK-120-02131
	3	RDKK-230-02131	RDKK-130-02131
22,13 - 23,16	1	RDKK-210-02213	RDKK-110-02213
	2	RDKK-220-02213	RDKK-120-02213
	3	RDKK-230-02213	RDKK-130-02213
22,91 - 23,96	1	RDKK-210-02291	RDKK-110-02291
	2	RDKK-220-02291	RDKK-120-02291
	3	RDKK-230-02291	RDKK-130-02291
23,70 - 24,74	1	RDKK-210-02370	RDKK-110-02370
	2	RDKK-220-02370	RDKK-120-02370
	3	RDKK-230-02370	RDKK-130-02370

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

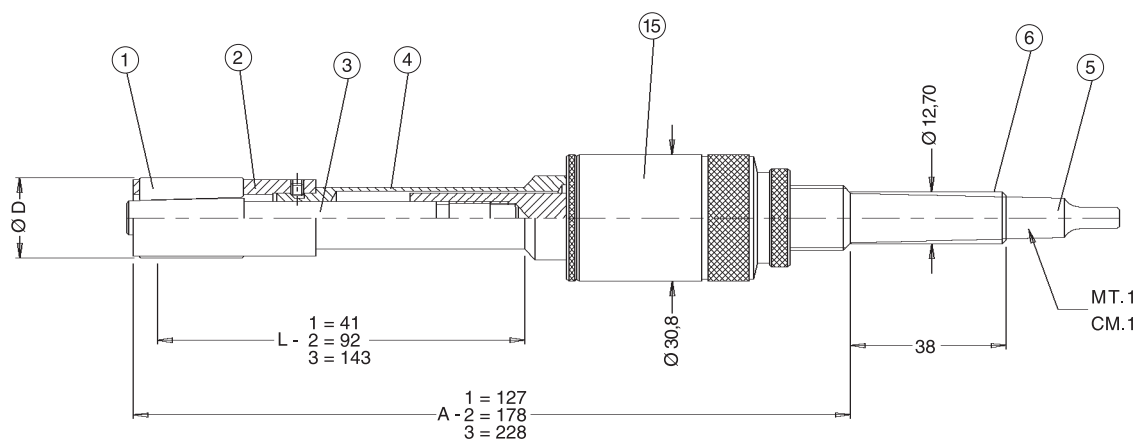
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 16,60 to 24,74 mm

Da diam. 16,60 a 24,74 mm



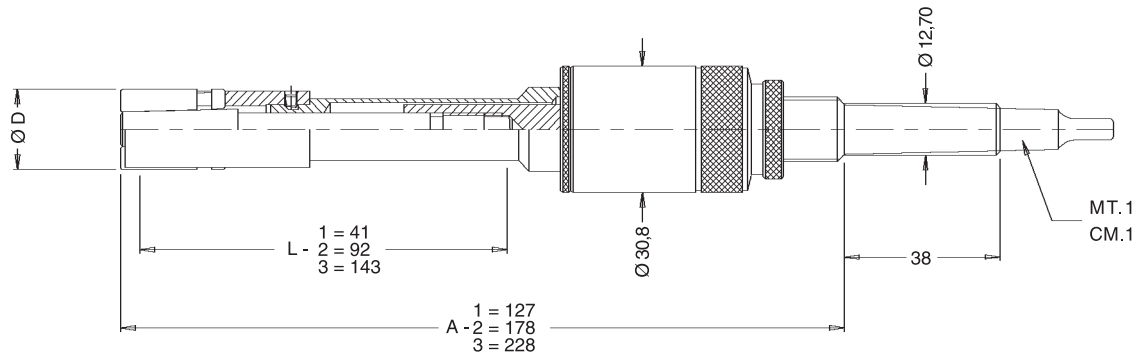
Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	Shank Attacco	Cage sleeve Guidagabbia pos.4	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
16,60 - 17,61	1 2 3	pos.5 RDSH-042-10000 RDSK-042-20000 RDSK-042-30000	RDAK-072-10000 RDAK-072-20000 RDAK-072-30000	RDCK-011-00042	RDTK-031-00042	RDRY-701-00187	5
17,40 - 18,39				RDCK-011-00044	RDTK-031-00044		
18,19 - 19,18				RDCK-011-00046	RDTK-031-00042		
18,96 - 19,99				RDCK-011-00048	RDTK-031-00044	RDRY-701-00218	
19,74 - 20,77				RDCK-011-00050	RDTK-031-00050		
20,52 - 21,57				RDCK-011-00052	RDTK-031-00052		
21,31 - 22,35				RDCK-011-00054	RDTK-031-00054		
22,13 - 23,16				RDCK-011-00056	RDTK-031-00050	RDRY-701-00265	
22,91 - 23,96				RDCK-011-00058	RDTK-031-00052		
23,70 - 24,74				RDCK-011-00060	RDTK-031-00054		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	L=1	RDWK-210-00000
			L=2	RDWK-220-00000
			L=3	RDWK-230-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	L=1	RDWK-110-00000
			L=2	RDWK-120-00000
			L=3	RDWK-130-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15		RDGH-182-00000

# ROLLER BURNISHING TOOLS SERIES RSKK - BLIND HOLES RULLATORI SERIE RSKK - FORI CIECHI

From diam. 16,60 to 24,74 mm

Da diam. 16,60 a 24,74 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
16,60 - 17,61	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
17,40 - 18,39	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
18,19 - 19,18	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
18,96 - 19,99	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
19,74 - 20,77	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
20,52 - 21,57	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
21,31 - 22,35	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
22,13 - 23,16	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
22,91 - 23,96	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx
23,70 - 24,74	1	RSKK-210-xxxxx	RSKK-110-xxxxx
	2	RSKK-220-xxxxx	RSKK-120-xxxxx
	3	RSKK-230-xxxxx	RSKK-130-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Standard series Roller burnishing tool Ø 20 mm straight shank: RSKK-120-02000

Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 20 attacco cilindrico, serie standard: RSKK-120-02000

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

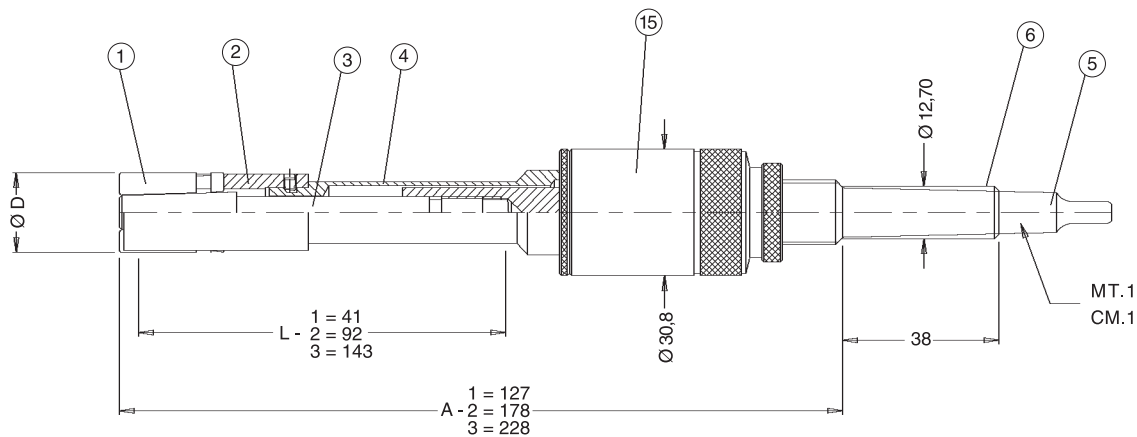
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO

From diam. 16,60 to 24,74 mm

Da diam. 16,60 a 24,74 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	Shank Attacco	Cage sleeve Guidagabbia pos.4	<b>B</b>	<b>C</b>	<b>D</b>	Rolls qty / Qtà rulli
				Cage Gabbia pos.2	Cone Asta pos.3	Rolls Rulli pos.1	
16,60 - 17,61	1 2 3	pos.5 RDSH-042-10000 RDSK-042-20000 RDSK-042-30000	RDAK-072-10000 RDAK-072-20000 RDAK-072-30000	RSCK-015-00042	RSTK-03x-00042	RSRY-708-00187	5
17,40 - 18,39				RSCK-015-00044	RSTK-03x-00044		
18,19 - 19,18				RSCK-015-00046	RSTK-03x-00042		
18,96 - 19,99				RSCK-015-00048	RSTK-03x-00044	RSRY-708-00218	
19,74 - 20,77				RSCK-015-00050	RSTK-03x-00050		
20,52 - 21,57				RSCK-015-00052	RSTK-03x-00052		
21,31 - 22,35				RSCK-015-00054	RSTK-03x-00054		
22,13 - 23,16				RSCK-015-00056	RSTK-03x-00050	RSRY-708-00265	
22,91 - 23,96				RSCK-015-00058	RSTK-03x-00052		
23,70 - 24,74				RSCK-015-00060	RSTK-03x-00054		

x=A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	L=1	RDWK-210-00000
			L=2	RDWK-220-00000
			L=3	RDWK-230-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	L=1	RDWK-110-00000
			L=2	RDWK-120-00000
			L=3	RDWK-130-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15		RDGH-182-00000



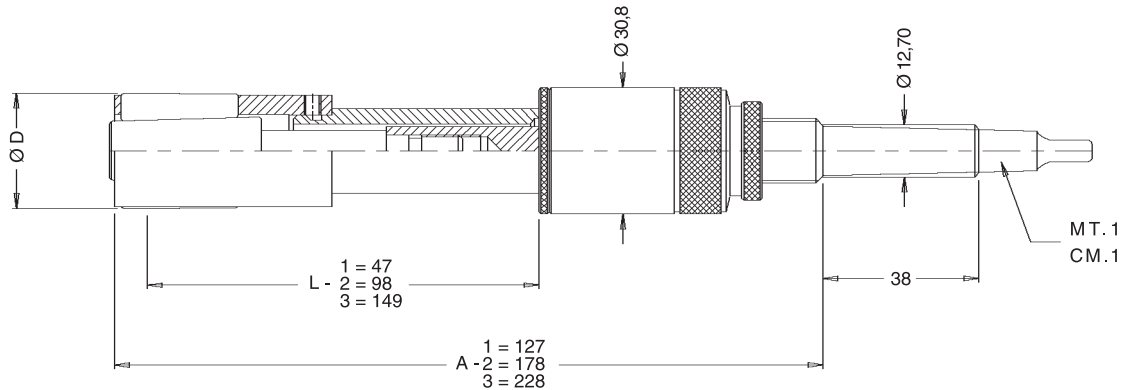
# ROLLER BURNISHING TOOLS

## SERIES RDKL - THROUGH HOLES

### RULLATORI SERIE RDKL - FORI PASSANTI

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code  
 N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
24,54 - 25,59	1	RDKL-210-02454	RDKL-110-02454
	2	RDKL-220-02454	RDKL-120-02454
	3	RDKL-230-02454	RDKL-130-02454
25,38 - 26,42	1	RDKL-210-02538	RDKL-110-02538
	2	RDKL-220-02538	RDKL-120-02538
	3	RDKL-230-02538	RDKL-130-02538
26,16 - 27,20	1	RDKL-210-02616	RDKL-110-02616
	2	RDKL-220-02616	RDKL-120-02616
	3	RDKL-230-02616	RDKL-130-02616
26,95 - 28,00	1	RDKL-210-02695	RDKL-110-02695
	2	RDKL-220-02695	RDKL-120-02695
	3	RDKL-230-02695	RDKL-130-02695
27,73 - 28,77	1	RDKL-210-02773	RDKL-110-02773
	2	RDKL-220-02773	RDKL-120-02773
	3	RDKL-230-02773	RDKL-130-02773
28,55 - 29,59	1	RDKL-210-02855	RDKL-110-02855
	2	RDKL-220-02855	RDKL-120-02855
	3	RDKL-230-02855	RDKL-130-02855
29,34 - 30,39	1	RDKL-210-02934	RDKL-110-02934
	2	RDKL-220-02934	RDKL-120-02934
	3	RDKL-230-02934	RDKL-130-02934
30,12 - 31,16	1	RDKL-210-03012	RDKL-110-03012
	2	RDKL-220-03012	RDKL-120-03012
	3	RDKL-230-03012	RDKL-130-03012

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

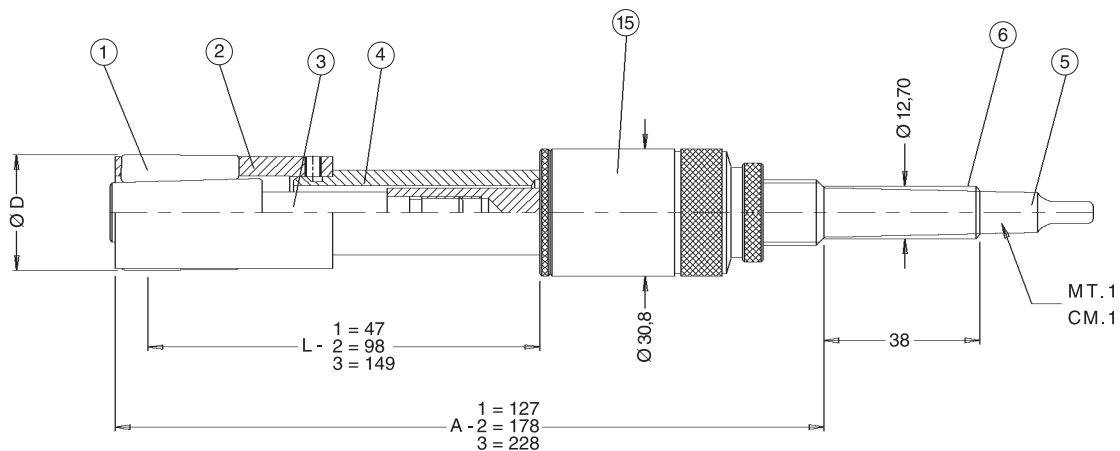
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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## RICAMBI SERIE RDKL

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



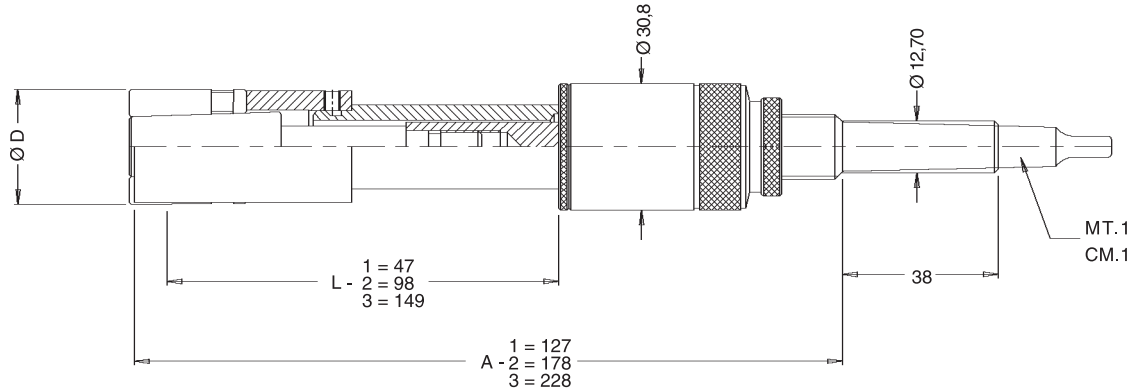
Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	Shank Attacco	Cage sleeve Guidagabbia pos.4	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qty rulli	
24,54 - 25,59	1 2 3	pos.5 RDSH-042-10000 RDSK-042-20000 RDSK-042-30000 pos.6 RDSH-041-10000 RDSK-041-20000 RDSK-041-30000	RDAL-072-10000 RDAL-072-20000 RDAL-072-30000	RDCL-011-00062	RDTL-031-00062	RDRY-701-00265	5	
25,38 - 26,42				RDCL-011-00064	RDTL-031-00064		7	
26,16 - 27,20				RDCL-011-00066	RDTL-031-00066			
26,95 - 28,00						RDCL-011-00068	RDTL-031-00068	
27,73 - 28,77						RDCL-011-00070	RDTL-031-00070	
28,55 - 29,59						RDCL-011-00072	RDTL-031-00066	
29,34 - 30,39						RDCL-011-00074	RDTL-031-00068	RDRY-701-00312
30,12 - 31,16						RDCL-011-00076	RDTL-031-00070	

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	L=1	RDWL-210-00000
			L=2	RDWL-220-00000
			L=3	RDWL-230-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	L=1	RDWL-110-00000
			L=2	RDWL-120-00000
			L=3	RDWL-130-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15		RDGH-182-00000

# ROLLER BURNISHING TOOLS SERIES RSKL - BLIND HOLES RULLATORI SERIE RSKL - FORI CIECHI

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



NB- To order the tool with the Ø 12 cylindrical shank, add "/12" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 12 aggiungere "/12" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura L	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
24,54 - 25,59	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
25,38 - 26,42	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
26,16 - 27,20	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
26,95 - 28,00	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
27,73 - 28,77	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
28,55 - 29,59	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
29,34 - 30,39	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx
30,12 - 31,16	1	RSKL-210-xxxxx	RSKL-110-xxxxx
	2	RSKL-220-xxxxx	RSKL-120-xxxxx
	3	RSKL-230-xxxxx	RSKL-130-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Short series Roller burnishing tool Ø 27,50 mm with MT.1 shank: RSKL-210-02750  
Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 27,50 attacco CM.1, serie corta: RSKL-210-02750

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

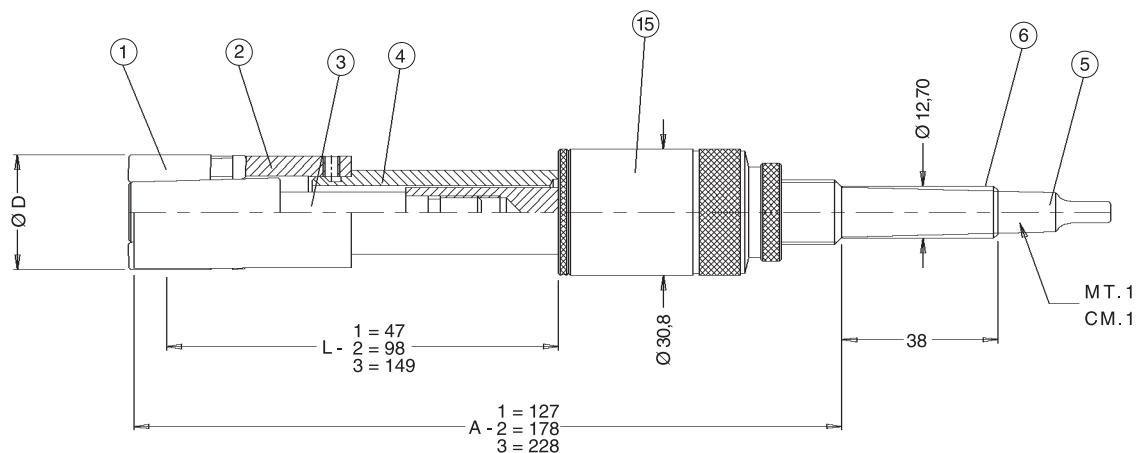
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

## RICAMBI SERIE RSKL

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



Adjustment range Campo di regolazione ØD min. max.	Burnishing length Lunghezza rullatura	Shank Attacco	Cage sleeve Guidagabbia pos.4	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli	
24,54 - 25,59	1 2 3	pos.5 RDSH-042-10000 RDSK-042-20000 RDSK-042-30000	RDAL-072-10000 RDAL-072-20000 RDAL-072-30000	RSCL-015-00062	RSTL-03x-00062	RSRY-708-00265	5	
25,38 - 26,42				RSCL-015-00064	RSTL-03x-00064			
26,16 - 27,20				RSCL-015-00066	RSTL-03x-00066			
26,95 - 28,00				RSCL-015-00068	RSTL-03x-00068			
27,73 - 28,77				pos.6 RDSH-041-10000 RDSK-041-20000 RDSK-041-30000	RSCL-015-00070	RSTL-03x-00070		RSRY-708-00312
28,55 - 29,59				RSCL-015-00072	RSTL-03x-00066			
29,34 - 30,39				RSCL-015-00074	RSTL-03x-00068			
30,12 - 31,16				RSCL-015-00076	RSTL-03x-00070			

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	L=1	RDWL-210-00000
			L=2	RDWL-220-00000
			L=3	RDWL-230-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	L=1	RDWL-110-00000
			L=2	RDWL-120-00000
			L=3	RDWL-130-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15		RDGH-182-00000



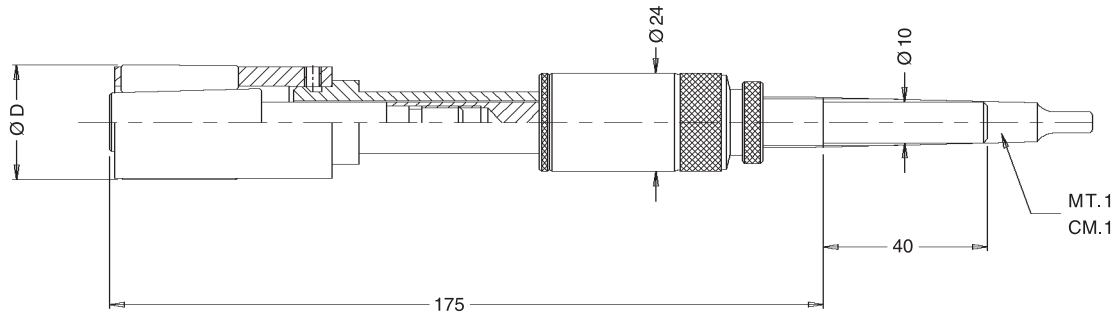
# ROLLER BURNISHING TOOLS

## SERIES RDKF - THROUGH HOLES

### RULLATORI SERIE RDKF - FORI PASSANTI

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
24,54 - 25,59	RDKF-200-02454	RDKF-100-02454
25,38 - 26,42	RDKF-200-02538	RDKF-100-02538
26,16 - 27,20	RDKF-200-02616	RDKF-100-02616
26,95 - 28,00	RDKF-200-02695	RDKF-100-02695
27,73 - 28,77	RDKF-200-02773	RDKF-100-02773
28,55 - 29,59	RDKF-200-02855	RDKF-100-02855
29,34 - 30,39	RDKF-200-02934	RDKF-100-02934
30,12 - 31,16	RDKF-200-03012	RDKF-100-03012

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

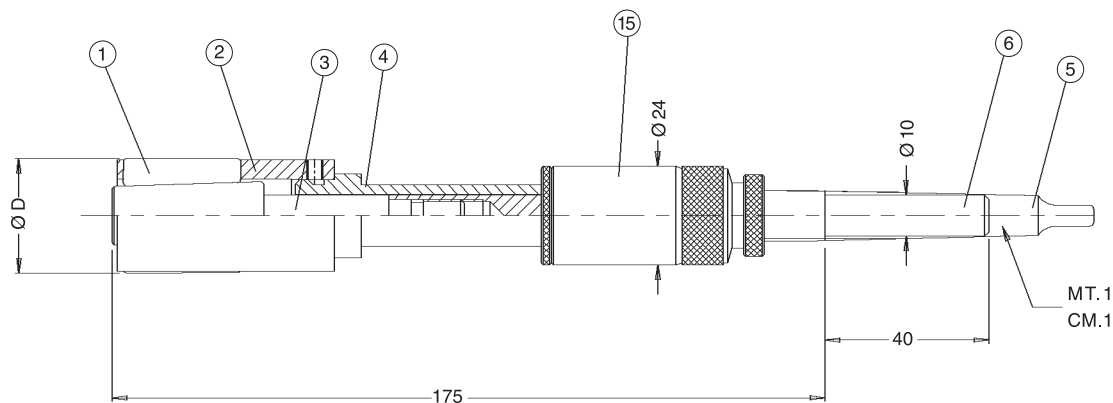
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	24,54 - 25,59	RDCL-011-00062	RDTF-031-00062	
25,38 - 26,42	RDCL-011-00064	RDTF-031-00064	7	
26,16 - 27,20	RDCL-011-00066	RDTF-031-00066		
26,95 - 28,00	RDCL-011-00068	RDTF-031-00068		
27,73 - 28,77	RDCL-011-00070	RDTF-031-00070		
28,55 - 29,59	RDCL-011-00072	RDTF-031-00066	RDRY-701-00312	
29,34 - 30,39	RDCL-011-00074	RDTF-031-00068		
30,12 - 31,16	RDCL-011-00076	RDTF-031-00070		

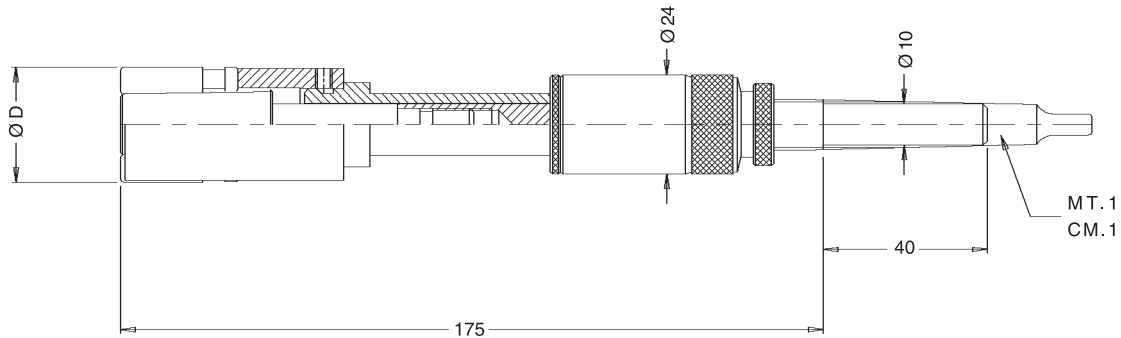
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWF-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWF-120-00000
	MT. shank / Attacco CM	pos.5	RDSF-042-20000
	Straight shank / Attacco cilindrico	pos.6	RDSF-041-20000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGF-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAF-072-20000

# ROLLER BURNISHING TOOLS SERIES RSKF - BLIND HOLES

## RULLATORI SERIE RSKF - FORI CIECHI

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
24,54 - 25,59	RSKF-200-xxxxx	RSKF-100-xxxxx
25,38 - 26,42	RSKF-200-xxxxx	RSKF-100-xxxxx
26,16 - 27,20	RSKF-200-xxxxx	RSKF-100-xxxxx
26,95 - 28,00	RSKF-200-xxxxx	RSKF-100-xxxxx
27,73 - 28,77	RSKF-200-xxxxx	RSKF-100-xxxxx
28,55 - 29,59	RSKF-200-xxxxx	RSKF-100-xxxxx
29,34 - 30,39	RSKF-200-xxxxx	RSKF-100-xxxxx
30,12 - 31,16	RSKF-200-xxxxx	RSKF-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 27 mm with MT.1 shank: RSKF-200-02700  
Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 27 attacco CM.1: RSKF-200-02700

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

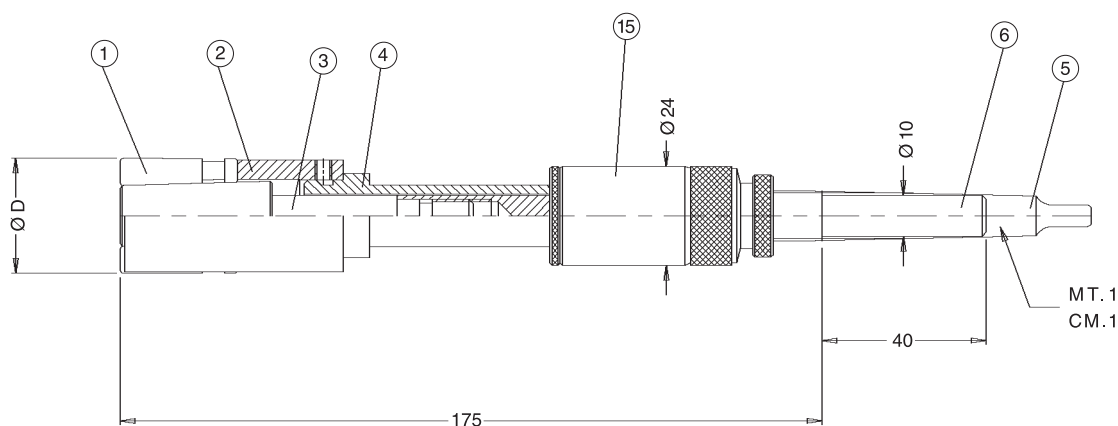
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 24,54 to 31,16 mm

Da diam. 24,54 a 31,16 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	24,54 - 25,59	RSCL-015-00062	RSTF-03x-00062	
25,38 - 26,42	RSCL-015-00064	RSTF-03x-00064		
26,16 - 27,20	RSCL-015-00066	RSTF-03x-00066		
26,95 - 28,00	RSCL-015-00068	RSTF-03x-00068		
27,73 - 28,77	RSCL-015-00070	RSTF-03x-00070		
28,55 - 29,59	RSCL-015-00072	RSTF-03x-00066	RSRY-708-00312	5
29,34 - 30,39	RSCL-015-00074	RSTF-03x-00068		
30,12 - 31,16	RSCL-015-00076	RSTF-03x-00070		

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

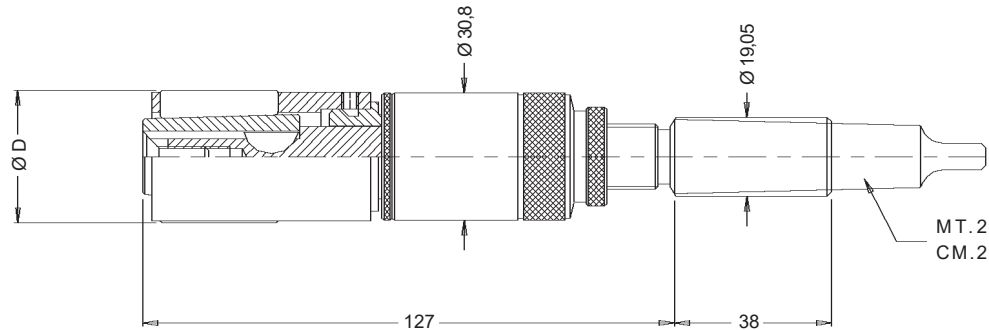
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWF-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWF-120-00000
	MT. shank / Attacco CM	pos.5	RDSF-042-20000
	Straight shank / Attacco cilindrico	pos.6	RDSF-041-20000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGF-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAF-072-20000



# ROLLER BURNISHING TOOLS SERIES RDKM - THROUGH HOLES RULLATORI SERIE RDKM - FORI PASSANTI

From diam. 30,85 to 35,86 mm

Da diam. 30,85 a 35,86 mm



NB- To order the tool with the Ø 16 cylindrical shank, add "/16" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 16 aggiungere "/16" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
30,85 - 31,90	RDKM-200-03085	RDKM-100-03085
31,67 - 32,71	RDKM-200-03167	RDKM-100-03167
32,44 - 33,47	RDKM-200-03244	RDKM-100-03244
33,24 - 34,29	RDKM-200-03324	RDKM-100-03324
34,05 - 35,09	RDKM-200-03405	RDKM-100-03405
34,83 - 35,86	RDKM-200-03483	RDKM-100-03483

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

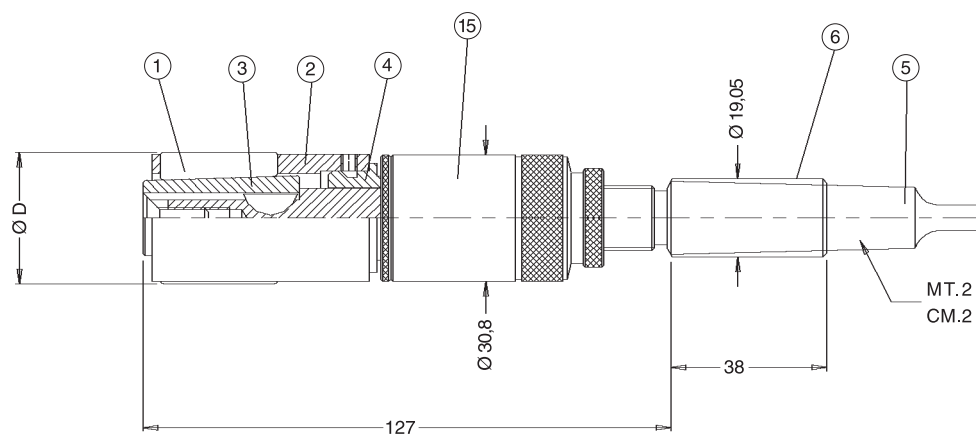
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 30,85 to 35,86 mm

Da diam. 30,85 a 35,86 mm



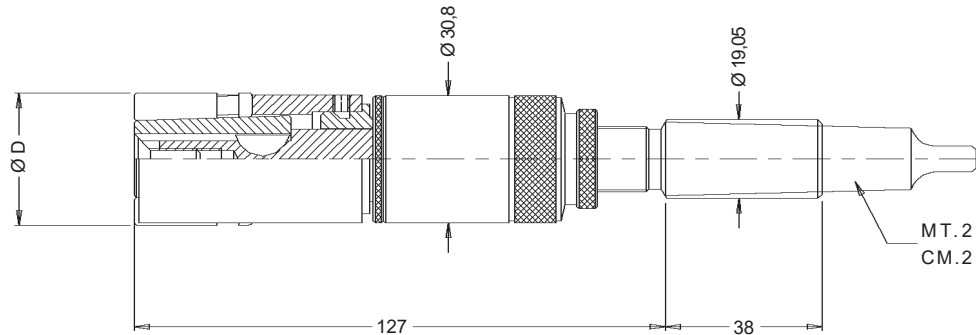
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	30,85 - 31,90	RDCM-011-00078	RDTM-031-00078	
31,67 - 32,71	RDCM-011-00080	RDTM-031-00080		
32,44 - 33,47	RDCM-011-00082	RDTM-031-00082		
33,24 - 34,29	RDCM-011-00084	RDTM-031-00078	RDRY-701-00312	
34,05 - 35,09	RDCM-011-00086	RDTM-031-00080		
34,83 - 35,86	RDCM-011-00088	RDTM-031-00082		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWM-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWM-100-00000
	MT. shank / Attacco CM	pos.5	RDSM-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSM-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAM-073-00000

# ROLLER BURNISHING TOOLS SERIES RSKM - BLIND HOLES RULLATORI SERIE RSKM - FORI CIECHI

From diam. 30,85 to 35,86 mm

Da diam. 30,85 a 35,86 mm



NB- To order the tool with the Ø 16 cylindrical shank, add "/16" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 16 aggiungere "/16" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
30,85 - 31,90	RSKM-200-xxxxx	RSKM-100-xxxxx
31,67 - 32,71	RSKM-200-xxxxx	RSKM-100-xxxxx
32,44 - 33,47	RSKM-200-xxxxx	RSKM-100-xxxxx
33,24 - 34,29	RSKM-200-xxxxx	RSKM-100-xxxxx
34,05 - 35,09	RSKM-200-xxxxx	RSKM-100-xxxxx
34,83 - 35,86	RSKM-200-xxxxx	RSKM-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 35 mm with MT.2 shank: RSKM-200-03500

Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 35 attacco CM.2: RSKM-200-03500

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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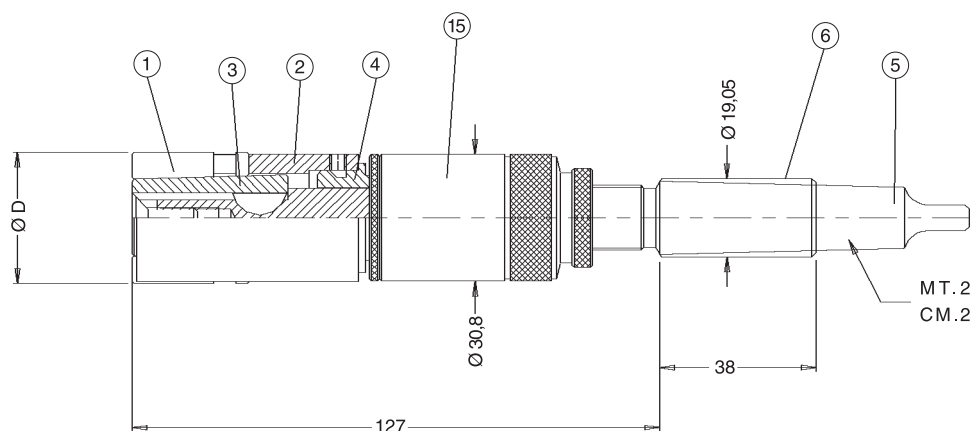
# SPARE PARTS SERIES RSKM

## RICAMBI SERIE RSKM

S.C.A.M.I.®

From diam. 30,85 to 35,86 mm

Da diam. 30,85 a 35,86 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	30,85 - 31,90	RSCM-015-00078	RSTM-03x-00078	
31,67 - 32,71	RSCM-015-00080	RSTM-03x-00080		
32,44 - 33,47	RSCM-015-00082	RSTM-03x-00082		
33,24 - 34,29	RSCM-015-00084	RSTM-03x-00078	RSRY-708-00312	
34,05 - 35,09	RSCM-015-00086	RSTM-03x-00080		
34,83 - 35,86	RSCM-015-00088	RSTM-03x-00082		

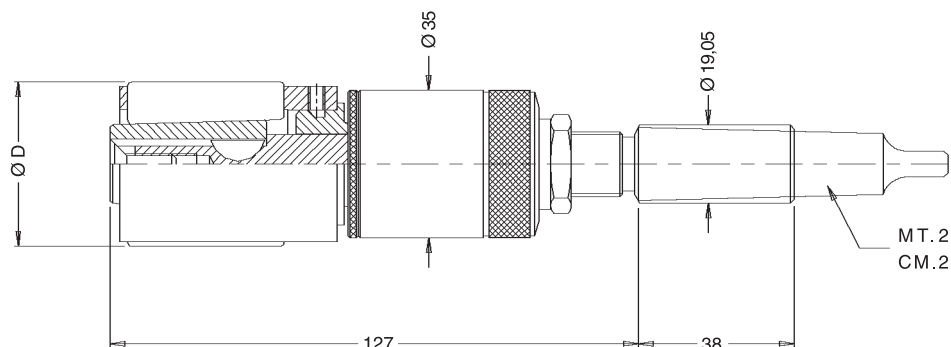
x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished.  
 For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare.  
 Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWM-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWM-100-00000
	MT. shank / Attacco CM	pos.5	RDSM-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSM-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAM-073-00000

# ROLLER BURNISHING TOOLS SERIES RDKN - THROUGH HOLES RULLATORI SERIE RDKN - FORI PASSANTI

From diam. 35,61 to 46,97 mm

Da diam. 35,61 a 46,97 mm



NB- To order the tool with the Ø 16 cylindrical shank, add "/16" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 16 aggiungere "/16" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
35,61 - 36,66	RDKN-200-03561	RDKN-100-03561
36,40 - 37,44	RDKN-200-03640	RDKN-100-03640
37,18 - 38,23	RDKN-200-03718	RDKN-100-03718
38,00 - 39,04	RDKN-200-03800	RDKN-100-03800
38,79 - 39,82	RDKN-200-03879	RDKN-100-03879
39,57 - 40,62	RDKN-200-03957	RDKN-100-03957
40,36 - 41,40	RDKN-200-04036	RDKN-100-04036
41,18 - 42,21	RDKN-200-04118	RDKN-100-04118
41,96 - 43,01	RDKN-200-04196	RDKN-100-04196
42,75 - 43,79	RDKN-200-04275	RDKN-100-04275
43,53 - 44,58	RDKN-200-04353	RDKN-100-04353
44,35 - 45,39	RDKN-200-04435	RDKN-100-04435
45,14 - 46,17	RDKN-200-04514	RDKN-100-04514
45,92 - 46,97	RDKN-200-04592	RDKN-100-04592

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

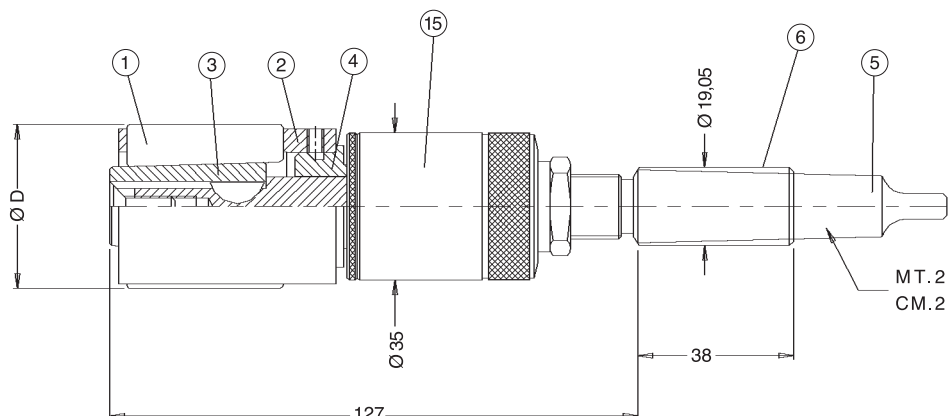
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO



From diam. 35,61 to 46,97 mm

Da diam. 35,61 a 46,97 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
35,61 - 36,66	RDCN-011-00090	RDTN-031-00090	RDRY-701-00312	7
36,40 - 37,44	RDCN-011-00092	RDTN-031-00092		
37,18 - 38,23	RDCN-011-00094	RDTN-031-00094		
38,00 - 39,04	RDCN-011-00096	RDTN-031-00096		
38,79 - 39,82	RDCN-011-00098	RDTM-031-00080	RDRY-701-00406	
39,57 - 40,62	RDCN-011-00100	RDTM-031-00082		
40,36 - 41,40	RDCN-011-00102	RDTN-031-00090		
41,18 - 42,21	RDCN-011-00104	RDTN-031-00092		
41,96 - 43,01	RDCN-011-00106	RDTN-031-00094		
42,75 - 43,79	RDCN-011-00108	RDTM-031-00082	RDRY-701-00468	
43,53 - 44,58	RDCN-011-00110	RDTN-031-00090		
44,35 - 45,39	RDCN-011-00112	RDTN-031-00092		
45,14 - 46,17	RDCN-011-00114	RDTN-031-00094		
45,92 - 46,97	RDCN-011-00116	RDTN-031-00096		

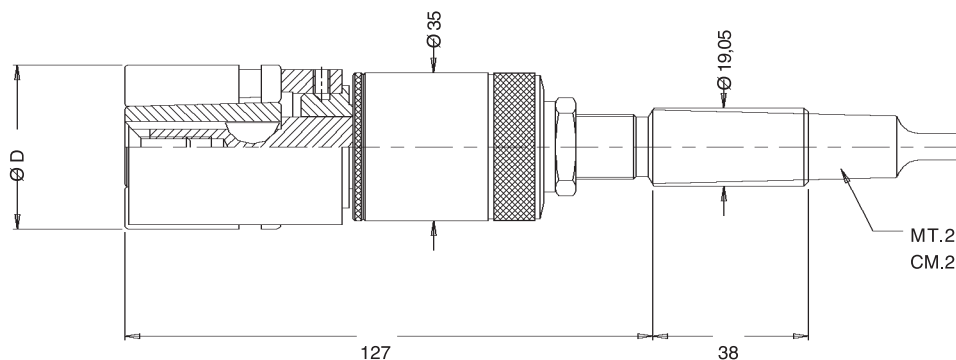
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWN-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWN-100-00000
	MT. shank / Attacco CM	pos.5	RDSM-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDS-041-00000
	Adjustment housing assembly / Boccia di registrazione	pos.15	RDGH-182-08033
	Cage sleeve / Guidagabbia	pos.4	RDAN-073-00000

# ROLLER BURNISHING TOOLS SERIES RSKN - BLIND HOLES

## RULLATORI SERIE RSKN - FORI CIECHI

From diam. 35,61 to 46,97 mm

Da diam. 35,61 a 46,97 mm



NB- To order the tool with the Ø 16 cylindrical shank, add "/16" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 16 aggiungere "/16" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
	35,61 - 36,66	RSKN-200-xxxxx
36,40 - 37,44	RSKN-200-xxxxx	RSKN-100-xxxxx
37,18 - 38,23	RSKN-200-xxxxx	RSKN-100-xxxxx
38,00 - 39,04	RSKN-200-xxxxx	RSKN-100-xxxxx
38,79 - 39,82	RSKN-200-xxxxx	RSKN-100-xxxxx
39,57 - 40,62	RSKN-200-xxxxx	RSKN-100-xxxxx
40,36 - 41,40	RSKN-200-xxxxx	RSKN-100-xxxxx
41,18 - 42,21	RSKN-200-xxxxx	RSKN-100-xxxxx
41,96 - 43,01	RSKN-200-xxxxx	RSKN-100-xxxxx
42,75 - 43,79	RSKN-200-xxxxx	RSKN-100-xxxxx
43,53 - 44,58	RSKN-200-xxxxx	RSKN-100-xxxxx
44,35 - 45,39	RSKN-200-xxxxx	RSKN-100-xxxxx
45,14 - 46,17	RSKN-200-xxxxx	RSKN-100-xxxxx
45,92 - 46,97	RSKN-200-xxxxx	RSKN-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.

e.g. Roller burnishing tool Ø 40 mm with straight shank: RSKN-100-04000

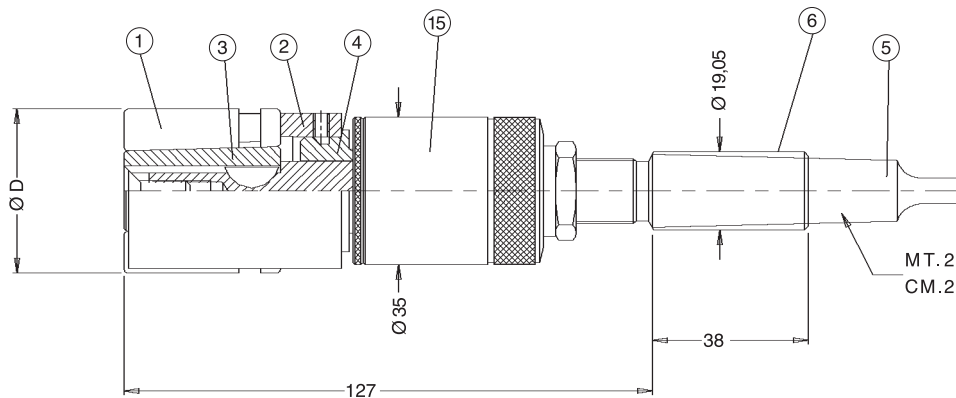
Numerazione che indica il diametro da rullare in centesimi

es. Rullatore Ø 40 attacco cilindrico: RSKN-100-04000

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D****A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulliSEE PAGE ON  
THE OTHER SIDE  
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A FIANCO

From diam. 35,61 to 46,97 mm

Da diam. 35,61 a 46,97 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
35,61 - 36,66	RSCN-015-00090	RSTN-03x-00090	RSRY-708-00312	5
36,40 - 37,44	RSCN-015-00092	RSTN-03x-00092		
37,18 - 38,23	RSCN-015-00094	RSTN-03x-00094		
38,00 - 39,04	RSCN-015-00096	RSTN-03x-00096		
38,79 - 39,82	RSCN-015-00098	RSTM-03x-00080	RSRY-708-00406	
39,57 - 40,62	RSCN-015-00100	RSTM-03x-00082		
40,36 - 41,40	RSCN-015-00102	RSTN-03x-00090		
41,18 - 42,21	RSCN-015-00104	RSTN-03x-00092		
41,96 - 43,01	RSCN-015-00106	RSTN-03x-00094	RSRY-708-00468	
42,75 - 43,79	RSCN-015-00108	RSTM-03x-00082		
43,53 - 44,58	RSCN-015-00110	RSTN-03x-00090		
44,35 - 45,39	RSCN-015-00112	RSTN-03x-00092		
45,14 - 46,17	RSCN-015-00114	RSTN-03x-00094		
45,92 - 46,97	RSCN-015-00116	RSTN-03x-00096		

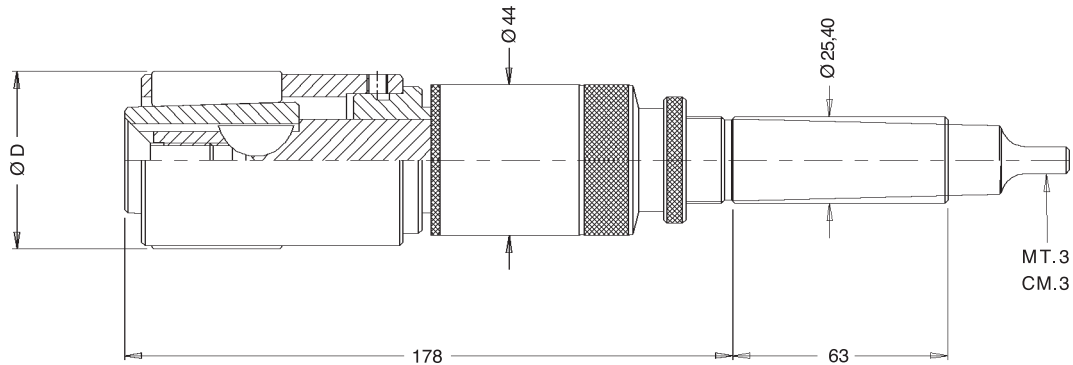
x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWN-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWN-100-00000
	MT. shank / Attacco CM	pos.5	RDSM-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSM-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGH-182-08033
	Cage sleeve / Guidagabbia	pos.4	RDAN-073-00000

# ROLLER BURNISHING TOOLS SERIES RDKO - THROUGH HOLES RULLATORI SERIE RDKO - FORI PASSANTI

From diam. 46,71 to 56,49 mm

Da diam. 46,71 a 56,49 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
46,71 - 47,75	RDKO-200-04671	RDKO-100-04671
47,53 - 48,56	RDKO-200-04753	RDKO-100-04753
48,31 - 49,36	RDKO-200-04831	RDKO-100-04837
49,10 - 50,14	RDKO-200-04910	RDKO-100-04910
49,88 - 50,93	RDKO-200-04988	RDKO-100-04988
50,70 - 51,74	RDKO-200-05070	RDKO-100-05070
51,49 - 52,53	RDKO-200-05149	RDKO-100-05149
52,27 - 53,32	RDKO-200-05227	RDKO-100-05227
53,06 - 54,10	RDKO-200-05306	RDKO-100-05306
53,87 - 54,91	RDKO-200-05387	RDKO-100-05387
54,66 - 55,71	RDKO-200-05466	RDKO-100-05466
55,45 - 56,49	RDKO-200-05545	RDKO-100-05545

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

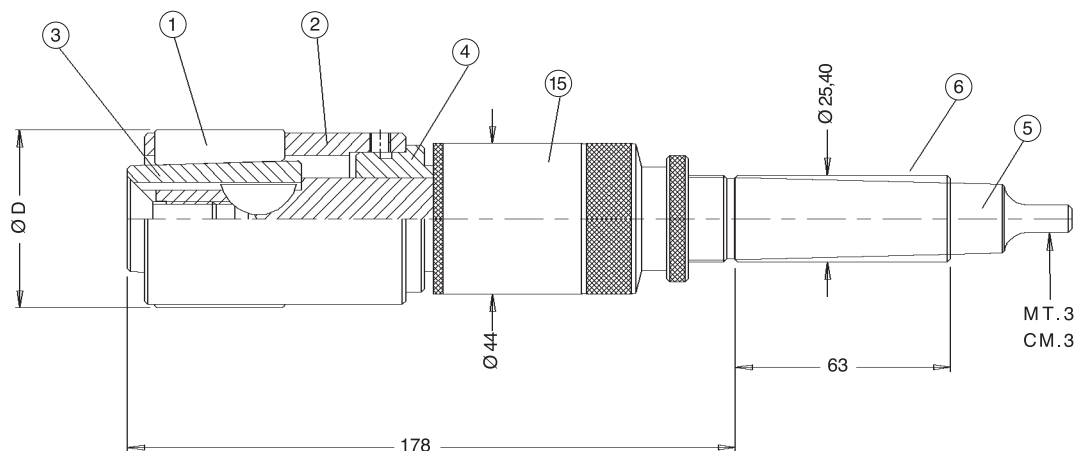
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 46,71 to 56,49 mm

Da diam. 46,71 a 56,49 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	46,71 - 47,75	RDCO-011-00118	RDTO-031-00118	
47,53 - 48,56	RDCO-011-00120	RDTO-031-00120		
48,31 - 49,36	RDCO-011-00122	RDTO-031-00122		
49,10 - 50,14	RDCO-011-00124	RDTO-031-00124		
49,88 - 50,93	RDCO-011-00126	RDTO-031-00126		
50,70 - 51,74	RDCO-011-00128	RDTO-031-00128		
51,49 - 52,53	RDCO-011-00130	RDTO-031-00118	RDRY-701-00406	
52,27 - 53,32	RDCO-011-00132	RDTO-031-00120		
53,06 - 54,10	RDCO-011-00134	RDTO-031-00122		
53,87 - 54,91	RDCO-011-00136	RDTO-031-00124		
54,66 - 55,71	RDCO-011-00138	RDTO-031-00126		
55,45 - 56,49	RDCO-011-00140	RDTO-031-00128		

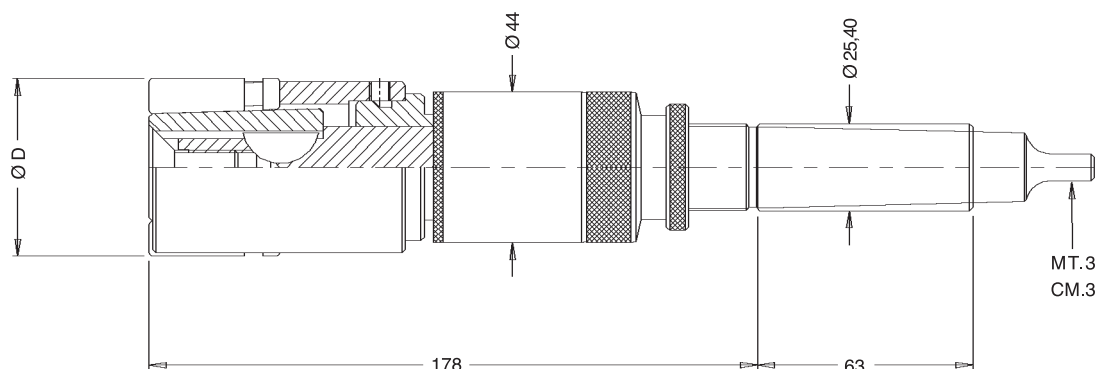
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWO-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWO-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAO-073-00000



# ROLLER BURNISHING TOOLS SERIES RSKO - BLIND HOLES RULLATORI SERIE RSKO - FORI CIECHI

From diam. 46,71 to 56,49 mm

Da diam. 46,71 a 56,49 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
	46,71 - 47,75	RSKO-200-xxxxx
47,53 - 48,56	RSKO-200-xxxxx	RSKO-100-xxxxx
48,31 - 49,36	RSKO-200-xxxxx	RSKO-100-xxxxx
49,10 - 50,14	RSKO-200-xxxxx	RSKO-100-xxxxx
49,88 - 50,93	RSKO-200-xxxxx	RSKO-100-xxxxx
50,70 - 51,74	RSKO-200-xxxxx	RSKO-100-xxxxx
51,49 - 52,53	RSKO-200-xxxxx	RSKO-100-xxxxx
52,27 - 53,32	RSKO-200-xxxxx	RSKO-100-xxxxx
53,06 - 54,10	RSKO-200-xxxxx	RSKO-100-xxxxx
53,87 - 54,91	RSKO-200-xxxxx	RSKO-100-xxxxx
54,66 - 55,71	RSKO-200-xxxxx	RSKO-100-xxxxx
55,45 - 56,49	RSKO-200-xxxxx	RSKO-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 50,25 mm with MT.3 shank: RSKO-200-05025  
Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 50,25 attacco CM.3: RSKO-200-05025

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

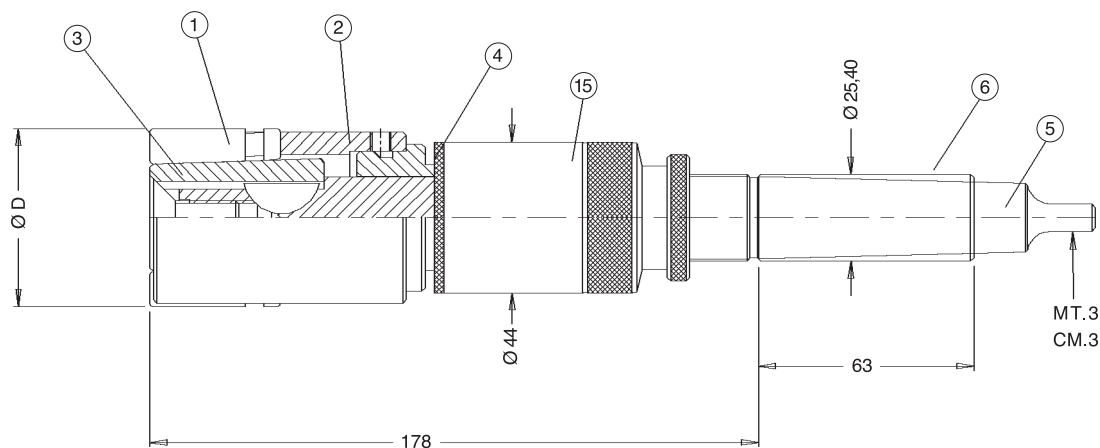
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO

From diam. 46,71 to 56,49 mm

Da diam. 46,71 a 56,49 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
46,71 - 47,75	RSCO-015-00118	RSTO-03x-00118	RSRY-708-00312	7
47,53 - 48,56	RSCO-015-00120	RSTO-03x-00120		
48,31 - 49,36	RSCO-015-00122	RSTO-03x-00122		
49,10 - 50,14	RSCO-015-00124	RSTO-03x-00124		
49,88 - 50,93	RSCO-015-00126	RSTO-03x-00126		
50,70 - 51,74	RSCO-015-00128	RSTO-03x-00128		
51,49 - 52,53	RSCO-015-00130	RSTO-03x-00118	RSRY-708-00406	
52,27 - 53,32	RSCO-015-00132	RSTO-03x-00120		
53,06 - 54,10	RSCO-015-00134	RSTO-03x-00122		
53,87 - 54,91	RSCO-015-00136	RSTO-03x-00124		
54,66 - 55,71	RSCO-015-00138	RSTO-03x-00126		
55,45 - 56,49	RSCO-015-00140	RSTO-03x-00128		

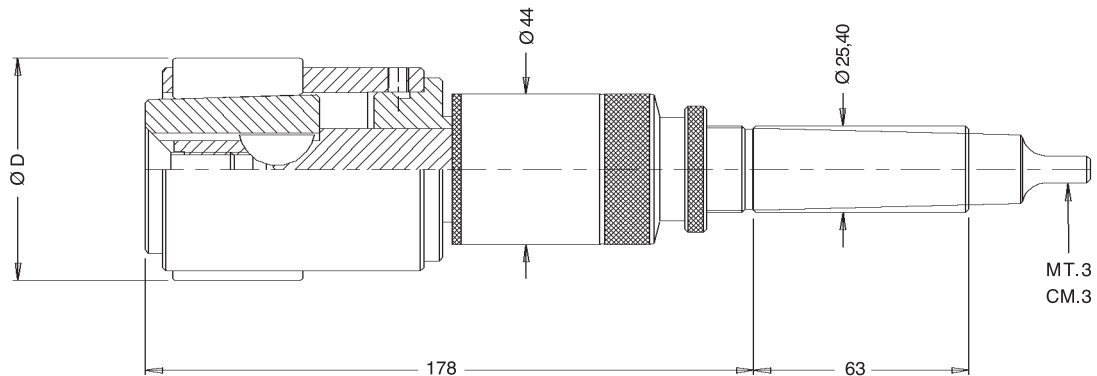
x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6  
 Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWO-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWO-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAO-073-00000

# ROLLER BURNISHING TOOLS SERIES RDKP - THROUGH HOLES RULLATORI SERIE RDKP - FORI PASSANTI

From diam. 56,23 to 69,19 mm

Da diam. 56,23 a 69,19 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
56,23 - 57,28	RDKP-200-05623	RDKP-100-05623
57,05 - 58,09	RDKP-200-05705	RDKP-100-05705
57,84 - 58,87	RDKP-200-05784	RDKP-100-05784
58,62 - 59,67	RDKP-200-05862	RDKP-100-05862
59,41 - 60,45	RDKP-200-05941	RDKP-100-05941
60,23 - 61,26	RDKP-200-06023	RDKP-100-06023
61,01 - 62,06	RDKP-200-06101	RDKP-100-06101
61,80 - 62,84	RDKP-200-06180	RDKP-100-06180
62,58 - 63,63	RDKP-200-06258	RDKP-100-06258
63,40 - 64,44	RDKP-200-06340	RDKP-100-06340
64,19 - 65,22	RDKP-200-06419	RDKP-100-06419
64,97 - 66,02	RDKP-200-06497	RDKP-100-06497
65,76 - 66,80	RDKP-200-06576	RDKP-100-06576
66,58 - 67,61	RDKP-200-06658	RDKP-100-06658
67,36 - 68,41	RDKP-200-06736	RDKP-100-06736
68,15 - 69,19	RDKP-200-06815	RDKP-100-06815

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

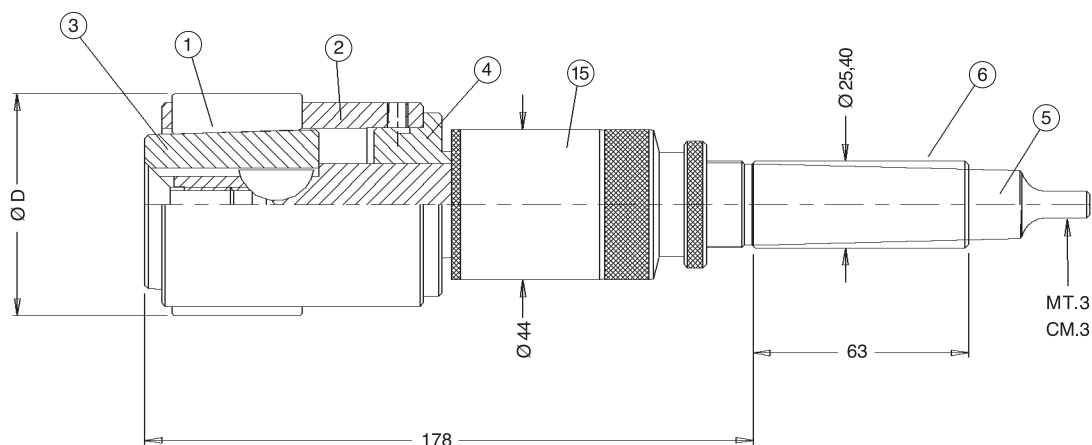
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO

From diam. 56,23 to 69,19 mm

Da diam. 56,23 a 69,19 mm



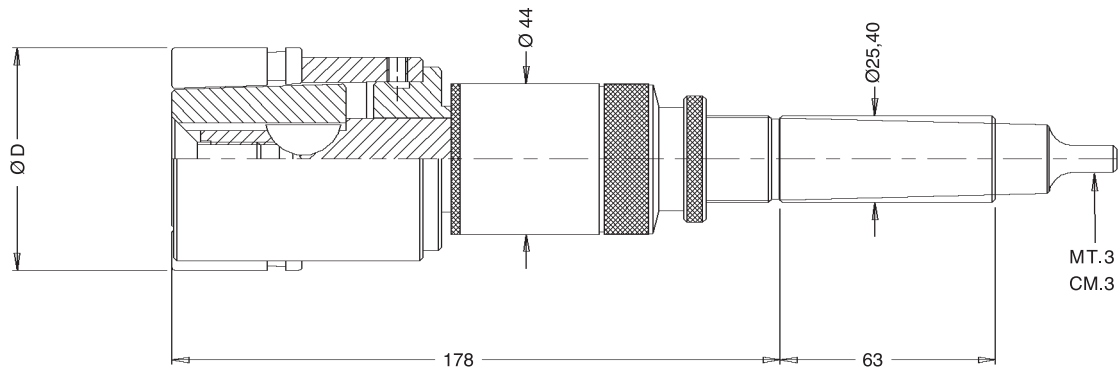
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
56,23 - 57,28	RDCP-011-00142	RDTP-031-00142	RDRY-701-00406	9
57,05 - 58,09	RDCP-011-00144	RDTP-031-00144		
57,84 - 58,87	RDCP-011-00146	RDTP-031-00146		
58,62 - 59,67	RDCP-011-00148	RDT P-031-00148		
59,41 - 60,45	RDCP-011-00150	RDTP-031-00142	RDRY-701-00468	
60,23 - 61,26	RDCP-011-00152	RDTP-031-00144		
61,01 - 62,06	RDCP-011-00154	RDTP-031-00146		
61,80 - 62,84	RDCP-011-00156	RDTP-031-00148		
62,58 - 63,63	RDCP-011-00158	RDTP-031-00158		
63,40 - 64,44	RDCP-011-00160	RDTP-031-00160		
64,19 - 65,22	RDCP-011-00162	RDTP-031-00162	RDRY-701-00531	
64,97 - 66,02	RDCP-011-00164	RDTP-031-00164		
65,76 - 66,80	RDCP-011-00166	RDTP-031-00158		
66,58 - 67,61	RDCP-011-00168	RDTP-031-00160		
67,36 - 68,41	RDCP-011-00170	RDTP-031-00162		
68,15 - 69,19	RDCP-011-00172	RDTP-031-00164		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWP-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWP-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAP-073-00000

# ROLLER BURNISHING TOOLS SERIES RSKP - BLIND HOLES RULLATORI SERIE RSKP - FORI CIECHI

From diam. 56,23 to 69,19 mm

Da diam. 56,23 a 69,19 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
56,23 - 57,28	RSKP-200-xxxxx	RSKP-100-xxxxx
57,05 - 58,09	RSKP-200-xxxxx	RSKP-100-xxxxx
57,84 - 58,87	RSKP-200-xxxxx	RSKP-100-xxxxx
58,62 - 59,67	RSKP-200-xxxxx	RSKP-100-xxxxx
59,41 - 60,45	RSKP-200-xxxxx	RSKP-100-xxxxx
60,23 - 61,26	RSKP-200-xxxxx	RSKP-100-xxxxx
61,01 - 62,06	RSKP-200-xxxxx	RSKP-100-xxxxx
61,80 - 62,84	RSKP-200-xxxxx	RSKP-100-xxxxx
62,58 - 63,63	RSKP-200-xxxxx	RSKP-100-xxxxx
63,40 - 64,44	RSKP-200-xxxxx	RSKP-100-xxxxx
64,19 - 65,22	RSKP-200-xxxxx	RSKP-100-xxxxx
64,97 - 66,02	RSKP-200-xxxxx	RSKP-100-xxxxx
65,76 - 66,80	RSKP-200-xxxxx	RSKP-100-xxxxx
66,58 - 67,61	RSKP-200-xxxxx	RSKP-100-xxxxx
67,36 - 68,41	RSKP-200-xxxxx	RSKP-100-xxxxx
68,15 - 69,19	RSKP-200-xxxxx	RSKP-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 60,05 mm with straight shank: RSKP-100-06005  
Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 60,05 attacco cilindrico: RSKP-100-06005

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

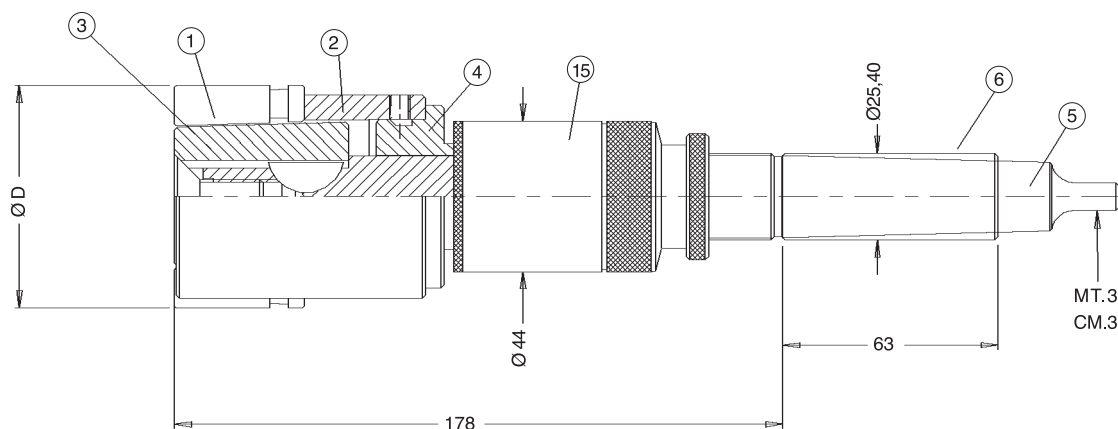
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO



From diam. 56,23 to 69,19 mm

Da diam. 56,23 a 69,19 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b>   Cage Gabbia pos.2	<b>C</b>   Cone Asta pos.3	<b>D</b>   Rolls Rulli pos.1	Rolls qty / Qtà rulli
	56,23 - 57,28	RSCP-015-00142	RSTP-03x-00142	
57,05 - 58,09	RSCP-015-00144	RSTP-03x-00144		
57,84 - 58,87	RSCP-015-00146	RSTP-03x-00146		
58,62 - 59,67	RSCP-015-00148	RSTP-03x-00148		
59,41 - 60,45	RSCP-015-00150	RSTP-03x-00142	RSRY-708-00468	
60,23 - 61,26	RSCP-015-00152	RSTP-03x-00144		
61,01 - 62,06	RSCP-015-00154	RSTP-03x-00146		
61,80 - 62,84	RSCP-015-00156	RSTP-03x-00148		
62,58 - 63,63	RSCP-015-00158	RSTP-03x-00158		
63,40 - 64,44	RSCP-015-00160	RSTP-03x-00160		
64,19 - 65,22	RSCP-015-00162	RSTP-03x-00162	RSRY-708-00531	
64,97 - 66,02	RSCP-015-00164	RSTP-03x-00164		
65,76 - 66,80	RSCP-015-00166	RSTP-03x-00158		
66,58 - 67,61	RSCP-015-00168	RSTP-03x-00160		
67,36 - 68,41	RSCP-015-00170	RSTP-03x-00162		
68,15 - 69,19	RSCP-015-00172	RSTP-03x-00164		

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6

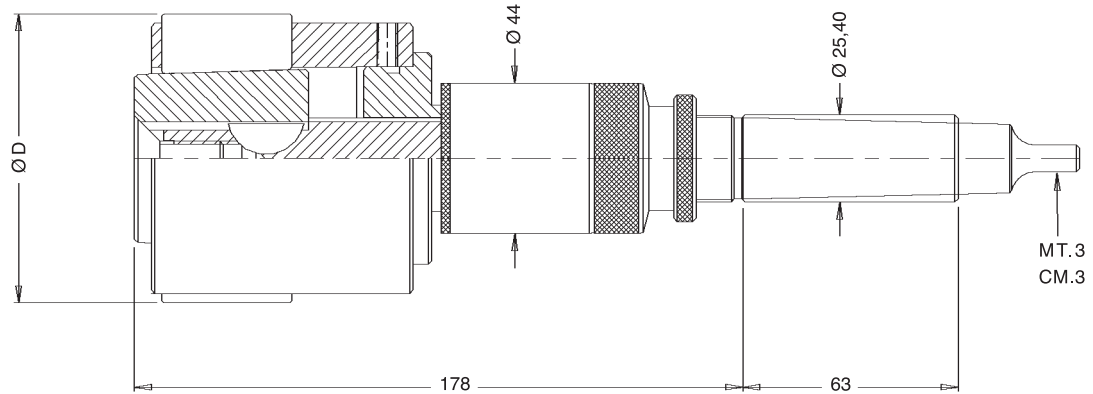
Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWP-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWP-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAP-073-00000

# ROLLER BURNISHING TOOLS SERIES RDKQ - THROUGH HOLES RULLATORI SERIE RDKQ - FORI PASSANTI

From diam. 68,93 to 85,07 mm

Da diam. 68,93 a 85,07 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
68,93 - 69,98	RDKQ-200-06893	RDKQ-100-06893	76,89 - 77,93	RDKQ-200-07689	RDKQ-100-07689
69,75 - 70,79	RDKQ-200-06975	RDKQ-100-06975	77,67 - 78,72	RDKQ-200-07767	RDKQ-100-07767
70,54 - 71,57	RDKQ-200-07054	RDKQ-100-07054	78,46 - 79,50	RDKQ-200-07846	RDKQ-100-07846
71,32 - 72,40	RDKQ-200-07132	RDKQ-100-07132	79,27 - 80,31	RDKQ-200-07927	RDKQ-100-07927
72,11 - 73,15	RDKQ-200-07211	RDKQ-100-07211	80,06 - 81,11	RDKQ-200-08006	RDKQ-100-08006
72,93 - 73,96	RDKQ-200-07293	RDKQ-100-07293	80,85 - 81,89	RDKQ-200-08085	RDKQ-100-08085
73,71 - 74,75	RDKQ-200-07371	RDKQ-100-07371	81,63 - 82,68	RDKQ-200-08163	RDKQ-100-08163
74,50 - 75,54	RDKQ-200-07450	RDKQ-100-07450	82,45 - 83,49	RDKQ-200-08245	RDKQ-100-08245
75,28 - 76,33	RDKQ-200-07528	RDKQ-100-07528	83,24 - 84,27	RDKQ-200-08324	RDKQ-100-08324
76,10 - 77,14	RDKQ-200-07610	RDKQ-100-07610	84,02 - 85,07	RDKQ-200-08402	RDKQ-100-08402

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

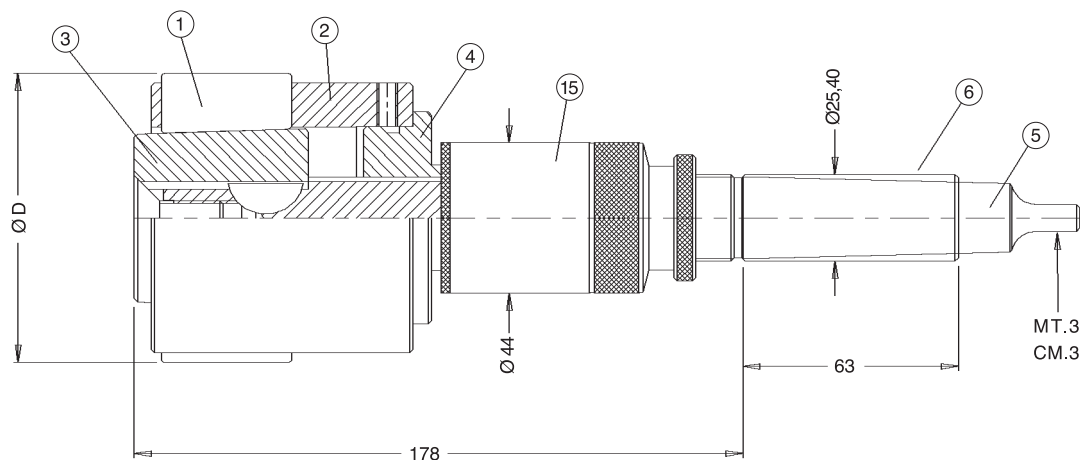
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 68,93 to 85,07 mm

Da diam. 68,93 a 85,07 mm



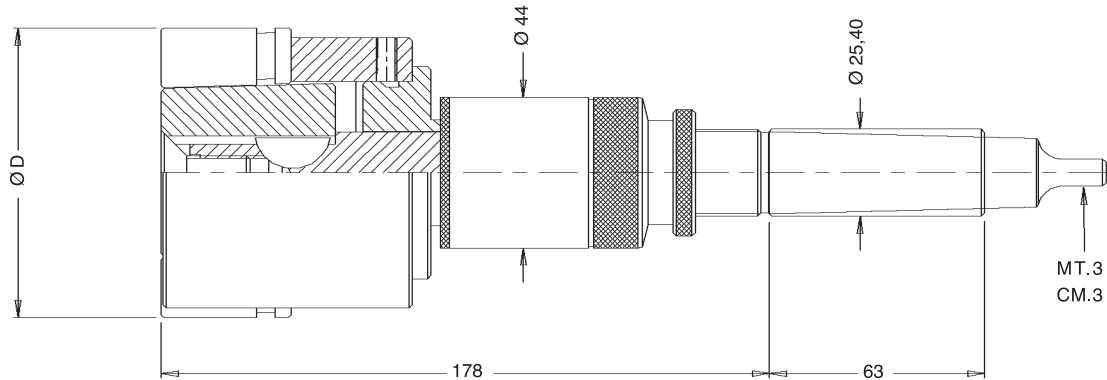
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty Qtà rulli
68,93 - 69,98	RDCQ-011-00174	RDTQ-031-00174	RDRY-701-00531	9
69,75 - 70,79	RDCQ-011-00176	RDTQ-031-00176		
70,54 - 71,57	RDCQ-011-00178	RDTQ-031-00178		
71,32 - 72,40	RDCQ-011-00180	RDTQ-031-00180		
72,11 - 73,15	RDCQ-011-00182	RDTQ-031-00182		
72,93 - 73,96	RDCQ-011-00184	RDTQ-031-00184	RDRY-701-00625	
73,71 - 74,75	RDCQ-011-00186	RDTQ-031-00174		
74,50 - 75,54	RDCQ-011-00188	RDTQ-031-00176		
75,28 - 76,33	RDCQ-011-00190	RDTQ-031-00178		
76,10 - 77,14	RDCQ-011-00192	RDTQ-031-00180		
76,89 - 77,93	RDCQ-011-00194	RDTQ-031-00182		
77,67 - 78,72	RDCQ-011-00196	RDTQ-031-00184		
78,46 - 79,50	RDCQ-011-00198	RDTQ-031-00198		
79,27 - 80,31	RDCQ-011-00200	RDTQ-031-00200	RDRY-701-00687	
80,06 - 81,11	RDCQ-011-00202	RDTQ-031-00202		
80,85 - 81,89	RDCQ-011-00204	RDTQ-031-00204		
81,63 - 82,68	RDCQ-011-00206	RDTQ-031-00198		
82,45 - 83,49	RDCQ-011-00208	RDTQ-031-00200		
83,24 - 84,27	RDCQ-011-00210	RDTQ-031-00202		
84,02 - 85,07	RDCQ-011-00212	RDTQ-031-00204		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWQ-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWQ-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDQA-073-00000

# ROLLER BURNISHING TOOLS SERIES RSKQ - BLIND HOLES RULLATORI SERIE RSKQ - FORI CIECHI

From diam. 68,93 to 85,07 mm

Da diam. 68,93 a 85,07 mm



NB- To order the tool with the Ø 25 cylindrical shank, add "/25" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 25 aggiungere "/25" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
68,93 - 69,98	RSKQ-200-xxxxx	RSKQ-100-xxxxx	76,89 - 77,93	RSKQ-200-xxxxx	RSKQ-100-xxxxx
69,75 - 70,79	RSKQ-200-xxxxx	RSKQ-100-xxxxx	77,67 - 78,72	RSKQ-200-xxxxx	RSKQ-100-xxxxx
70,54 - 71,57	RSKQ-200-xxxxx	RSKQ-100-xxxxx	78,46 - 79,50	RSKQ-200-xxxxx	RSKQ-100-xxxxx
71,32 - 72,40	RSKQ-200-xxxxx	RSKQ-100-xxxxx	79,27 - 80,31	RSKQ-200-xxxxx	RSKQ-100-xxxxx
72,11 - 73,15	RSKQ-200-xxxxx	RSKQ-100-xxxxx	80,06 - 81,11	RSKQ-200-xxxxx	RSKQ-100-xxxxx
72,93 - 73,96	RSKQ-200-xxxxx	RSKQ-100-xxxxx	80,85 - 81,89	RSKQ-200-xxxxx	RSKQ-100-xxxxx
73,71 - 74,75	RSKQ-200-xxxxx	RSKQ-100-xxxxx	81,63 - 82,68	RSKQ-200-xxxxx	RSKQ-100-xxxxx
74,50 - 75,54	RSKQ-200-xxxxx	RSKQ-100-xxxxx	82,45 - 83,49	RSKQ-200-xxxxx	RSKQ-100-xxxxx
75,28 - 76,33	RSKQ-200-xxxxx	RSKQ-100-xxxxx	83,24 - 84,27	RSKQ-200-xxxxx	RSKQ-100-xxxxx
76,10 - 77,14	RSKQ-200-xxxxx	RSKQ-100-xxxxx	84,02 - 85,07	RSKQ-200-xxxxx	RSKQ-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 75 mm with MT.3 shank: RSKQ-200-07500

Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 75 attacco CM.3: RSKQ-200-07500

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

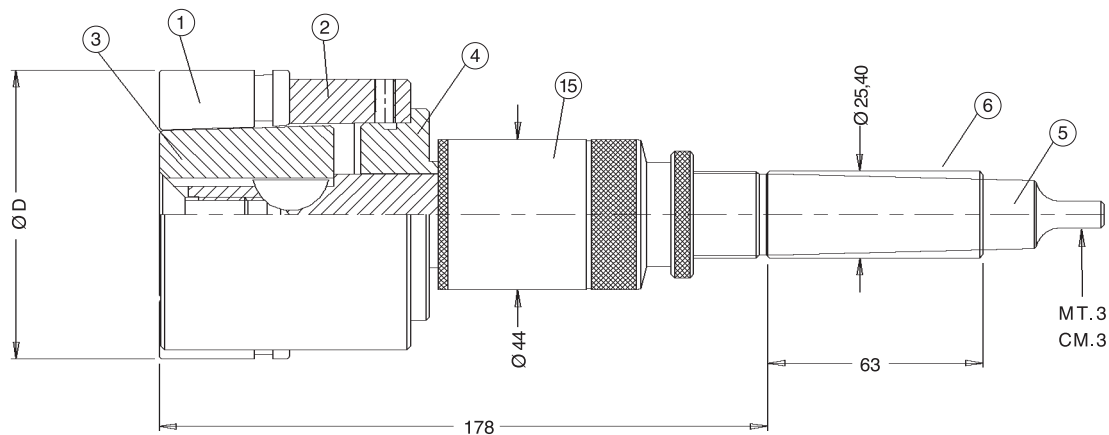
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

From diam. 68,93 to 85,07 mm

Da diam. 68,93 a 85,07 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty Qtà rulli
68,93 - 69,98	RSCQ-015-00174	RSTQ-03x-00174	RSRY-708-00531	7
69,75 - 70,79	RSCQ-015-00176	RSTQ-03x-00176		
70,54 - 71,57	RSCQ-015-00178	RSTQ-03x-00178		
71,32 - 72,40	RSCQ-015-00180	RSTQ-03x-00180		
72,11 - 73,15	RSCQ-015-00182	RSTQ-03x-00182		
72,93 - 73,96	RSCQ-015-00184	RSTQ-03x-00184		
73,71 - 74,75	RSCQ-015-00186	RSTQ-03x-00174	RSRY-708-00625	
74,50 - 75,54	RSCQ-015-00188	RSTQ-03x-00176		
75,28 - 76,33	RSCQ-015-00190	RSTQ-03x-00178		
76,10 - 77,14	RSCQ-015-00192	RSTQ-03x-00180		
76,89 - 77,93	RSCQ-015-00194	RSTQ-03x-00182		
77,67 - 78,72	RSCQ-015-00196	RSTQ-03x-00184		
78,46 - 79,50	RSCQ-015-00198	RSTQ-03x-00198	RSRY-708-00687	
79,27 - 80,31	RSCQ-015-00200	RSTQ-03x-00200		
80,06 - 81,11	RSCQ-015-00202	RSTQ-03x-00202		
80,85 - 81,89	RSCQ-015-00204	RSTQ-03x-00204		
81,63 - 82,68	RSCQ-015-00206	RSTQ-03x-00198		
82,45 - 83,49	RSCQ-015-00208	RSTQ-03x-00200		
83,24 - 84,27	RSCQ-015-00210	RSTQ-03x-00202		
84,02 - 85,07	RSCQ-015-00212	RSTQ-03x-00204		

x= A number in the range from 2 to 8 depending upon the exact diameter to be finished. For the correct identification of "x" value go to page 6

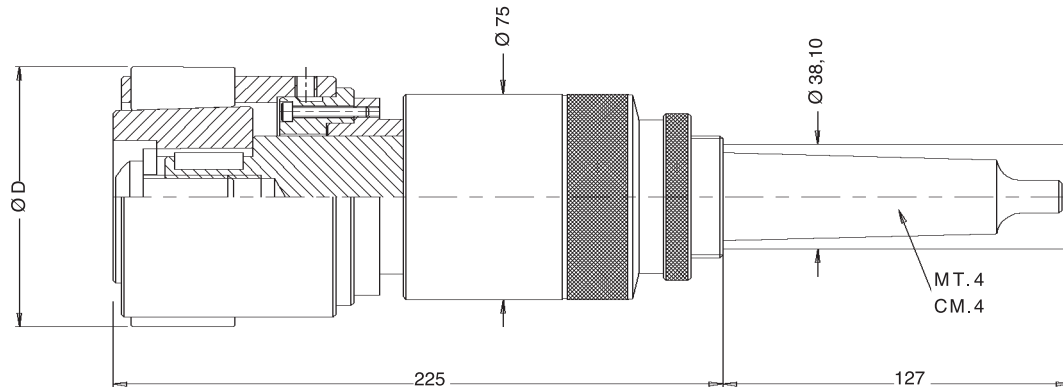
Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWQ-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWQ-100-00000
	MT. shank / Attacco CM	pos.5	RDSO-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSO-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGO-182-00000
	Cage sleeve / Guidagabbia	pos.4	RDAQ-073-00000

# ROLLER BURNISHING TOOLS SERIES RDKR - THROUGH HOLES RULLATORI SERIE RDKR - FORI PASSANTI

From diam. 84,81 to 104,12 mm

Da diam. 84,81 a 104,12 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code

N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

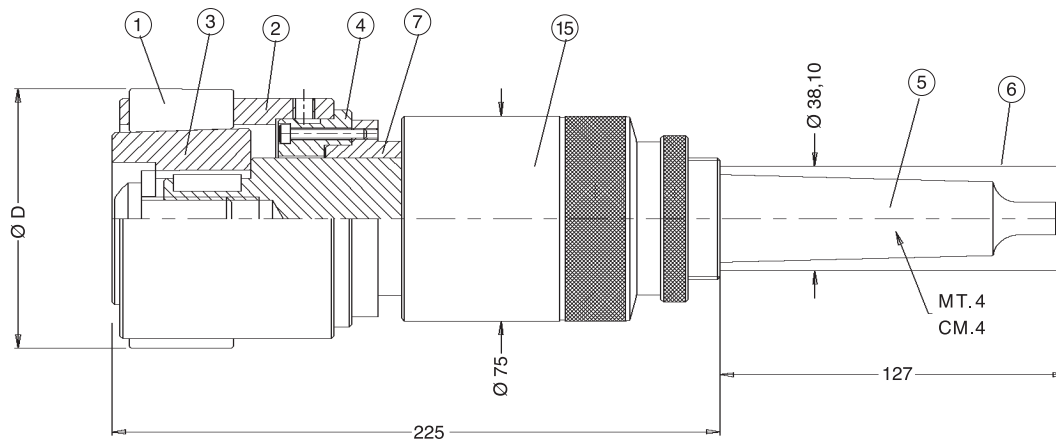
Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
84,81 - 85,85	RDKR-200-08481	RDKR-100-08481
85,63 - 86,66	RDKR-200-08563	RDKR-100-08563
86,41 - 87,45	RDKR-200-08641	RDKR-100-08641
87,20 - 88,24	RDKR-200-08720	RDKR-100-08720
87,99 - 89,03	RDKR-200-08799	RDKR-100-08799
88,79 - 89,84	RDKR-200-08879	RDKR-100-08879
89,59 - 90,63	RDKR-200-08959	RDKR-100-08959
90,37 - 91,42	RDKR-200-09037	RDKR-100-09037
91,16 - 92,20	RDKR-200-09116	RDKR-100-09116
91,97 - 93,02	RDKR-200-09197	RDKR-100-09197
92,76 - 93,80	RDKR-200-09276	RDKR-100-09276
93,55 - 94,59	RDKR-200-09355	RDKR-100-09355
94,34 - 95,38	RDKR-200-09434	RDKR-100-09434
95,15 - 96,19	RDKR-200-09515	RDKR-100-09515
95,94 - 96,98	RDKR-200-09594	RDKR-100-09594
96,72 - 97,77	RDKR-200-09672	RDKR-100-09672
97,51 - 98,55	RDKR-200-09751	RDKR-100-09751
98,32 - 99,37	RDKR-200-09832	RDKR-100-09832
99,11 - 100,15	RDKR-200-09911	RDKR-100-09911
99,90 - 100,94	RDKR-200-09990	RDKR-100-09990
100,69 - 101,73	RDKR-200-10069	RDKR-100-10069
101,50 - 102,54	RDKR-200-10150	RDKR-100-10150
102,29 - 103,33	RDKR-200-10229	RDKR-100-10229
103,07 - 104,12	RDKR-200-10307	RDKR-100-10307

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D****A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulliSEE PAGE ON  
THE OTHER SIDE  
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A FIANCO



From diam. 84,81 to 104,12 mm

Da diam. 84,81 a 104,12 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
84,81 - 85,85	RDCR-011-00214	RDTR-073-00001	RDRY-701-00468	9
85,63 - 86,66	RDCR-011-00216	RDTR-074-00001		
86,41 - 87,45	RDCR-011-00218	RDTR-071-00001	RDRY-701-00531	
87,20 - 88,24	RDCR-011-00220	RDTR-072-00001		
87,99 - 89,03	RDCR-011-00222	RDTR-073-00001		
88,79 - 89,84	RDCR-011-00224	RDTR-074-00001		
89,59 - 90,63	RDCR-011-00226	RDTR-075-00001		
90,37 - 91,42	RDCR-011-00228	RDTR-076-00001		
91,16 - 92,20	RDCR-011-00230	RDTR-071-00001		
91,97 - 93,02	RDCR-011-00232	RDTR-072-00001	RDRY-701-00625	
92,76 - 93,80	RDCR-011-00234	RDTR-073-00001		
93,55 - 94,59	RDCR-011-00236	RDTR-074-00001		
94,34 - 95,38	RDCR-011-00238	RDTR-075-00001		
95,15 - 96,19	RDCR-011-00240	RDTR-076-00001		
95,94 - 96,98	RDCR-011-00242	RDTR-077-00001		
96,72 - 97,77	RDCR-011-00244	RDTR-078-00001		

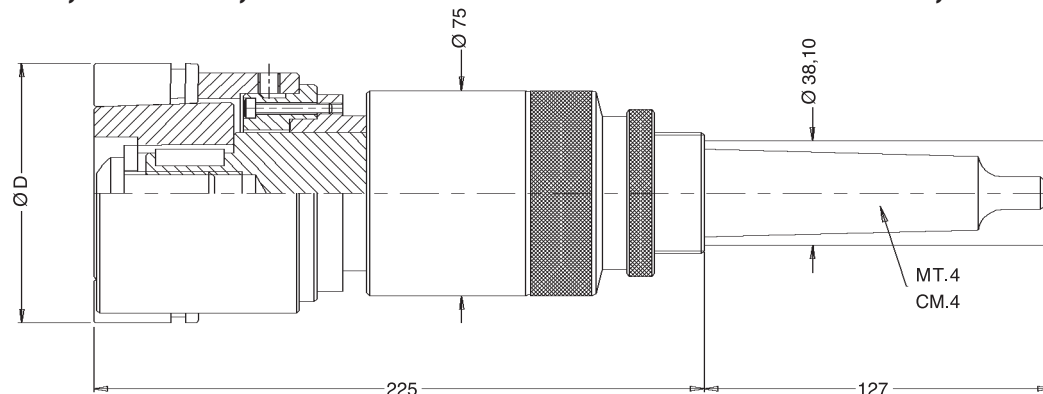
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
97,51 - 98,55	RDCR-011-00246	RDTR-075-00001	RDRY-701-00687	9
98,32 - 99,37	RDCR-011-00248	RDTR-076-00001		
99,11 - 100,15	RDCR-011-00250	RDTR-077-00001		
99,90 - 100,94	RDCR-011-00252	RDTR-078-00001		
100,69 - 101,73	RDCR-011-00254	RDTR-079-00001		
101,50 - 102,54	RDCR-011-00256	RDTR-080-00001		
102,29 - 103,33	RDCR-011-00258	RDTR-081-00001		
103,07 - 104,12	RDCR-011-00260	RDTR-082-00001		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15+7	RDWR-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15+7	RDWR-100-00000
	MT. shank / Attacco CM	pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGR-182-00000
	Cage sleeve / Portaflangia	pos.7	RDAR-074-00000
	Cage adapter / Flangia	pos.4	RDAR-092-00000

# ROLLER BURNISHING TOOLS SERIES RSKR - BLIND HOLES RULLATORI SERIE RSKR - FORI CIECHI

From diam. 84,81 to 104,12 mm

Da diam. 84,81 a 104,12 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
84,81 - 85,85	RSKR-200-xxxxx	RSKR-100-xxxxx
85,63 - 86,66	RSKR-200-xxxxx	RSKR-100-xxxxx
86,41 - 87,45	RSKR-200-xxxxx	RSKR-100-xxxxx
87,20 - 88,24	RSKR-200-xxxxx	RSKR-100-xxxxx
87,99 - 89,03	RSKR-200-xxxxx	RSKR-100-xxxxx
88,79 - 89,84	RSKR-200-xxxxx	RSKR-100-xxxxx
89,59 - 90,63	RSKR-200-xxxxx	RSKR-100-xxxxx
90,37 - 91,42	RSKR-200-xxxxx	RSKR-100-xxxxx
91,16 - 92,20	RSKR-200-xxxxx	RSKR-100-xxxxx
91,97 - 93,02	RSKR-200-xxxxx	RSKR-100-xxxxx
92,76 - 93,80	RSKR-200-xxxxx	RSKR-100-xxxxx
93,55 - 94,59	RSKR-200-xxxxx	RSKR-100-xxxxx
94,34 - 95,38	RSKR-200-xxxxx	RSKR-100-xxxxx
95,15 - 96,19	RSKR-200-xxxxx	RSKR-100-xxxxx
95,94 - 96,98	RSKR-200-xxxxx	RSKR-100-xxxxx
96,72 - 97,77	RSKR-200-xxxxx	RSKR-100-xxxxx
97,51 - 98,55	RSKR-200-xxxxx	RSKR-100-xxxxx
98,32 - 99,37	RSKR-200-xxxxx	RSKR-100-xxxxx
99,11 - 100,15	RSKR-200-xxxxx	RSKR-100-xxxxx
99,90 - 100,94	RSKR-200-xxxxx	RSKR-100-xxxxx
100,69 - 101,73	RSKR-200-xxxxx	RSKR-100-xxxxx
101,50 - 102,54	RSKR-200-xxxxx	RSKR-100-xxxxx
102,29 - 103,33	RSKR-200-xxxxx	RSKR-100-xxxxx
103,07 - 104,12	RSKR-200-xxxxx	RSKR-100-xxxxx

xxxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool  
Ø 100 mm with straight shank:  
RSKR-100-10000  
Numerazione che indica il  
diametro da rullare in centesimi  
es. Rullatore Ø 100 attacco  
cilindrico: RSKR-100-10000

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

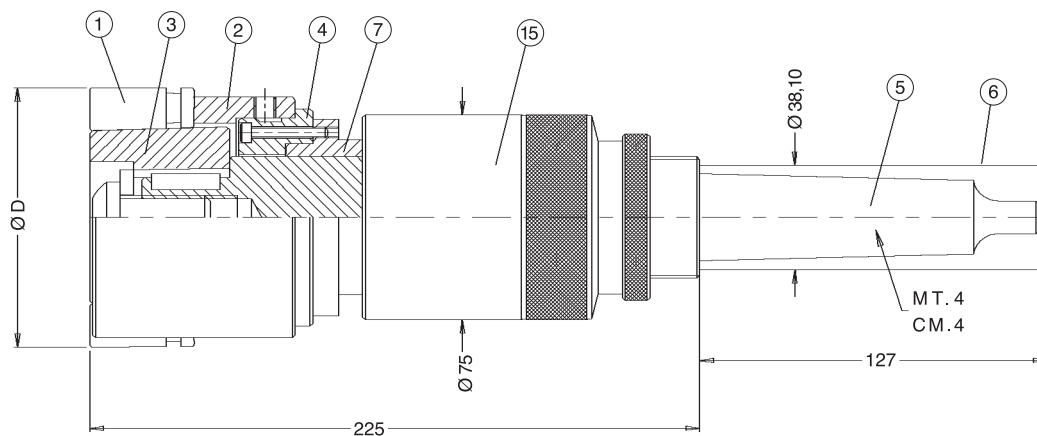
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 84,81 to 104,12 mm

Da diam. 84,81 a 104,12 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
84,81 - 85,85	RSCR-015-00214	RSTR-073-0000x	RSRY-708-00468	9
85,63 - 86,66	RSCR-015-00216	RSTR-074-0000x		
86,41 - 87,45	RSCR-015-00218	RSTR-071-0000x	RSRY-708-00531	
87,20 - 88,24	RSCR-015-00220	RSTR-072-0000x		
87,99 - 89,03	RSCR-015-00222	RSTR-073-0000x		
88,79 - 89,84	RSCR-015-00224	RSTR-074-0000x		
89,59 - 90,63	RSCR-015-00226	RSTR-075-0000x		
90,37 - 91,42	RSCR-015-00228	RSTR-076-0000x		
91,16 - 92,20	RSCR-015-00230	RSTR-071-0000x	RSRY-708-00625	
91,97 - 93,02	RSCR-015-00232	RSTR-072-0000x		
92,76 - 93,80	RSCR-015-00234	RSTR-073-0000x		
93,55 - 94,59	RSCR-015-00236	RSTR-074-0000x		
94,34 - 95,38	RSCR-015-00238	RSTR-075-0000x		
95,15 - 96,19	RSCR-015-00240	RSTR-076-0000x		
95,94 - 96,98	RSCR-015-00242	RSTR-077-0000x		
96,72 - 97,77	RSCR-015-00244	RSTR-078-0000x		

Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
97,51 - 98,55	RSCR-015-00246	RSTR-075-0000x	RSRY-708-00687	9
98,32 - 99,37	RSCR-015-00248	RSTR-076-0000x		
99,11 - 100,15	RSCR-015-00250	RSTR-077-0000x		
99,90 - 100,94	RSCR-015-00252	RSTR-078-0000x		
100,69 - 101,73	RSCR-015-00254	RSTR-079-0000x		
101,50 - 102,54	RSCR-015-00256	RSTR-080-0000x		
102,29 - 103,33	RSCR-015-00258	RSTR-081-0000x		
103,07 - 104,12	RSCR-015-00260	RSTR-082-0000x		

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6

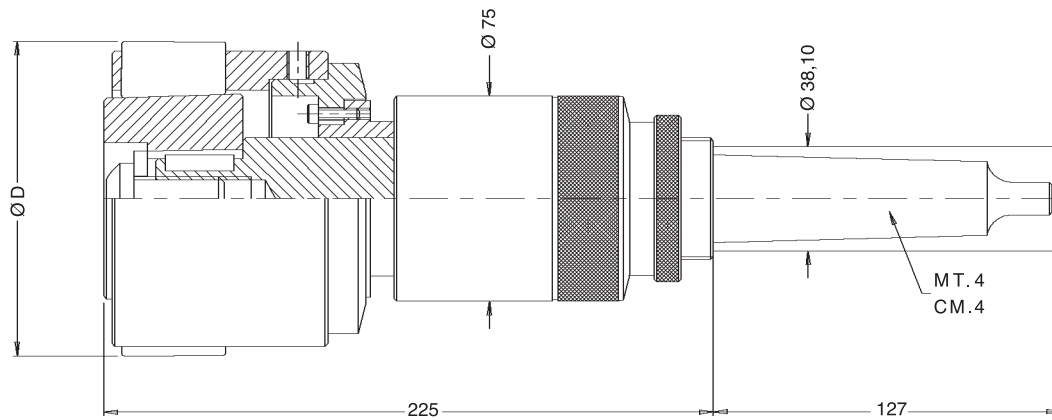
Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15+7	RDWR-200-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15+7	RDWR-100-00000
	MT. shank / Attacco CM	pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGR-182-00000
	Cage sleeve / Portaflangia	pos.7	RDAR-074-00000
	Cage adapter / Flangia	pos.4	RDAR-092-00000

# ROLLER BURNISHING TOOLS SERIES RDKS - THROUGH HOLES RULLATORI SERIE RDKS - FORI PASSANTI

From diam. 103,86 to 127,94 mm

Da diam. 103,86 a 127,94 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
103,86 - 104,90	RDKS-200-10386	RDKS-100-10386	115,77 - 116,82	RDKS-200-11577	RDKS-100-11577
104,67 - 105,72	RDKS-200-10467	RDKS-100-10467	116,56 - 117,60	RDKS-200-11656	RDKS-100-11656
105,46 - 106,50	RDKS-200-10546	RDKS-100-10546	117,37 - 118,42	RDKS-200-11737	RDKS-100-11737
106,25 - 107,29	RDKS-200-10625	RDKS-100-10625	118,16 - 119,20	RDKS-200-11816	RDKS-100-11816
107,04 - 108,08	RDKS-200-10704	RDKS-100-10704	118,95 - 119,99	RDKS-200-11895	RDKS-100-11895
107,85 - 108,89	RDKS-200-10785	RDKS-100-10785	119,74 - 120,78	RDKS-200-11974	RDKS-100-11974
108,64 - 109,68	RDKS-200-10864	RDKS-100-10864	120,55 - 121,59	RDKS-200-12055	RDKS-100-12055
109,42 - 110,47	RDKS-200-10942	RDKS-100-10942	121,34 - 122,38	RDKS-200-12134	RDKS-100-12134
110,21 - 111,25	RDKS-200-11021	RDKS-100-11021	122,12 - 123,17	RDKS-200-12212	RDKS-100-12212
111,02 - 112,07	RDKS-200-11102	RDKS-100-11102	122,91 - 123,95	RDKS-200-12291	RDKS-100-12291
111,81 - 112,85	RDKS-200-11181	RDKS-100-11181	123,72 - 124,77	RDKS-200-12372	RDKS-100-12372
112,60 - 113,64	RDKS-200-11260	RDKS-100-11260	124,51 - 125,55	RDKS-200-12451	RDKS-100-12451
113,34 - 114,43	RDKS-200-11334	RDKS-100-11334	125,30 - 126,34	RDKS-200-12530	RDKS-100-12530
114,20 - 115,24	RDKS-200-11420	RDKS-100-11420	126,09 - 127,13	RDKS-200-12609	RDKS-100-12609
114,99 - 116,03	RDKS-200-11499	RDKS-100-11499	126,90 - 127,94	RDKS-200-12690	RDKS-100-12690

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

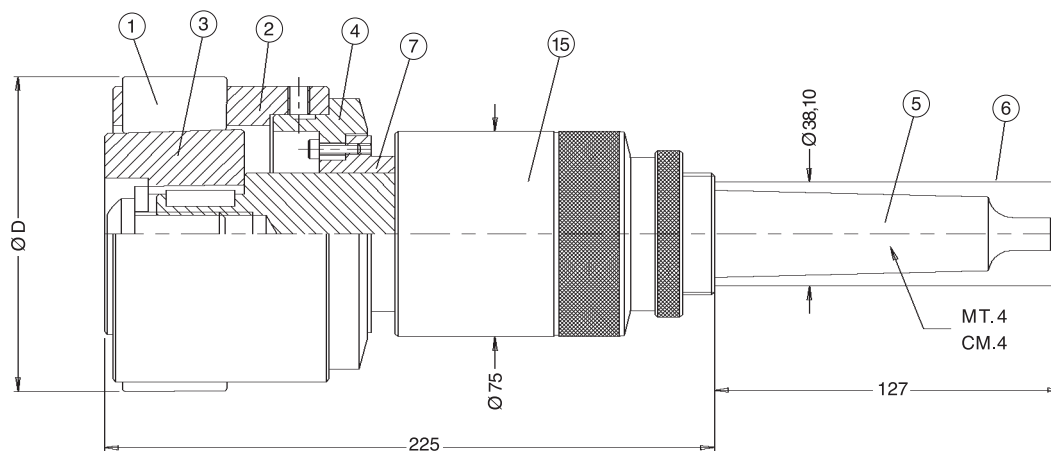
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

From diam. 103,86 to 127,94 mm

Da diam. 103,86 a 127,94 mm



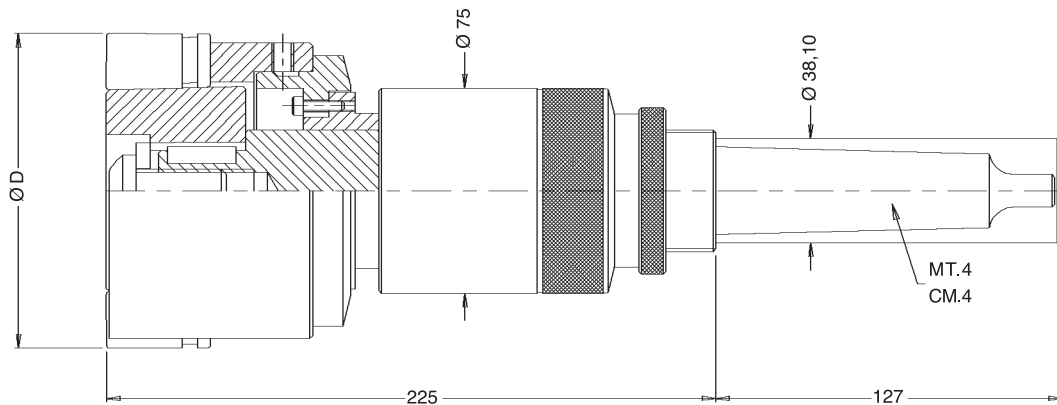
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli	Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
	103,86 - 104,90	RDCS-011-00262	RDTS-083-00001			RDRY-701-00687	9	115,77 - 116,82	
104,67 - 105,72	RDCS-011-00264	RDTS-084-00001	116,56 - 117,60	RDCS-011-00294	RDTS-091-00001				
105,46 - 106,50	RDCS-011-00266	RDTS-085-00001	117,37 - 118,42	RDCS-011-00296	RDTS-092-00001				
106,25 - 107,29	RDCS-011-00268	RDTS-086-00001	118,16 - 119,20	RDCS-011-00298	RDTS-093-00001				
107,04 - 108,08	RDCS-011-00270	RDTS-087-00001	118,95 - 119,99	RDCS-011-00300	RDTS-094-00001				
107,85 - 108,89	RDCS-011-00272	RDTS-088-00001	119,74 - 120,78	RDCS-011-00302	RDTS-095-00001				
108,64 - 109,68	RDCS-011-00274	RDTS-089-00001	120,55 - 121,59	RDCS-011-00304	RDTS-096-00001				
109,42 - 110,47	RDCS-011-00276	RDTS-090-00001	121,34 - 122,38	RDCS-011-00306	RDTS-097-00001				
110,21 - 111,25	RDCS-011-00278	RDTS-083-00001	122,12 - 123,17	RDCS-011-00308	RDTS-098-00001				
111,02 - 112,07	RDCS-011-00280	RDTS-084-00001	122,91 - 123,95	RDCS-011-00310	RDTS-099-00001				
111,81 - 112,85	RDCS-011-00282	RDTS-085-00001	123,72 - 124,77	RDCS-011-00312	RDTS-100-00001				
112,60 - 113,64	RDCS-011-00284	RDTS-086-00001	124,51 - 125,55	RDCS-011-01245	RDTS-031-01245				
113,34 - 114,43	RDCS-011-00286	RDTS-087-00001	125,30 - 126,34	RDCS-011-01255	RDTS-031-01255				
114,20 - 115,24	RDCS-011-00288	RDTS-088-00001	126,09 - 127,13	RDCS-011-01265	RDTS-031-01265				
114,99 - 116,03	RDCS-011-00290	RDTS-089-00001	126,90 - 127,94	RDCS-011-01275	RDTS-031-01275				

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	up to / fino Ø max 125,55	pos.4+5+15	RDWS-200-00000
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	from / da Ø min 125,30		RDWS-200-00001
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	up to / fino Ø max 125,55	pos.4+6+15	RDWS-100-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	from / da Ø min 125,30		RDWS-100-00001
	MT. shank / Attacco CM		pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico		pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione		pos.15	RDGR-182-00000
	Cage sleeve / Guidagabbia		pos.7	RDAR-074-00000
	Cage adapter / Flangia	up to / fino Ø max 125,55	pos.4	RDAS-092-00000
	Cage adapter / Flangia	from / da Ø min 125,30	pos.4	RDAS-092-00001

# ROLLER BURNISHING TOOLS SERIES RSKS - BLIND HOLES RULLATORI SERIE RSKS - FORI CIECHI

From diam. 103,86 to 127,94 mm

Da diam. 103,86 a 127,94 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico	Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
103,86 - 104,90	RSKS-200-xxxxx	RSKS-100-xxxxx	115,77 - 116,82	RSKS-200-xxxxx	RSKS-100-xxxxx
104,67 - 105,72	RSKS-200-xxxxx	RSKS-100-xxxxx	116,56 - 117,60	RSKS-200-xxxxx	RSKS-100-xxxxx
105,46 - 106,50	RSKS-200-xxxxx	RSKS-100-xxxxx	117,37 - 118,42	RSKS-200-xxxxx	RSKS-100-xxxxx
106,25 - 107,29	RSKS-200-xxxxx	RSKS-100-xxxxx	118,16 - 119,20	RSKS-200-xxxxx	RSKS-100-xxxxx
107,04 - 108,08	RSKS-200-xxxxx	RSKS-100-xxxxx	118,95 - 119,99	RSKS-200-xxxxx	RSKS-100-xxxxx
107,85 - 108,89	RSKS-200-xxxxx	RSKS-100-xxxxx	119,74 - 120,78	RSKS-200-xxxxx	RSKS-100-xxxxx
108,64 - 109,68	RSKS-200-xxxxx	RSKS-100-xxxxx	120,55 - 121,59	RSKS-200-xxxxx	RSKS-100-xxxxx
109,42 - 110,47	RSKS-200-xxxxx	RSKS-100-xxxxx	121,34 - 122,38	RSKS-200-xxxxx	RSKS-100-xxxxx
110,21 - 111,25	RSKS-200-xxxxx	RSKS-100-xxxxx	122,12 - 123,17	RSKS-200-xxxxx	RSKS-100-xxxxx
111,02 - 112,07	RSKS-200-xxxxx	RSKS-100-xxxxx	122,91 - 123,95	RSKS-200-xxxxx	RSKS-100-xxxxx
111,81 - 112,85	RSKS-200-xxxxx	RSKS-100-xxxxx	123,72 - 124,77	RSKS-200-xxxxx	RSKS-100-xxxxx
112,60 - 113,64	RSKS-200-xxxxx	RSKS-100-xxxxx	124,51 - 125,55	RSKS-200-xxxxx	RSKS-100-xxxxx
113,34 - 114,43	RSKS-200-xxxxx	RSKS-100-xxxxx	125,30 - 126,34	RSKS-200-xxxxx	RSKS-100-xxxxx
114,20 - 115,24	RSKS-200-xxxxx	RSKS-100-xxxxx	126,09 - 127,13	RSKS-200-xxxxx	RSKS-100-xxxxx
114,99 - 116,03	RSKS-200-xxxxx	RSKS-100-xxxxx	126,90 - 127,94	RSKS-200-xxxxx	RSKS-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 120,05 mm with MT.4 shank: RSKS-200-12005  
Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 120,05 attacco CM.4: RSKS-200-12005

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

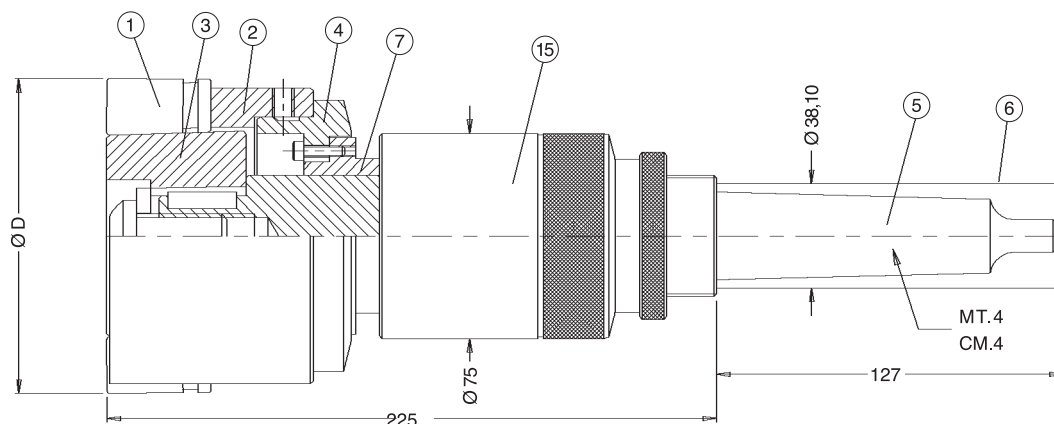
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO



From diam. 103,86 to 127,94 mm

Da diam. 103,86 a 127,94 mm



Adjustment range Campo di regolazione ØD min. max.	B Cage Gabbia pos.2	C Cone Asta pos.3	D Rolls Rulli pos.1	Rolls qty / Qtà rulli	Adjustment range Campo di regolazione ØD min. max.	B Cage Gabbia pos.2	C Cone Asta pos.3	D Rolls Rulli pos.1	Rolls qty / Qtà rulli
103,86 - 104,90	RSCS-015-00262	RSTS-083-0000x	RSRY-708-00687	9	115,77 - 116,82	RSCS-015-00292	RSTS-090-0000x	RSRY-708-00812	9
104,67 - 105,72	RSCS-015-00264	RSTS-084-0000x			116,56 - 117,60	RSCS-015-00294	RSTS-091-0000x		
105,46 - 106,50	RSCS-015-00266	RSTS-085-0000x			117,37 - 118,42	RSCS-015-00296	RSTS-092-0000x		
106,25 - 107,29	RSCS-015-00268	RSTS-086-0000x			118,16 - 119,20	RSCS-015-00298	RSTS-093-0000x		
107,04 - 108,08	RSCS-015-00270	RSTS-087-0000x			118,95 - 119,99	RSCS-015-00300	RSTS-094-0000x		
107,85 - 108,89	RSCS-015-00272	RSTS-088-0000x			119,74 - 120,78	RSCS-015-00302	RSTS-095-0000x		
108,64 - 109,68	RSCS-015-00274	RSTS-089-0000x			120,55 - 121,59	RSCS-015-00304	RSTS-096-0000x		
109,42 - 110,47	RSCS-015-00276	RSTS-090-0000x			121,34 - 122,38	RSCS-015-00306	RSTS-097-0000x		
110,21 - 111,25	RSCS-015-00278	RSTS-083-0000x			122,12 - 123,17	RSCS-015-00308	RSTS-098-0000x		
111,02 - 112,07	RSCS-015-00280	RSTS-084-0000x	RSRY-708-00812	9	122,91 - 123,95	RSCS-015-00310	RSTS-099-0000x	9	
111,81 - 112,85	RSCS-015-00282	RSTS-085-0000x			123,72 - 124,77	RSCS-015-00312	RSTS-100-0000x		
112,60 - 113,64	RSCS-015-00284	RSTS-086-0000x			124,51 - 125,55	RSCS-015-01245	RSTS-03x-01245		
113,34 - 114,43	RSCS-015-00286	RSTS-087-0000x			125,30 - 126,34	RSCS-015-01255	RSTS-03x-01255		
114,20 - 115,24	RSCS-015-00288	RSTS-088-0000x			126,09 - 127,13	RSCS-015-01265	RSTS-03x-01265		
114,99 - 116,03	RSCS-015-00290	RSTS-089-0000x			126,90 - 127,94	RSCS-015-01275	RSTS-03x-01275		

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value go to page 6

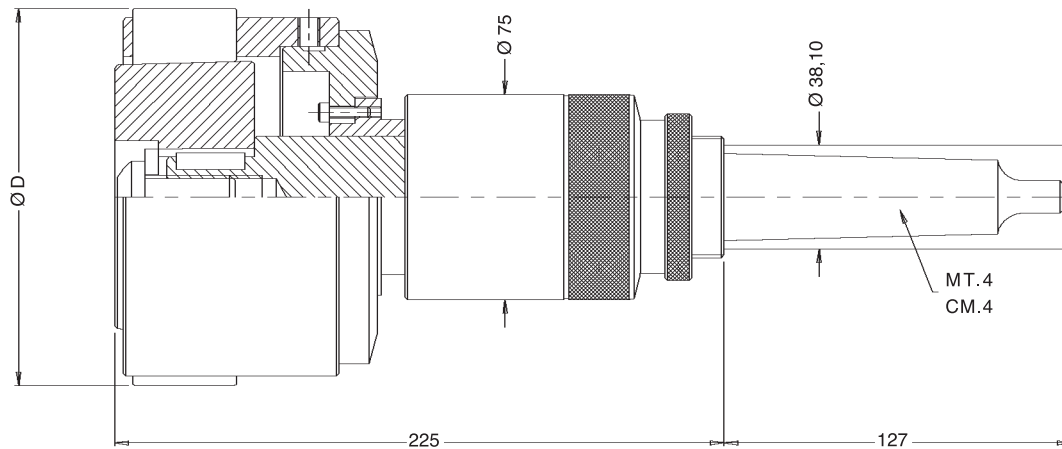
Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 7

A	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	up to / fino Ø max 125,55	pos.4+5+15	RDWS-200-00000
A	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	from / da Ø min 125,30		RDWS-200-00001
A	Basic assembly with straight shank / Corpo base con attacco cilindrico	up to / fino Ø max 125,55	pos.4+6+15	RDWS-100-00000
A	Basic assembly with straight shank / Corpo base con attacco cilindrico	from / da Ø min 125,30		RDWS-100-00001
	MT. shank / Attacco CM		pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico		pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione		pos.15	RDGR-182-00000
	Cage sleeve / Guidagabbia		pos.7	RDAR-074-00000
	Cage adapter / Flangia	up to / fino Ø max 125,55	pos.4	RDAS-092-00000
	Cage adapter / Flangia	from / da Ø min 125,30	pos.4	RDAS-092-00001

# ROLLER BURNISHING TOOLS SERIES RDKT - THROUGH HOLES RULLATORI SERIE RDKT - FORI PASSANTI

From diam. 127,90 to 149,90 mm

Da diam. 127,90 a 149,90 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
127,90 - 128,90	RDKT-200-12790	RDKT-100-12790
128,90 - 129,90	RDKT-200-12890	RDKT-100-12890
129,90 - 130,90	RDKT-200-12990	RDKT-100-12990
130,90 - 131,90	RDKT-200-13090	RDKT-100-13090
131,90 - 132,90	RDKT-200-13190	RDKT-100-13190
132,90 - 133,90	RDKT-200-13290	RDKT-100-13290
133,90 - 134,90	RDKT-200-13390	RDKT-100-13390
134,90 - 135,90	RDKT-200-13490	RDKT-100-13490
135,90 - 136,90	RDKT-200-13590	RDKT-100-13590
136,90 - 137,90	RDKT-200-13690	RDKT-100-13690
137,90 - 138,90	RDKT-200-13790	RDKT-100-13790
138,90 - 139,90	RDKT-200-13890	RDKT-100-13890
139,90 - 140,90	RDKT-200-13990	RDKT-100-13990
140,90 - 141,90	RDKT-200-14090	RDKT-100-14090
141,90 - 142,90	RDKT-200-14190	RDKT-100-14190
142,90 - 143,90	RDKT-200-14290	RDKT-100-14290
143,90 - 144,90	RDKT-200-14390	RDKT-100-14390
144,90 - 145,90	RDKT-200-14490	RDKT-100-14490
145,90 - 146,90	RDKT-200-14590	RDKT-100-14590
146,90 - 147,90	RDKT-200-14690	RDKT-100-14690
147,90 - 148,90	RDKT-200-14790	RDKT-100-14790
148,90 - 149,90	RDKT-200-14890	RDKT-100-14890

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

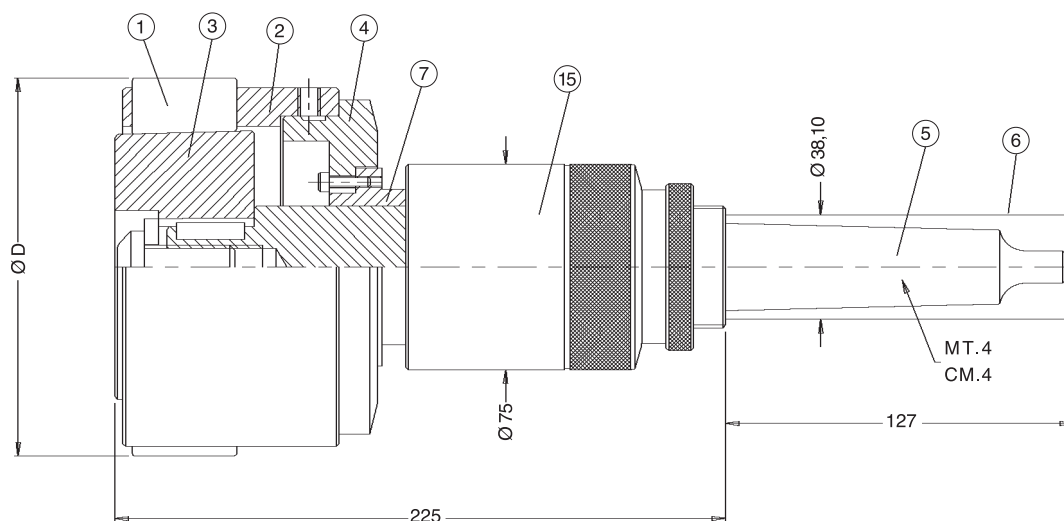
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
THE OTHER SIDE  
VEDERE PAGINA  
A FIANCO

From diam. 127,90 to 149,90 mm

Da diam. 127,90 a 149,90 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
127,90 - 128,90	RDCT-011-01280	RDTT-031-01280	RDRY-701-00812	11
128,90 - 129,90	RDCT-011-01290	RDTT-031-01290		
129,90 - 130,90	RDCT-011-01300	RDTT-031-01300		
130,90 - 131,90	RDCT-011-01310	RDTT-031-01310		
131,90 - 132,90	RDCT-011-01320	RDTT-031-01320		
132,90 - 133,90	RDCT-011-01330	RDTT-031-01330		
133,90 - 134,90	RDCT-011-01340	RDTT-031-01340		
134,90 - 135,90	RDCT-011-01350	RDTT-031-01350		
135,90 - 136,90	RDCT-011-01360	RDTT-031-01360		
136,90 - 137,90	RDCT-011-01370	RDTT-031-01370		
137,90 - 138,90	RDCT-011-01380	RDTT-031-01380		

Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
138,90 - 139,90	RDCT-011-01390	RDTT-031-01390	RDRY-701-00812	11
139,90 - 140,90	RDCT-011-01400	RDTT-031-01400		
140,90 - 141,90	RDCT-011-01410	RDTT-031-01410		
141,90 - 142,90	RDCT-011-01420	RDTT-031-01420		
142,90 - 143,90	RDCT-011-01430	RDTT-031-01430		
143,90 - 144,90	RDCT-011-01440	RDTT-031-01440		
144,90 - 145,90	RDCT-011-01450	RDTT-031-01450		
145,90 - 146,90	RDCT-011-01460	RDTT-031-01460		
146,90 - 147,90	RDCT-011-01470	RDTT-031-01470		
147,90 - 148,90	RDCT-011-01480	RDTT-031-01480		
148,90 - 149,90	RDCT-011-01490	RDTT-031-01490		

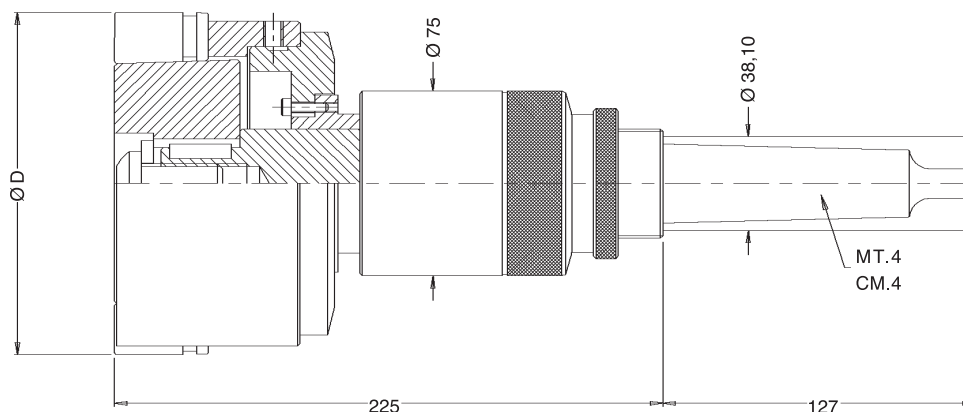
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	up to / fino Ø max 144,90	pos.4+5+15	RDWT-200-00000
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	from / da Ø min 144,90		RDWT-200-00001
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	up to / fino Ø max 144,90	pos.4+6+15	RDWT-100-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	from / da Ø min 144,90		RDWT-100-00001
	MT. shank / Attacco CM		pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico		pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione		pos.15	RDGR-182-00000
	Cage sleeve / Guidagabbia		pos.7	RDAR-074-00000
	Cage adapter / Flangia	up to / fino Ø max 144,90	pos.4	RDAT-092-00000
	Cage adapter / Flangia	from / da Ø min 144,90	pos.4	RDAT-092-00001

# ROLLER BURNISHING TOOLS SERIES RSKT - BLIND HOLES

## RULLATORI SERIE RSKT - FORI CIECHI

From diam. 127,90 to 149,90 mm

Da diam. 127,90 a 149,90 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
127,90 - 128,90	RSKT-200-xxxxx	RSKT-100-xxxxx
128,90 - 129,90	RSKT-200-xxxxx	RSKT-100-xxxxx
129,90 - 130,90	RSKT-200-xxxxx	RSKT-100-xxxxx
130,90 - 131,90	RSKT-200-xxxxx	RSKT-100-xxxxx
131,90 - 132,90	RSKT-200-xxxxx	RSKT-100-xxxxx
132,90 - 133,90	RSKT-200-xxxxx	RSKT-100-xxxxx
133,90 - 134,90	RSKT-200-xxxxx	RSKT-100-xxxxx
134,90 - 135,90	RSKT-200-xxxxx	RSKT-100-xxxxx
135,90 - 136,90	RSKT-200-xxxxx	RSKT-100-xxxxx
136,90 - 137,90	RSKT-200-xxxxx	RSKT-100-xxxxx
137,90 - 138,90	RSKT-200-xxxxx	RSKT-100-xxxxx
138,90 - 139,90	RSKT-200-xxxxx	RSKT-100-xxxxx
139,90 - 140,90	RSKT-200-xxxxx	RSKT-100-xxxxx
140,90 - 141,90	RSKT-200-xxxxx	RSKT-100-xxxxx
141,90 - 142,90	RSKT-200-xxxxx	RSKT-100-xxxxx
142,90 - 143,90	RSKT-200-xxxxx	RSKT-100-xxxxx
143,90 - 144,90	RSKT-200-xxxxx	RSKT-100-xxxxx
144,90 - 145,90	RSKT-200-xxxxx	RSKT-100-xxxxx
145,90 - 146,90	RSKT-200-xxxxx	RSKT-100-xxxxx
146,90 - 147,90	RSKT-200-xxxxx	RSKT-100-xxxxx
147,90 - 148,90	RSKT-200-xxxxx	RSKT-100-xxxxx
148,90 - 149,90	RSKT-200-xxxxx	RSKT-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool  
Ø 140 mm with straight shank:  
RSKT-100-14000

Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 140 attacco cilindrico: RSKT-100-14000

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A + B + C + D**

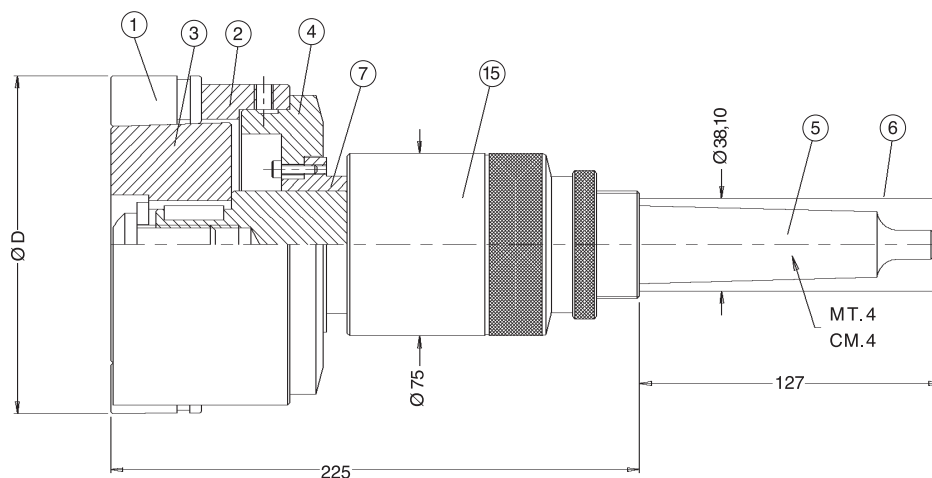
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO

From diam. 127,90 to 149,90 mm

Da diam. 127,90 a 149,90 mm



Per ordinare l'utensile con l'attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli	Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
127,90 - 128,90	RSCT-015-01280	RSTT-0xx-01280	RSRY-708-00812	11	138,90 - 139,90	RSCT-015-01390	RSTT-0xx-01390	RSRY-708-00812	11
128,90 - 129,90	RSCT-015-01290	RSTT-0xx-01290			139,90 - 140,90	RSCT-015-01400	RSTT-0xx-01400		
129,90 - 130,90	RSCT-015-01300	RSTT-0xx-01300			140,90 - 141,90	RSCT-015-01410	RSTT-0xx-01410		
130,90 - 131,90	RSCT-015-01310	RSTT-0xx-01310			141,90 - 142,90	RSCT-015-01420	RSTT-0xx-01420		
131,90 - 132,90	RSCT-015-01320	RSTT-0xx-01320			142,90 - 143,90	RSCT-015-01430	RSTT-0xx-01430		
132,90 - 133,90	RSCT-015-01330	RSTT-0xx-01330			143,90 - 144,90	RSCT-015-01440	RSTT-0xx-01440		
133,90 - 134,90	RSCT-015-01340	RSTT-0xx-01340			144,90 - 145,90	RSCT-015-01450	RSTT-0xx-01450		
134,90 - 135,90	RSCT-015-01350	RSTT-0xx-01350			145,90 - 146,90	RSCT-015-01460	RSTT-0xx-01460		
135,90 - 136,90	RSCT-015-01360	RSTT-0xx-01360			146,90 - 147,90	RSCT-015-01470	RSTT-0xx-01470		
136,90 - 137,90	RSCT-015-01370	RSTT-0xx-01370			147,90 - 148,90	RSCT-015-01480	RSTT-0xx-01480		
137,90 - 138,90	RSCT-015-01380	RSTT-0xx-01380			148,90 - 149,90	RSCT-015-01490	RSTT-0xx-01490		

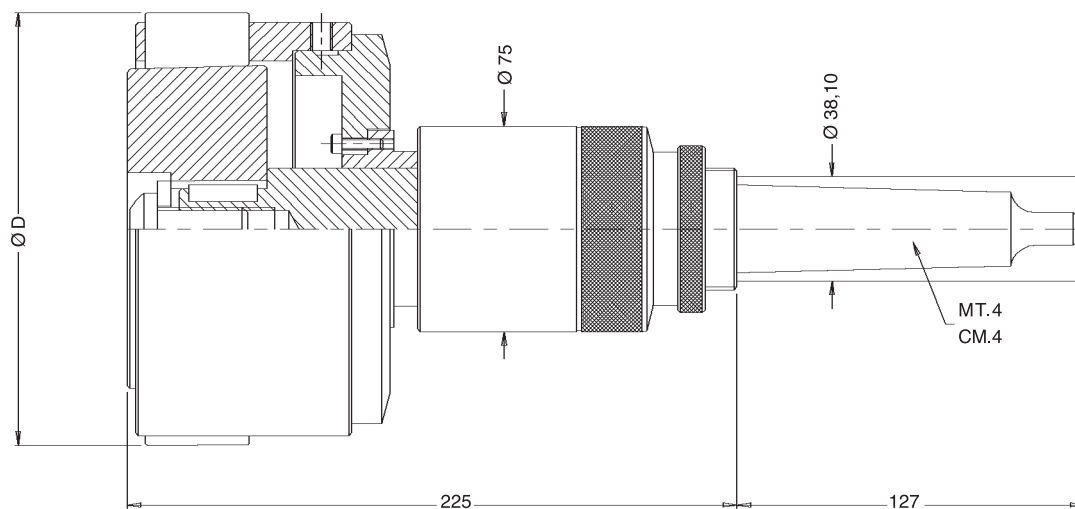
xx = A number in the range from 32 to 40 depending upon the exact diameter to be burnished. For the correct identification of "xx" value go to page 6  
 Numero che varia da 32 a 40 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "xx" vedi pagina 7

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	up to / fino Ø max 144,90	pos.4+5+15	RDWT-200-00000
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	from / da Ø min 144,90		RDWT-200-00001
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	up to / fino Ø max 144,90	pos.4+6+15	RDWT-100-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	from / da Ø min 144,90		RDWT-100-00001
	MT. shank / Attacco CM		pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico		pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione		pos.15	RDGR-182-00000
	Cage sleeve / Guidagabbia		pos.7	RDAR-074-00000
	Cage adapter / Flangia	up to / fino Ø max 144,90	pos.4	RDAT-092-00000
	Cage adapter / Flangia	from / da Ø min 144,90	pos.4	RDAT-092-00001

# ROLLER BURNISHING TOOLS SERIES RDKU - THROUGH HOLES RULLATORI SERIE RDKU - FORI PASSANTI

From diam. 149,90 to 165,90 mm

Da diam. 149,90 a 165,90 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
149,90 - 150,90	RDKU-200-14990	RDKU-100-14990
150,90 - 151,90	RDKU-200-15090	RDKU-100-15090
151,90 - 152,90	RDKU-200-15190	RDKU-100-15190
152,90 - 153,90	RDKU-200-15290	RDKU-100-15290
153,90 - 154,90	RDKU-200-15390	RDKU-100-15390
154,90 - 155,90	RDKU-200-15490	RDKU-100-15490
155,90 - 156,90	RDKU-200-15590	RDKU-100-15590
156,90 - 157,90	RDKU-200-15690	RDKU-100-15690
157,90 - 158,90	RDKU-200-15790	RDKU-100-15790
158,90 - 159,90	RDKU-200-15890	RDKU-100-15890
159,90 - 160,90	RDKU-200-15990	RDKU-100-15990
160,90 - 161,90	RDKU-200-16090	RDKU-100-16090
161,90 - 162,90	RDKU-200-16190	RDKU-100-16190
162,90 - 163,90	RDKU-200-16290	RDKU-100-16290
163,90 - 164,90	RDKU-200-16390	RDKU-100-16390
164,90 - 165,90	RDKU-200-16490	RDKU-100-16490

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

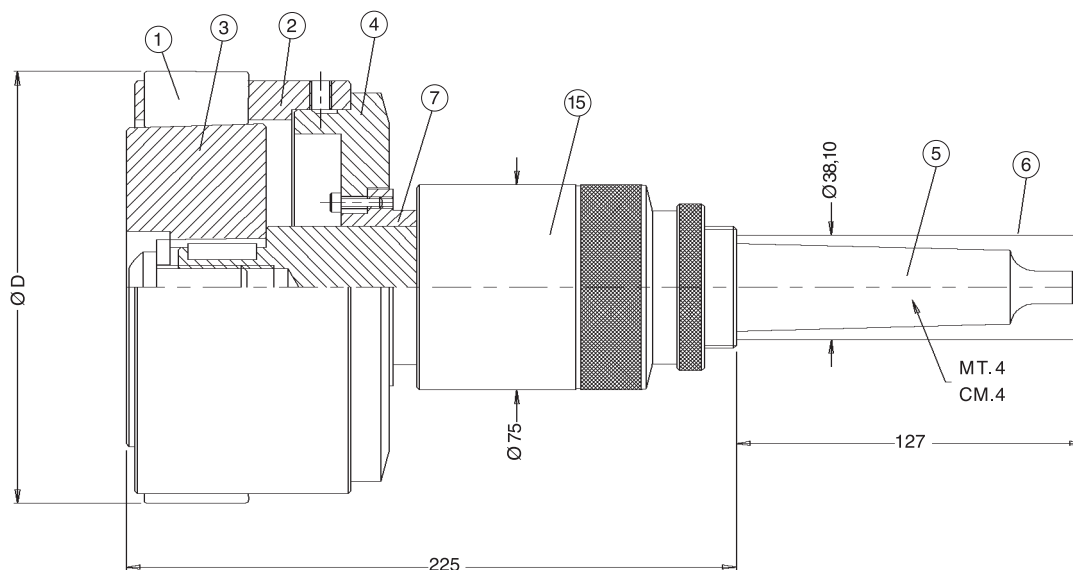
**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

SEE PAGE ON  
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A FIANCO



From diam. 149,90 to 165,90 mm

Da diam. 149,90 a 165,90 mm



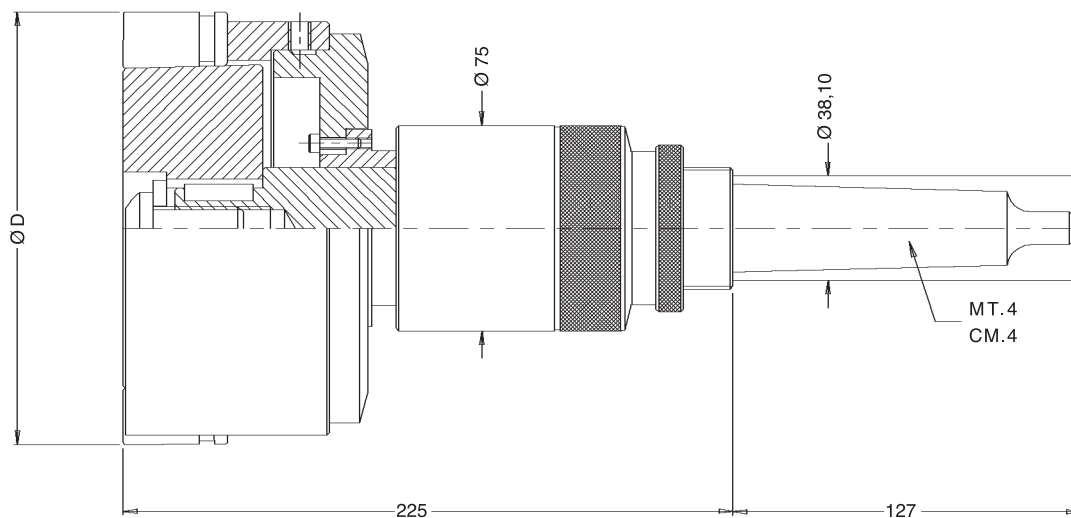
Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
149,90 - 150,90	RDCU-011-01500	RDTU-031-01500	RDRY-701-00812	13
150,90 - 151,90	RDCU-011-01510	RDTU-031-01510		
151,90 - 152,90	RDCU-011-01520	RDTU-031-01520		
152,90 - 153,90	RDCU-011-01530	RDTU-031-01530		
153,90 - 154,90	RDCU-011-01540	RDTU-031-01540		
154,90 - 155,90	RDCU-011-01550	RDTU-031-01550		
155,90 - 156,90	RDCU-011-01560	RDTU-031-01560		
156,90 - 157,90	RDCU-011-01570	RDTU-031-01570		
157,90 - 158,90	RDCU-011-01580	RDTU-031-01580		
158,90 - 159,90	RDCU-011-01590	RDTU-031-01590		
159,90 - 160,90	RDCU-011-01600	RDTU-031-01600		
160,90 - 161,90	RDCU-011-01610	RDTU-031-01610		
161,90 - 162,90	RDCU-011-01620	RDTU-031-01620		
162,90 - 163,90	RDCU-011-01630	RDTU-031-01630		
163,90 - 164,90	RDCU-011-01640	RDTU-031-01640		
164,90 - 165,90	RDCU-011-01650	RDTU-031-01650		

<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWU-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWU-120-00000
	MT. shank / Attacco CM	pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGR-182-00000
	Cage sleeve / Portaflangia	pos.7	RDAR-074-00000
	Cage adapter / Flangia	pos.4	RDAU-092-00000

# ROLLER BURNISHING TOOLS SERIES RSKU - BLIND HOLES RULLATORI SERIE RSKU - FORI CIECHI

From diam. 149,90 to 165,90 mm

Da diam. 149,90 a 165,90 mm



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B Per ordinare l'utensile con attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

Adjustment range Campo di regolazione ØD min. max.	Roller burnishing tool with Morse Taper shank Rullatore con attacco Cono Morse	Roller burnishing tool with straight shank Rullatore con attacco cilindrico
149,90 - 150,90	RSKU-200-xxxxx	RSKU-100-xxxxx
150,90 - 151,90	RSKU-200-xxxxx	RSKU-100-xxxxx
151,90 - 152,90	RSKU-200-xxxxx	RSKU-100-xxxxx
152,90 - 153,90	RSKU-200-xxxxx	RSKU-100-xxxxx
153,90 - 154,90	RSKU-200-xxxxx	RSKU-100-xxxxx
154,90 - 155,90	RSKU-200-xxxxx	RSKU-100-xxxxx
155,90 - 156,90	RSKU-200-xxxxx	RSKU-100-xxxxx
156,90 - 157,90	RSKU-200-xxxxx	RSKU-100-xxxxx
157,90 - 158,90	RSKU-200-xxxxx	RSKU-100-xxxxx
158,90 - 159,90	RSKU-200-xxxxx	RSKU-100-xxxxx
159,90 - 160,90	RSKU-200-xxxxx	RSKU-100-xxxxx
160,90 - 161,90	RSKU-200-xxxxx	RSKU-100-xxxxx
161,90 - 162,90	RSKU-200-xxxxx	RSKU-100-xxxxx
162,90 - 163,90	RSKU-200-xxxxx	RSKU-100-xxxxx
163,90 - 164,90	RSKU-200-xxxxx	RSKU-100-xxxxx
164,90 - 165,90	RSKU-200-xxxxx	RSKU-100-xxxxx

xxxxx = Indicates to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tool Ø 160 mm with MT.4 shank: RSKU-200-16000

Numerazione che indica il diametro da rullare in centesimi es. Rullatore Ø 160 attacco CM.4: RSKU-200-16000

Each roller burnishing tool is composed by the items / Ogni rullatore è composto dagli elementi **A** + **B** + **C** + **D**

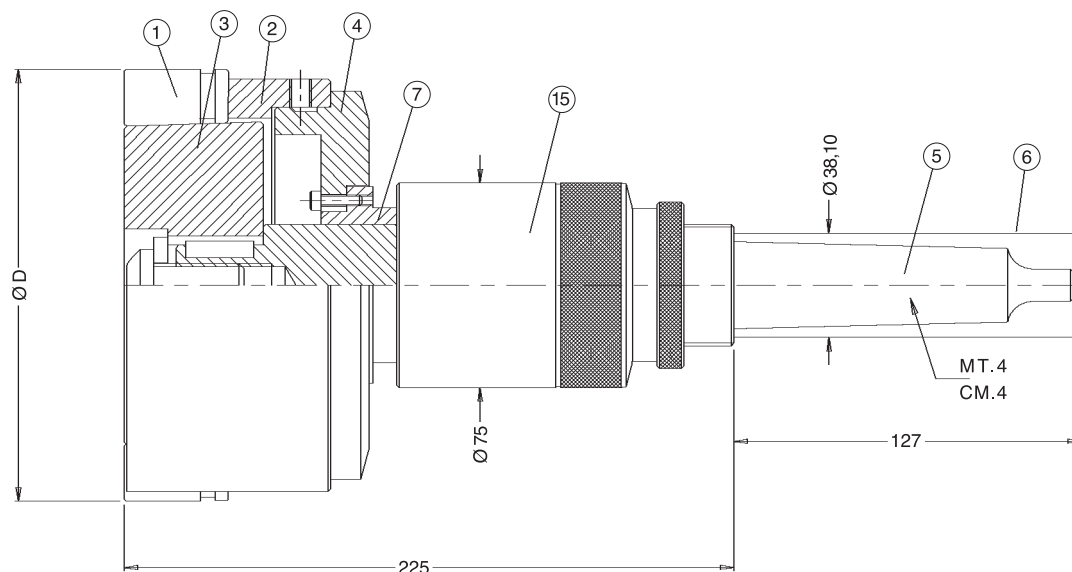
**A** = basic assembly (which includes MT or straight shank) / corpo base (comprensivo di attacco CM. o cilindrico),

**B** = cage / gabbia, **C** = cone / asta, **D** = set of rolls / serie di rulli

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A FIANCO

From diam. 149,90 to 165,90 mm

Da diam. 149,90 a 165,90 mm



Adjustment range Campo di regolazione ØD min. max.	<b>B</b> Cage Gabbia pos.2	<b>C</b> Cone Asta pos.3	<b>D</b> Rolls Rulli pos.1	Rolls qty / Qtà rulli
149,90 - 150,90	RSCU-015-01500	RSTU-0xx-01500	RSRY-708-00812	13
150,90 - 151,90	RSCU-015-01510	RSTU-0xx-01510		
151,90 - 152,90	RSCU-015-01520	RSTU-0xx-01520		
152,90 - 153,90	RSCU-015-01530	RSTU-0xx-01530		
153,90 - 154,90	RSCU-015-01540	RSTU-0xx-01540		
154,90 - 155,90	RSCU-015-01550	RSTU-0xx-01550		
155,90 - 156,90	RSCU-015-01560	RSTU-0xx-01560		
156,90 - 157,90	RSCU-015-01570	RSTU-0xx-01570		
157,90 - 158,90	RSCU-015-01580	RSTU-0xx-01580		
158,90 - 159,90	RSCU-015-01590	RSTU-0xx-01590		
159,90 - 160,90	RSCU-015-01600	RSTU-0xx-01600		
160,90 - 161,90	RSCU-015-01610	RSTU-0xx-01610		
161,90 - 162,90	RSCU-015-01620	RSTU-0xx-01620		
162,90 - 163,90	RSCU-015-01630	RSTU-0xx-01630		
163,90 - 164,90	RSCU-015-01640	RSTU-0xx-01640		
164,90 - 165,90	RSCU-015-01650	RSTU-0xx-01650		

xx = A number in the range from 32 to 40 depending upon the exact diameter to be burnished. For the correct identification of "xx" value go to page 6  
 Numero che varia da 32 a 40 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "xx" vedi pagina 7

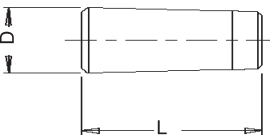
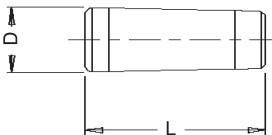
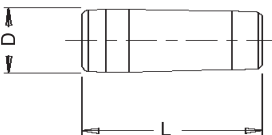
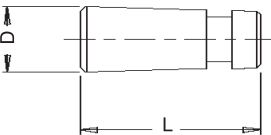
<b>A</b>	Basic assembly with Morse Taper shank / Corpo base con attacco Cono Morse	pos.4+5+15	RDWU-220-00000
<b>A</b>	Basic assembly with straight shank / Corpo base con attacco cilindrico	pos.4+6+15	RDWU-120-00000
	MT. shank / Attacco CM	pos.5	RDSR-042-00000
	Straight shank / Attacco cilindrico	pos.6	RDSR-041-00000
	Adjustment housing assembly / Boccola di registrazione	pos.15	RDGR-182-00000
	Cage sleeve / Portaflangia	pos.7	RDAR-074-00000
	Cage adapter / Flangia	pos.4	RDAU-092-00000

**Series RDRY = rolls for through holes**

**Series RSRY = rolls for blind holes**

**Serie RDRY = rullini per fori passanti**

**Serie RSRY = rullini per fori ciechi**

Rolls / Rulli 704 - 707			Rolls / Rulli 701			Rolls / Rulli 706			Rolls / Rulli 708 - 705		
											
Code / Codice	D	L	Code / Codice	D	L	Code / Codice	D	L	Code / Codice	D	L
RDRY - 704 - 00062	1,57	6,35									
RDRY - 704 - 00070	1,77	7,94									
RDRY - 704 - 00078	1,97	9,53									
RDRY - 704 - 00086	2,17	9,53							RSRY - 708 - 00086	2,17	9,53
RDRY - 704 - 00093	2,36	9,53									
RDRY - 704 - 00109	2,75	12,70									
RDRY - 704 - 00125	3,16	12,70							RSRY - 708 - 00125	3,16	12,70
RDRY - 704 - 00148	3,74	12,70									
RDRY - 704 - 00156	3,95	12,70							RSRY - 708 - 00156	3,95	12,70
RDRY - 704 - 00172	4,34	15,88							RSRY - 708 - 00172	4,35	15,88
RDRY - 704 - 00187	4,72	22,28	RDRY - 701 - 00187	4,65	22,28				RSRY - 708 - 00187	4,72	22,28
RDRY - 707 - 00187	4,72	12,70							RSRY - 705 - 00187	4,74	12,70
RDRY - 704 - 00218	5,52	12,70	RDRY - 701 - 00218	5,43	25,40	RDRY - 706 - 00218	5,26	25,40	RSRY - 708 - 00218	5,52	25,40
RDRY - 707 - 00218	5,52	25,40							RSRY - 705 - 00218	5,52	12,70
RDRY - 704 - 00265	6,70	28,58	RDRY - 701 - 00265	6,63	28,58	RDRY - 706 - 00265	6,46	28,58	RSRY - 708 - 00265	6,70	28,58
RDRY - 704 - 00312	7,90	38,10	RDRY - 701 - 00312	7,72	38,10	RDRY - 706 - 00312	7,55	38,10	RSRY - 708 - 00312	7,90	38,10
RDRY - 707 - 00312	7,92	28,58							RSRY - 705 - 00312	7,90	28,58
RDRY - 704 - 00406	10,28	38,10	RDRY - 701 - 00406	10,11	38,10	RDRY - 706 - 00406	9,93	38,10	RSRY - 708 - 00406	10,29	38,10
RDRY - 704 - 00468	11,86	38,10	RDRY - 701 - 00468	11,68	38,10	RDRY - 706 - 00468	11,51	38,10	RSRY - 708 - 00468	11,86	38,10
RDRY - 704 - 00531	13,46	38,10	RDRY - 701 - 00531	13,28	38,10	RDRY - 706 - 00531	13,11	38,10	RSRY - 708 - 00531	13,46	38,10
RDRY - 704 - 00625	15,85	38,10	RDRY - 701 - 00625	15,67	38,10	RDRY - 706 - 00625	15,50	38,10	RSRY - 708 - 00625	15,85	38,10
RDRY - 704 - 00687	17,42	38,10	RDRY - 701 - 00687	17,27	38,10	RDRY - 706 - 00687	17,07	38,10	RSRY - 708 - 00687	17,42	38,10
RDRY - 704 - 00812	20,60	38,10	RDRY - 701 - 00812	20,42	38,10	RDRY - 706 - 00812	20,25	38,10	RSRY - 708 - 00812	20,60	38,10

# ADJUSTMENT HOUSING COMPONENTS

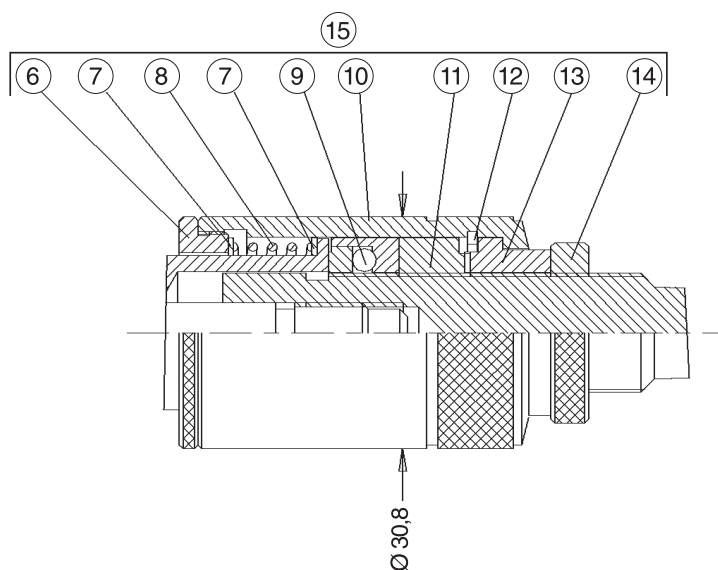
## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGH - 182 - 10000

S.C.A.M.I.®

From diam. 4,70 to 12,77 mm

Da diam. 4,70 a 12,77 mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZH-811-00000	1
7	Thrust washer / Ralla di bronzo	RDZH-010-03017	2
8	Release spring / Molla	RDZH-001-00005	1
9	Thrust bearing / Cuscinetto	RDZH-337-30001	1
10	Housing / Boccola	RDZH-182-00000	1
11	Micrometer nut / Innesto filettato	RDZH-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 26)	RDZH-106-03008	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZH-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZH-171-00000	1
15	Adjustment housing assembly / Boccola di registrazione	RDGH-182-10000	1

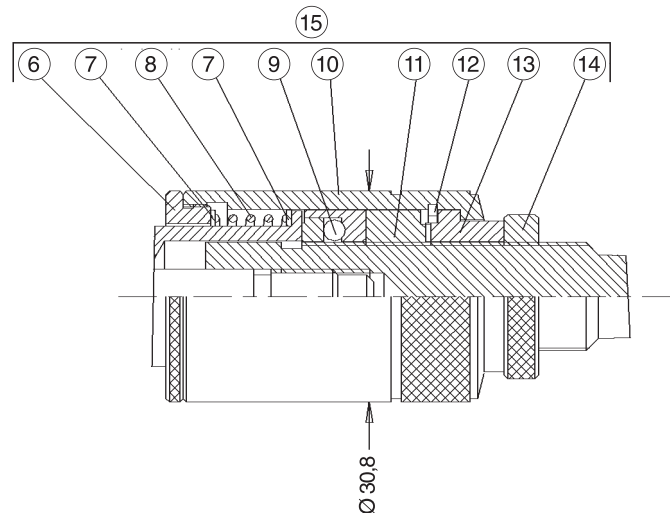
# ADJUSTMENT HOUSING COMPONENTS

## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGH - 182 - 00000

From diam. 12,64 to 35,86 mm

Da diam. 12,64 a 35,86mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZH-811-00000	1
7	Thrust washer / Ralla di bronzo	RDZH-010-03017	2
8	Release spring / Molla	RDZH-003-00005	1
9	Thrust bearing / Cuscinetto	RDZH-337-30001	1
10	Housing / Boccola	RDZH-182-00000	1
11	Micrometer nut / Innesto filettato	RDZH-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 26)	RDZH-106-03008	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZH-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZH-171-00000	1
15	Adjustment housing assembly / Boccola di registrazione	RDGH-182-00000	1



# ADJUSTMENT HOUSING COMPONENTS

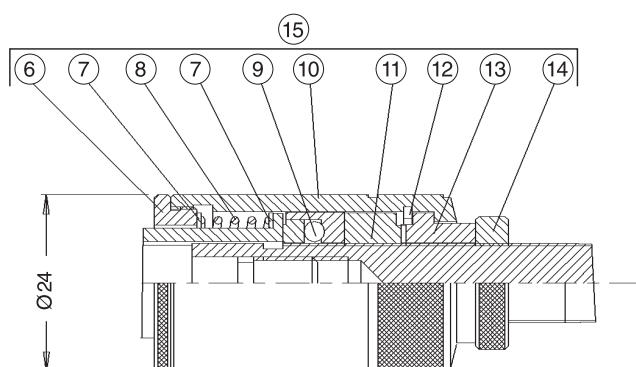
## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGF - 182 - 00000

S.C.A.M.I.®

From diam. 25,54 to 31,16 mm

Da diam. 25,54 a 31,16 mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZF-811-00000	1
7	Thrust washer / Ralla di bronzo	RDZF-010-03017	2
8	Release spring / Molla	RDZF-003-00005	1
9	Thrust bearing / Cuscinetto	RDZF-337-30001	1
10	Housing / Boccola	RDZF-182-00000	1
11	Micrometer nut / Innesto filettato	RDZF-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 20)	RDZF-106-03008	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZF-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZF-171-00000	1
15	Adjustment housing assembly / Boccola di registrazione	RDGF-182-00000	1

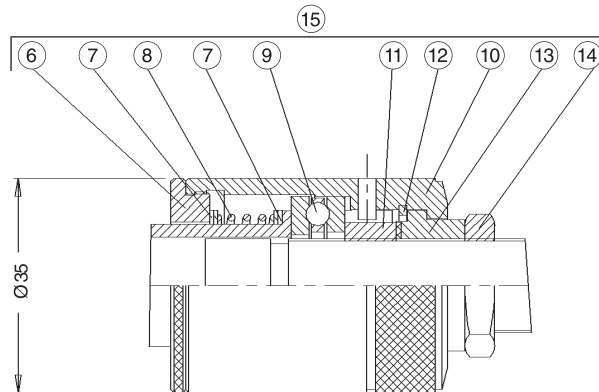
# ADJUSTMENT HOUSING COMPONENTS

## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGH - 182 - 08033

From diam. 35,61 to 46,97 mm

Da diam. 35,61 a 46,97 mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZH-811-08033	1
7	Thrust washer / Ralla di bronzo	RDZH-010-03017	2
8	Release spring / Molla	RDZH-003-00005	1
9	Thrust bearing / Cuscinetto 51103	RDZN-337-30001	1
10	Housing / Boccola	RDZH-182-08033	1
11	Micrometer nut / Innesto filettato	RDZH-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 26)	RDZH-106-03008	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZH-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZH-171-00000	1
15	Adjustment housing assembly / Boccola di registrazione	RDGH-182-08033	1

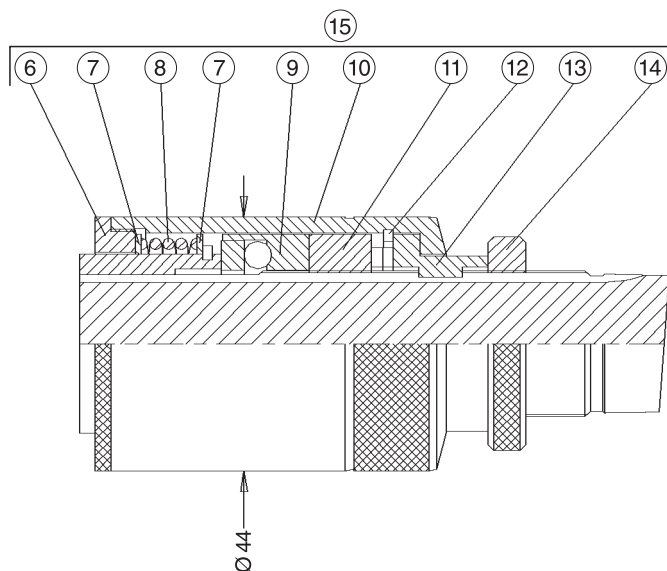
# ADJUSTMENT HOUSING COMPONENTS S.C.A.M.I.®

## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGO - 182 - 00000

From diam. 46,71 to 85,07 mm

Da diam. 46,71 a 85,07 mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZO-811-00000	1
7	Thrust washer / Ralla di bronzo	RDZO-010-03018	2
8	Release spring / Molla	RDZO-003-00008	1
9	Thrust bearing / Cuscinetto	RDZO-337-30018	1
10	Housing / Boccia	RDZO-182-00000	1
11	Micrometer nut / Innesto filettato	RDZO-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 39)	RDZO-106-03009	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZO-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZO-171-00000	1
15	Adjustment housing assembly / Boccia di registrazione	RDGO-182-00000	1

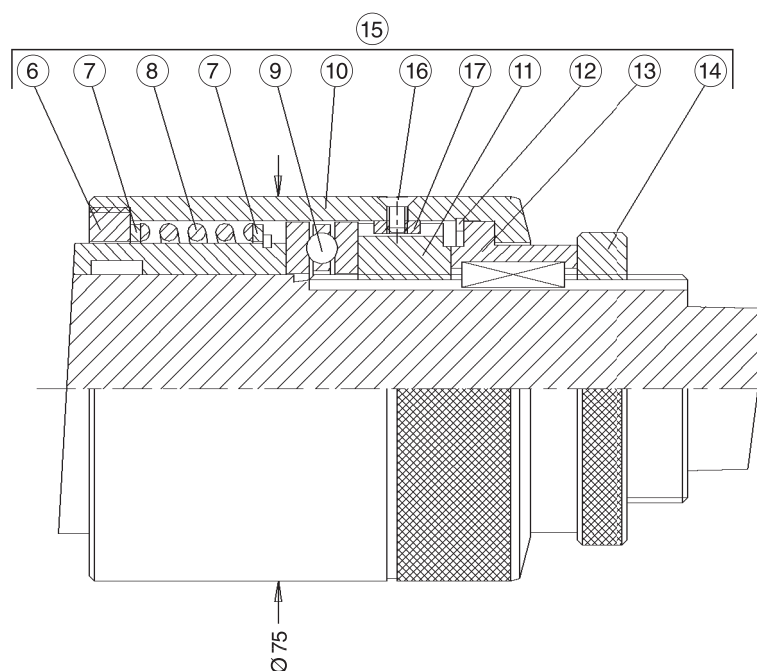
# ADJUSTMENT HOUSING COMPONENTS

## COMPONENTI BOCCOLA DI REGISTRAZIONE

### SERIES / SERIE RDGR - 182 - 00000

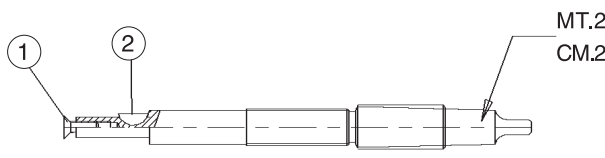
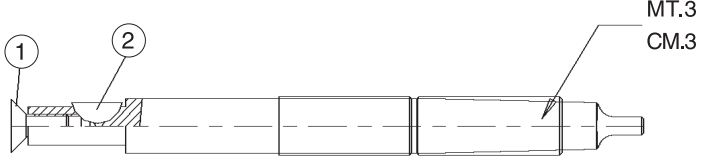
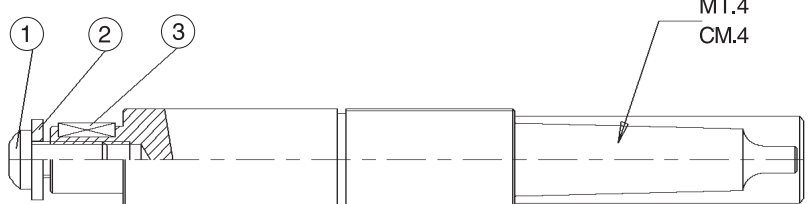
From diam. 84,81 to 165,90 mm

Da diam. 84,81 a 165,90 mm



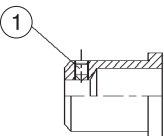
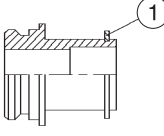
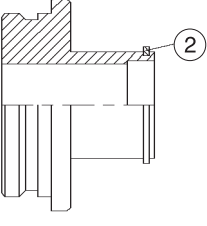
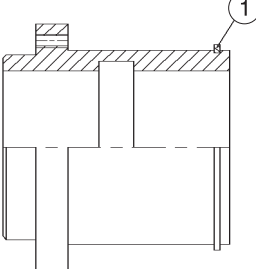
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
6	Housing nut / Tappo	RDZR-825-00000	1
7	Thrust washer / Ralla di bronzo	RDZR-010-03019	2
8	Release spring / Molla	RDZR-003-00010	1
9	Thrust bearing / Cuscinetto 51109	RDZR-025-05003	1
10	Housing / Boccola	RDZR-182-00000	1
11	Micrometer nut / Innesto filettato	RDZR-151-00000	1
12	Micro nut retaining ring / Anello di tenuta (seeger SB 65)	RDZR-106-03010	1
13	Micrometer nut lock sleeve / Innesto con chiavetta	RDZR-161-00000	1
14	Adjustment lock nut / Ghiera di bloccaggio	RDZR-171-00000	1
15	Adjustment housing assembly / Boccola di registrazione	RDGR-182-00000	1
16	Screw / Vite	RDZR-020-10007	1
17	Key / Chiavetta	RDZR-022-01001	1

# SHANK COMPONENTS COMPONENTI ATTACCHI

From diam. 30,85 to 46,97 mm Da diam. 30,85 a 46,97 mm			
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Vite dell'asta	RDZM-020-30001	1
2	Key / Chiavetta	RDZM-006-01039	1
From diam. 46,71 to 85,07 mm Da diam. 46,71 a 85,07 mm			
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Vite dell'asta	RDZO-020-10004	1
2	Key / Chiavetta	RDZO-006-01004	1
From diam. 84,81 to 165,90 mm Da diam. 84,81 a 165,90 mm			
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Vite dell'asta	RDZR-010-10012	1
2	Screw spacer / Distanziale	RDZR-005-01028	1
3	Key / Chiavetta	RDZR-006-01003	1

# CAGE SLEEVE COMPONENTS

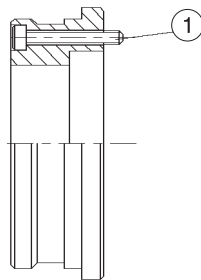
## COMPONENTI GUIDAGABBIA

From diam. 4,70 to 12,77 mm Da diam. 4,70 a 12,77 mm			
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Grano	RDZH-040-00500	3
From diam. 30,85 to 46,97 mm Da diam. 30,85 a 46,97 mm		From diam. 46,71 to 85,07 mm Da diam. 46,71 a 85,07 mm	
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Retaining ring Anello di tenuta (seeger SW-20)	RDZM-010-10052	1
2	Retaining ring Anello di tenuta (seeger SW-30)	RDZO-010-10028	1
From diam. 84,81 to 165,90 mm Da diam. 84,81 a 165,90 mm			
			
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Retaining ring Anello di tenuta (seeger SW-55)	RDZR-010-10029	1

# CAGE ADAPTER COMPONENTS

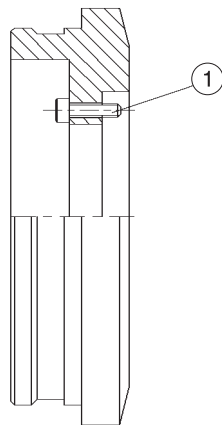
## COMPONENTI FLANGE

From diam. 84,81 to 104,12 mm  
Da diam. 84,81 a 104,12 mm



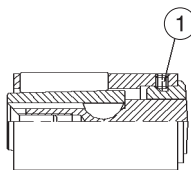
Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Vite	RDZR-001-10034	4

From diam. 103,86 to 165,90 mm  
Da diam. 103,86 a 165,90 mm



Item Particolare	Description Descrizione	Code Codice	Qty Qtà
1	Screw / Vite	RDZS-001-10063	4



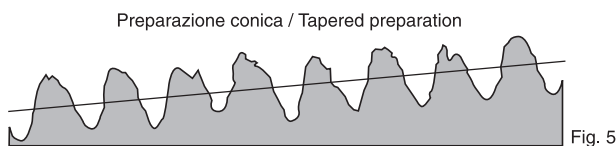
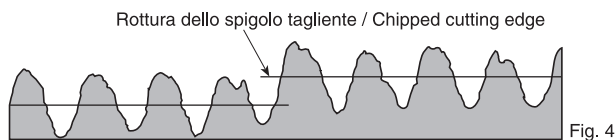
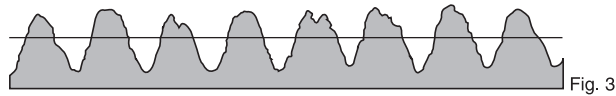


Adjustment range Campo di regolazione mm min. max.	Item Particolare	Description Descrizione	Code Codice	Qty Qtà
16,60 - 19,99	1	Screw / Grano	RDZK-030-00300	3
19,74 - 24,74	1	Screw / Grano	RDZK-030-00400	3
24,54 - 28,77	1	Screw / Grano	RDZK-040-00400	3
28,55 - 31,16	1	Screw / Grano	RDZK-040-00500	3
30,85 - 36,66	1	Screw / Grano	RDZK-040-00400	3
36,40 - 40,62	1	Screw / Grano	RDZK-040-00500	3
40,36 - 46,97	1	Screw / Grano	RDZK-040-00600	3
46,71 - 50,14	1	Screw / Grano	RDZK-060-00500	3
49,88 - 54,91	1	Screw / Grano	RDZK-060-00600	3
54,66 - 56,49	1	Screw / Grano	RDZK-060-00800	3
56,23 - 59,67	1	Screw / Grano	RDZK-060-00500	3
59,41 - 65,22	1	Screw / Grano	RDZK-060-00600	3
64,97 - 69,19	1	Screw / Grano	RDZK-060-00800	3
68,93 - 72,40	1	Screw / Grano	RDZK-060-00600	3
72,11 - 80,31	1	Screw / Grano	RDZK-060-00800	3
80,06 - 85,07	1	Screw / Grano	RDZK-060-01000	3
84,81 - 93,02	1	Screw / Grano	RDZK-080-00600	3
92,76 - 100,15	1	Screw / Grano	RDZK-080-00800	3
99,90 - 104,12	1	Screw / Grano	RDZK-080-01000	3
103,86 - 110,47	1	Screw / Grano	RDZK-080-00600	3
110,21 - 116,82	1	Screw / Grano	RDZK-080-00800	3
116,56 - 127,94	1	Screw / Grano	RDZK-080-01000	3
127,90 - 132,90	1	Screw / Grano	RDZK-080-00600	3
132,90 - 138,90	1	Screw / Grano	RDZK-080-00800	3
138,90 - 149,90	1	Screw / Grano	RDZK-080-01000	3
149,90 - 154,90	1	Screw / Grano	RDZK-080-00600	3
154,90 - 159,90	1	Screw / Grano	RDZK-080-00800	3
159,90 - 165,90	1	Screw / Grano	RDZK-080-01000	3

# PREPARATION FOR ROLLER BURNISHING

## PREPARAZIONE ALLA RULLATURA

S.C.A.M.I.®



### PREPARATION FOR ROLLER BURNISHING

Roller burnishing is a cold working process for obtaining fine finishings.

We remind you some helpful considerations in order to obtain an excellent result:

- **FINISHING:** the ductility and hardness of the workpiece material and the surface preparation dictates the quality of the burnished finish.
- **WORKABILITY:** any ductile and malleable material up to RC40 can be roller burnished.
- **WORKED SURFACE PROPERTIES:** workpieces with an interrupted surface of no more than 10% of the circumference can be successfully burnished with a standard tool. (see fig.1 & 2).
- **TOLERANCE OF THE BURNISHED PIECE:** the tolerance range achieved from the burnishing will be equal to that achieved from the pre machining as no material will be removed.

The ideal surface for the burnishing is a succession of peaks, which corresponds on regular feed of the preparation tool (fig. 3)

We suggest the ALVAN® expanding reamer for the pre-burnishing as it assures a uniform roughness and a tolerance in the range ISO6 - ISO7.

Attention must be paid to pre machining tapers and surface irregularities caused by cutting tool failure as these conditions cannot be rectified by the roller burnishing operation (see fig.4 & 5).

### PREPARAZIONE ALLA RULLATURA

La rullatura è un procedimento di lavorazione per ottenere delle superfiniture.

Rammentiamo alcune considerazioni utili al fine di un ottimo risultato:

- **FINITURA:** la finitura superficiale è funzione della durezza e duttilità del pezzo e della rugosità che si ottiene nella preparazione alla rullatura.
- **LAVORABILITÀ DEL PEZZO:** si può dire che ogni materiale lavorabile all'utensile può essere rullato. In linea generale è meglio che la durezza del pezzo non superi i 40 HRC.
- **CARATTERISTICHE DELLA SUPERFICIE LAVORATA:** è sempre meglio che la superficie lavorata non presenti discontinuità. Ad ogni modo è importante che la larghezza di una eventuale interruzione non superi il 10% del diametro del pezzo rullato. Numero minimo di rullini = 5
- **TOLLERANZA DEL PEZZO RULLATO:** la tolleranza che si vuole ottenere dopo la rullatura, occorre che sia già rispettata nella preparazione.

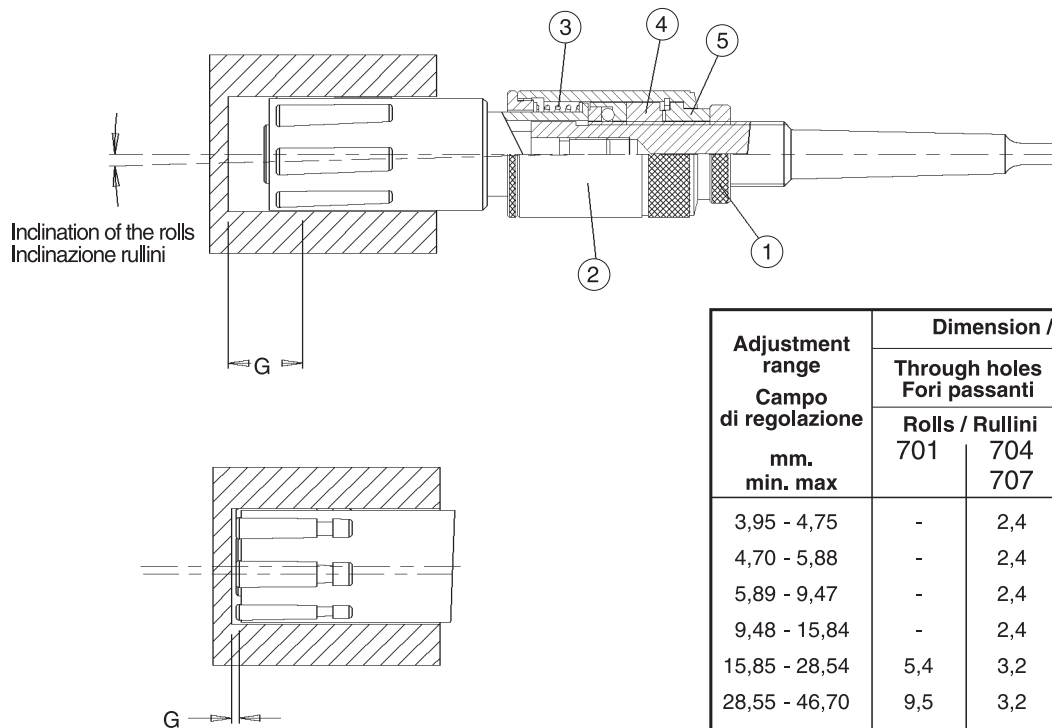
La superficie ideale per la rullatura è quella che si ottiene come successione di creste, corrispondenti ad un avanzamento regolare dell'utensile preparatore (fig. 3).

Come utensile di pre-rullatura, suggeriamo l'alesatore ALVAN®, in quanto assicura una rugosità uniforme ed una tolleranza nel campo ISO6 - ISO7.

Nella preparazione alla rullatura occorre prestare attenzione ad eventuali errori di conicità e ad errori dovuti a scheggiature dello spigolo tagliente. Infatti il rullatore non è in grado di rimediare ad errori di conicità né a solchi troppo evidenti già in fase di preparazione (vedi fig. 4 e 5). Lo spessore minimo della cartella rullabile è pari al 10% del diametro da rullare.

# ADJUSTMENT & HOW THE ROLLER BURNISHING TOOL WORKS

## REGISTRAZIONE E FUNZIONAMENTO DEL RULLATORE



Adjustment range Campo di regolazione mm. min. max	Dimension / Quota "G"		
	Through holes Fori passanti		Blind holes Fori ciechi
	Rolls / Rullini 701	704 707	Rolls / Rullini 708
3,95 - 4,75	-	2,4	-
4,70 - 5,88	-	2,4	-
5,89 - 9,47	-	2,4	0,6
9,48 - 15,84	-	2,4	0,6
15,85 - 28,54	5,4	3,2	1,0
28,55 - 46,70	9,5	3,2	1,0
46,71 - 84,80	9,5	4,0	1,0
84,81 - 165,90	10,3	4,7	1,0

### Adjustment

The roller burnishing tool incorporates a shank, a body and a planetary system of conical rolls which are evenly spaced by a retaining cage.

Before use, the burnishing tool must be adjusted to the required working diameter using the following steps:

- 1) unscrew the lock nut (item 1);
- 2) pull the housing (item 2) towards the lock nut and turn to increase or decrease the diameter;
- 3) ensure that the micrometer nut and sleeve (item 4 and 5) are engaged.
- 4) tighten the lock nut.

### How it works

The roller burnishing tool must be aligned with the workpiece (maximum error 0,1); if there are doubts on the alignment error, a floating shank is needed.

When the tool is in the bore, the cone pushes the rolls onto the surface to be burnished. The cage retains the rolls in an angled position to the axis of the tool, so the pressure of the burnishing generates a self feed that draws the tool into the bore. When self feed is not required, i.e. blind hole applications, you must use a cage which holds the rolls parallel with the axis of the tool. If the machine feed is stopped or slower than the natural rate, the rolls pull the cage, held in position by the release spring (item 3), and they then release from the surface of the bore. The release of the rolls permits the quick retraction from the bore (see table dimension "G").

The release spring will ensure the rolls are in the correct position to burnish the required diameter.

The roller burnishing tool requires lubrication not cooling. A plentiful supply of lubricant must be fed directly to tool to provide a good flushing and cleaning action. It is recommended that a filter is fitted to the lubrication system to prevent the circulation of chips which may cause damage to the burnished surface and the tool.

### Registrazione

Il rullatore è costituito da un attacco, un corpo ed un sistema planetario di rullini conici, tenuti in posizione da una gabbia. L'impiego del rullatore deve essere preceduto dalla regolazione alla misura di lavoro; tale operazione si esegue:

- 1) svitare la ghiera di bloccaggio (part.1);
- 2) tirare la boccola di registrazione (part.2) verso la ghiera di bloccaggio e ruotarla a seconda se si vuole aumentare o diminuire il diametro;
- 3) rilasciare la boccola di registrazione facendo attenzione che gli innesti (part.4 e 5) siano agganciati;
- 4) avvitare la ghiera di bloccaggio.

### Funzionamento

L'utensile deve essere allineato col pezzo (errore massimo 0,1); quando esistono dubbi sull'errore di allineamento, si deve utilizzare un attacco flottante.

Quando l'utensile entra in presa sul pezzo, l'asta conica forza i rullini contro la superficie da rullare. I rullini conici sono tenuti dalla gabbia in una posizione inclinata rispetto all'asse dell'utensile e pertanto la pressione di rullatura genera una componente assiale che tira l'utensile nel pezzo e viceversa. Quando si richiede la rullatura di fori ciechi, si ricorre alla gabbia che tiene i rullini dritti. Se il rullatore non penetra nel pezzo con l'avanzamento richiesto da tale componente, i rullini trascinano in avanti la gabbia che è tenuta in posizione dalla molla (part.3) e si sganciano dalla superficie lavorata, con conseguente discontinuità di finitura e di misura. Peraltro, la possibilità di sganciare i rullini dalla superficie lavorata consente l'estrazione rapida del pezzo (vedi tabella quota "G"). Provvederà la molla a riportare i rullini in posizione di lavoro, alla misura fissata.

Il rullatore necessita di lubrificazione. Qualsiasi olio lubrificante o miscela di olio solubile è utilizzabile. Il lubrificante deve arrivare sull'utensile con continuità ed abbondanza. È indispensabile l'impiego di un filtro per impedire che i trucioli siano trascinati in circolo, con conseguente danno all'utensile ed alla superficie del pezzo rullato.

# TECHNICAL INFORMATION

## INDICAZIONI TECNICHE

Material to work Materiale da lavorare	Hole diameter Diametro del foro mm	Stock allowance on Ø Sovrametallo sul Ø	Surface finish (Ra) / Rugosità (Ra)	
			Before roller burnishing Prima della rullatura	After roller burnishing Dopo la rullatura
High ductility Molto duttile	3 - 12	0,010 - 0,018	1,6 - 3,2	0,2
	12 - 25	0,018 - 0,040	1,6 - 3,2	0,2
	25 - 50	0,025 - 0,045	1,6 - 3,2	0,2
	50 - 165	0,030 - 0,050	2,0 - 5,0	0,2
	165 - 300	0,030 - 0,050	2,0 - 5,0	0,2
Low ductility Poco duttile	3 - 12	0,010 - 0,018	1,6 - 2,3	0,3
	12 - 25	0,012 - 0,018	1,6 - 3,0	0,3
	25 - 50	0,012 - 0,025	1,6 - 3,2	0,3
	50 - 165	0,020 - 0,035	2,0 - 4,0	0,3
	165 - 300	0,020 - 0,035	2,0 - 4,0	0,3

Hole diameter Diametro del foro mm	Feed mm / rev Auto avanzamento mm / giro	Speed RPM Velocità giri / min
5	0,10	1200
7	0,15	
8	0,18	
10	0,25	900
13	0,28	
16	0,38	
18	0,45	
20	0,50	600
25	0,64	
30	0,76	
35	1,10	
40	1,20	
45	1,30	
50	1,70	300
55	1,80	
60	1,90	
65	2,10	
70	1,90	
75	2,00	
85	2,50	
100	2,30	200
120	2,70	
140	3,20	
165	3,90	

### High ductility materials

They have less than 30 RC and more 18% elongation  
E.g. stainless steel, annealed steel, aluminium, brass, bronze and malleable iron

### Low ductility materials

Have less than 40 RC and less than 18% elongation  
E.g.: nodular iron, grey cast iron, heat treated steel, magnesium alloys and hard copper alloys.

### Materiali molto duttili

Durezza inferiore a 30 HRC, con allungamento percentuale dopo rottura superiore al 18%  
Es.: acciai a basso tenore di carbonio, acciai da costruzione ricotti, acciai inox, alluminio, ottone, ghisa malleabile, rame.

### Materiali poco duttili

Durezza inferiore a 40 HRC, con allungamento percentuale dopo rottura inferiore al 18%  
Es.: ghisa grigia, acciai bonificati, leghe al magnesio.

RPM can be increased or decrease according to the material to work.  
The chart is for guide purposes only; in different conditions the results may vary.  
Excessive roller burnishing accelerates tool wear and can produce flaking on the burnished surface.

Il numero dei giri / min può essere aumentato o diminuito in funzione del tipo di materiale lavorato.  
Mantenersi sui valori della tabella; valori eccessivi della velocità o dell'avanzamento riducono la durata dell'utensile.

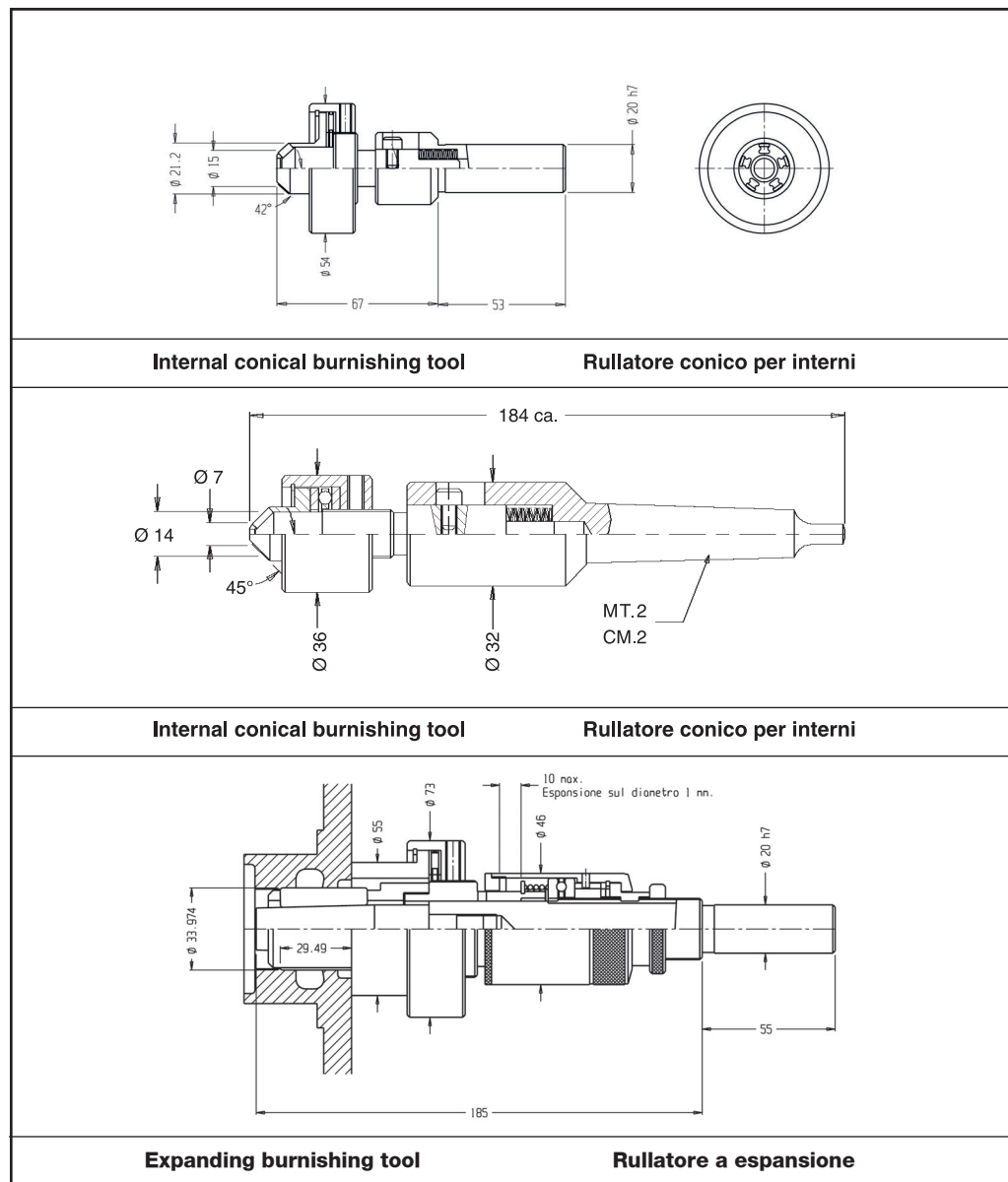
# EXAMPLE OF SPECIAL ROLLER BURNISHING TOOLS ESEMPI DI RULLATORI SPECIALI

Roller burnishing tools which require special working lengths or shanks can be supplied on request.

SCAMI have proven designs of Roller Burnishing equipment to suit most applications. The following pages show but a few innovations incorporating many standard sub assemblies. Moreover, depending on the application there are different kinds of burnishing tools.

Su richiesta tutti i rullatori possono essere forniti con diverse lunghezze di rullatura e di attacchi speciali.

Inoltre a seconda dell'applicazione esistono diversi tipi di rullatori.







# EXTERNAL ROLLER BURNISHING TOOLS RULLATORI PER ESTERNI





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Body components - Series RAWB / Componenti del corpo - Serie RAWB	page / pag.	108
Body components - Series RAWC / Componenti del corpo - Serie RAWC	page / pag.	109
Body components - Series RAWD / Componenti del corpo - Serie RAWD	page / pag.	110
Adjustment & How the roller burnishing tool works		
Registrazione e funzionamento del rullatore	page / pag.	111
Technical Information		
Indicazioni tecniche	page / pag.	112
Instructions for assembly and disassembly (Ø2,74 ÷ Ø 11,95)	page / pag.	113
Istruzioni per il montaggio e lo smontaggio (Ø2,74 ÷ Ø 11,95)	page / pag.	114
Instructions for assembly and disassembly (Ø11,96 ÷ Ø 95,35)	page / pag.	115
Istruzioni per il montaggio e lo smontaggio (Ø11,96 ÷ Ø 95,35)	page / pag.	116



## Diamond roller burnishing tool

Single-roller with diamond tip for super finishing materials with hardness up to 65 HRC

- The tool is available to realise surface roughness in the Ra range between 0,05 and 0,15 micron.
- Diamond with radius: 0,8 - 1,2 - 2,0
- Working angle adjustable in 15° steps



### Code to order

DRS-A1616-R08

DRS-A2020-R08

DRS-A2525-R08

DRS-A1616-R12

DRS-A2020-R12

DRS-A2525-R12

DRS-A1616-R20

DRS-A2020-R20

DRS-A2525-R20

### Description

square Ø 16 with diamond R0.8

square Ø 20 with diamond R0.8

square Ø 25 with diamond R0.8

square Ø 16 with diamond R1.2

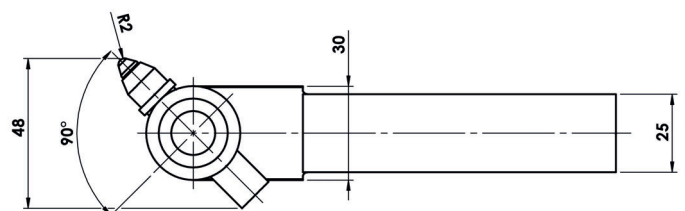
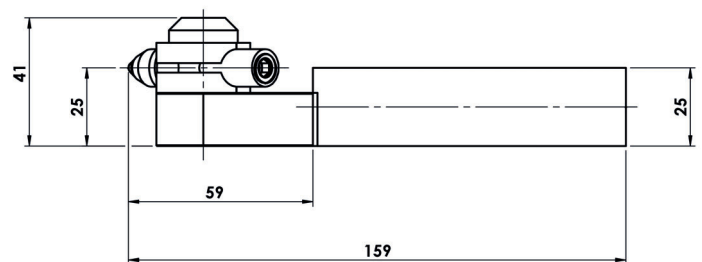
square Ø 20 with diamond R1.2

square Ø 25 with diamond R1.2

square Ø 16 with diamond R2.0

square Ø 20 with diamond R2.0

square Ø 25 with diamond R2.0



# CODE DESCRIPTION OF THE COMPLETE ROLLER BURNISHING TOOL

S.C.A.M.I.®

**R A K A - 1 0 0 - 0 0 3 2 4**

**A**

**B**

**C**

**D**

**E**

**A**

A = Roller burnishing tools for through holes  
B = Roller burnishing tools for bottoming style

**B**

Burnishing tool series A =  $\varnothing 2,74 \div 11,95$  mm.  
Burnishing tool series B =  $\varnothing 11,96 \div 38,20$  mm.  
Burnishing tool series C =  $\varnothing 38,21 \div 66,77$  mm.  
Burnishing tool series D =  $\varnothing 66,78 \div 95,35$  mm.

**C**

1 = straight shank  
2 = morse taper shank

**D**

0 = steel cone  
H = high speed steel cone  
2 = cage for through style without self-feed series  
4 = cage for bottoming style with self-feed series

**E**

Roller burnishing tools for through style = maximum diameter of burnishing range  
Roller burnishing tools for bottom style = diameter to burnish

# IDENTIFICAZIONE CODICE DEL RULLATORE COMPLETO

**R A K A - 1 0 0 - 0 0 3 2 4**

**A**

**B**

**C**

**D**

**E**

**A**

A = Rullatore per esecuzione passante  
B = Rullatore per esecuzione con battuta

**B**

Rullatore serie A = Ø 2,74 ÷ 11,95 mm.  
Rullatore serie B = Ø 11,96 ÷ 38, 20 mm.  
Rullatore serie C = Ø 38,21 ÷ 66,77 mm.  
Rullatore serie D = Ø 66,78 ÷ 95,35 mm.

**C**

1 = attacco cilindrico  
2 = attacco C.M.

**D**

0 = asta in acciaio  
H = asta in acciaio superrapido  
2 = gabbia per esecuzione passante senza autoavanzamento  
4 = gabbia per esecuzione a battuta con autoavanzamento

**E**

Rullatore per esecuzione passante = diametro massimo della gamma di rullatura  
Rullatore per esecuzione a battuta = diametro da rullare

# CODE DESCRIPTION OF THE REDUCED CONES

S.C.A.M.I.®

## FOR ROLLER BURNISHING TOOLS BOTTOMING STYLE

### Method for the identification of number "x" contained in the code of the bottoming style cones.

With burnishing tools for bottoming style the cone must not extend past the end of the rolls, otherwise it risks the collision. Each burnishing tool has an adjustment range of approximately 0,4 mm on diameter for tools below Ø 11,95 and 0,8 mm for tools above Ø 11,95 mm.

For through burnishing tools style the standard cone value "x" is 1. If the standard cone is used for bottoming style it will not extend past the end of the rolls only when the tool is set to the maximum value of the adjustment range. However, if an external diameter bottoming style to be burnished is greater than the maximum diameter of the tool, then a reduced diameter cone is required.

With these applications the "x" be (always an integer number) in the range from 2 to 8.

#### CASE A - RULE FOR THE IDENTIFICATION OF THE REDUCED CONE (burnishing tools from Ø 2,74 to 11,95)

$$"x" = 1 + \frac{Z - Y}{0,05}$$

Z= diameter to be burnished

Y= maximum diameter setting of the burnishing tool in question (see tables on following pages).

As a consequence of the above mentioned calculation, the "x" value could culminate as a decimal figure. This must be approximated to an integer value below or above if decimal figure is greater than 0,8 mm.

**Example:**

Z = diameter to be burnished 6,5 mm. Y = maximum diameter setting 6,8 mm.

$$"x" = 1 + \frac{6,8 - 6,5}{0,05} = 7$$

The correct cone is: **RBTA - 037- 00017**

#### CASE B - RULE FOR THE IDENTIFICATION OF THE REDUCED CONE (burnishing tools from Ø 11,96 to 95,35)

**Example :**

Z= diameter to be burnished 17,76 mm. Y=maximum diameter setting 18,33 mm

$$"x" = 1 + \frac{18,33 - 17,76}{0,1} = 6,7 \quad \text{which is approximated at } "x" = 6$$

The correct cone is: **RBTB - 036 - 00039**

# IDENTIFICAZIONE CODICE DELLE ASTE RIDOTTE

## RULLATORI PER ESECUZIONE CON BATTUTA

### Metodo per l'identificazione del numero "x" contenuto nel codice di ogni asta per esecuzione con battuta.

Nei rullatori per esterni con battuta l'asta conica non deve sporgere oltre i rulli altrimenti si rischia la collisione pertanto, va individuata l'asta corretta che non sporga. Ogni rullatore ha un campo di regolazione di circa 0,4 mm su diametri inferiori a 11,95 mm e di circa 0,8 mm per quelli superiori. L'asta per la quale il valore "x" è uguale a 1 è quella normalmente utilizzata per i rullatori per fori passanti e, qualora venga utilizzata nel corrispondente rullatore con battuta, non sporge rispetto ai rulli solamente se il rullatore è regolato al valore massimo del suo campo di regolazione. Qualora occorra rullare un diametro esterno con battuta che si colloca su un valore intermedio del campo di regolazione, bisogna necessariamente ricorrere ad un'asta ridotta, per la quale il valore "x" (numero intero) varia tra i valori 2 e 8.

#### CASO A - CALCOLO PER L'IDENTIFICAZIONE DELL'ASTA RIDOTTA (rullatori dal Ø 2,74 a 11,95)

$$"x" = 1 + \frac{Z-Y}{0,05}$$

Z= diametro da rullare

Y = diametro massimo del campo di regolazione del rullatore in oggetto (vedi tabelle nelle pagine seguenti).

Dal calcolo di cui sopra "x" sarà un valore con decimali dopo la virgola. Occorre approssimarlo al valore intero inferiore a meno che il decimale sia uguale o superiore 0,8, nel cui caso va approssimato al numero intero superiore.

**Esempio:** z = diametro da rullare 6,5 mm. Y = diametro massimo della gamma 6,8 mm.

$$"x" = 1 + \frac{6,8 - 6,5}{0,05} = 7$$

L'asta corretta da ordinare sarà pertanto: **RBTA - 037 - 00017**

#### CASO B - CALCOLO PER L'IDENTIFICAZIONE DELL'ASTA RIDOTTA (rullatori dal Ø 11,96 a 95,35)

**Esempio:** z = diametro da rullare 17,76 mm. Y = diametro massimo della gamma 18,33 mm.

$$"x" = 1 + \frac{18,33-17,76}{0,1} = 6,7 \text{ approssimando } "x" = 6$$

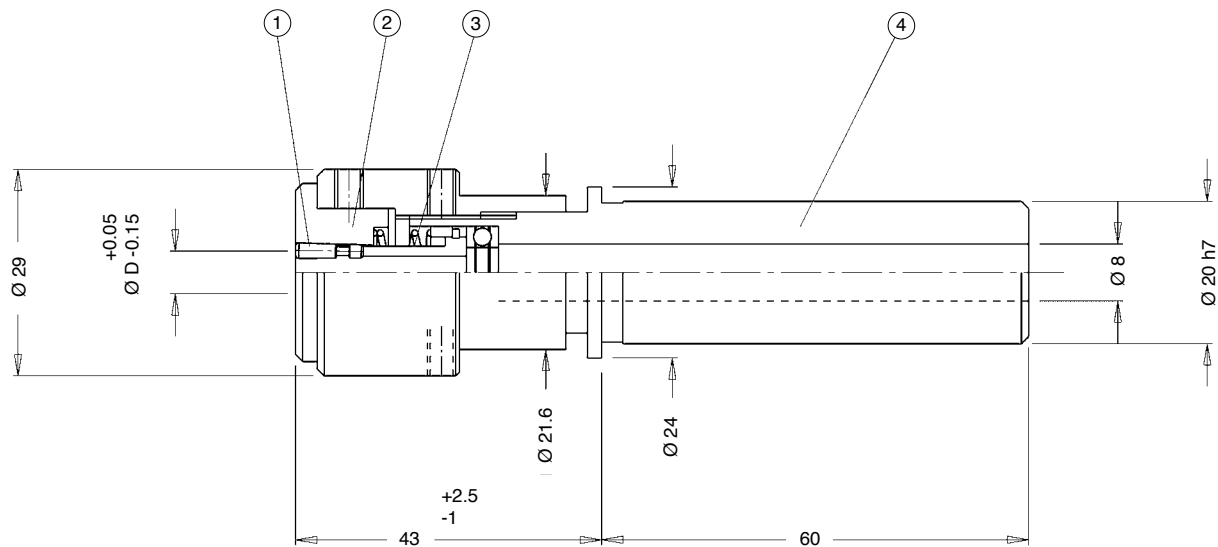
L'asta corretta da ordinare sarà pertanto: **RBTB - 036 - 00039**

# EXTRA SHORT ROLLER BURNISHING TOOLS - SERIES RAKM

## RULLATORI EXTRACORTI - SERIE RAKM

From diam. 2,70 to 6,50 mm.

Da diam. 2,70 a 6,50 mm.



<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>		<b>D</b>	
Adjustment range	Cage	Cone	Rolls		Rolls	
Corpo base completo pos.4	Gabbia pos.3	Asta pos. 2	Rullini da Ø 2,70 a Ø 4,50 pos. 1	Rolls qty / Qtà rullini	Rullini da Ø 4,51 a Ø 6,50 pos. 1	Rolls qty / Qtà rullini
RAWM-020-00000	RACM-000-00xxx*	RATM-000-00xxx*	RSRY-708-00086	4	RSRY-708-00086	5

Code of the complete roller burnishing tool

Codice del rullatore completo:

RAKM-120-00xxx \*

\* 00xxx = Diameter to work / Diametro da rullare

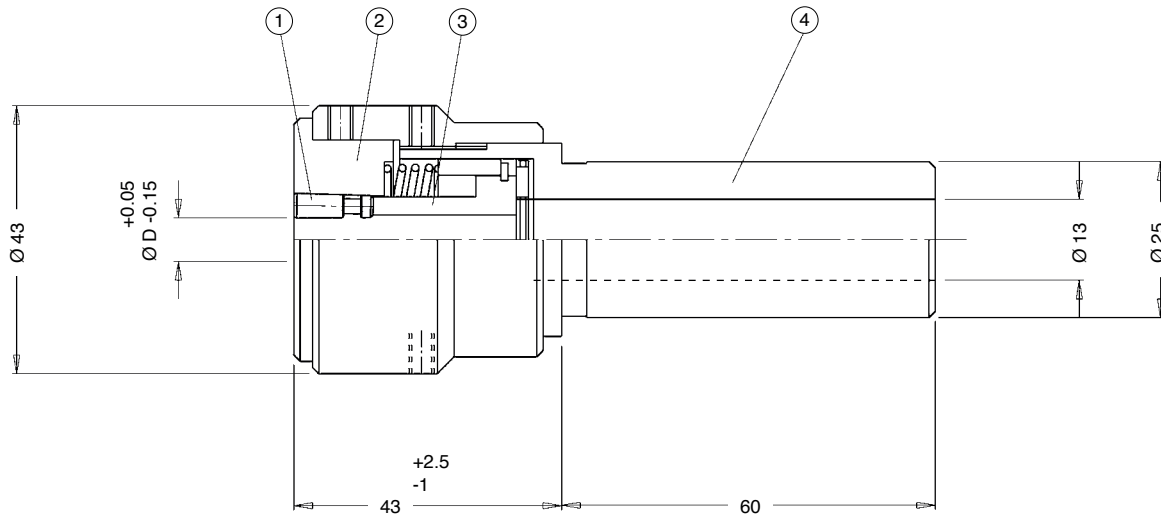
es. Ø 6,05 = 00605



# EXTRA SHORT ROLLER BURNISHING TOOLS - SERIES RAKN RULLATORI EXTRACORTI - SERIE RAKN

From diam. 6,51 to 12,50 mm.

Da diam. 6,51 a 12,50 mm.



<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	
Adjustment range	Cage	Cone	Rolls	Rolls qty / Qtà rullini
Corpo base completo pos.4	Gabbia pos.3	Asta pos. 2	Rullini pos. 1	
RAWN-025-00000	RACN-000-0xxxx*	RATN-000-0xxxx*	RSRY-708-00156	
				5

Code of the complete roller burnishing tool

Codice del rullatore completo:

RAKN-125-0xxxx \*

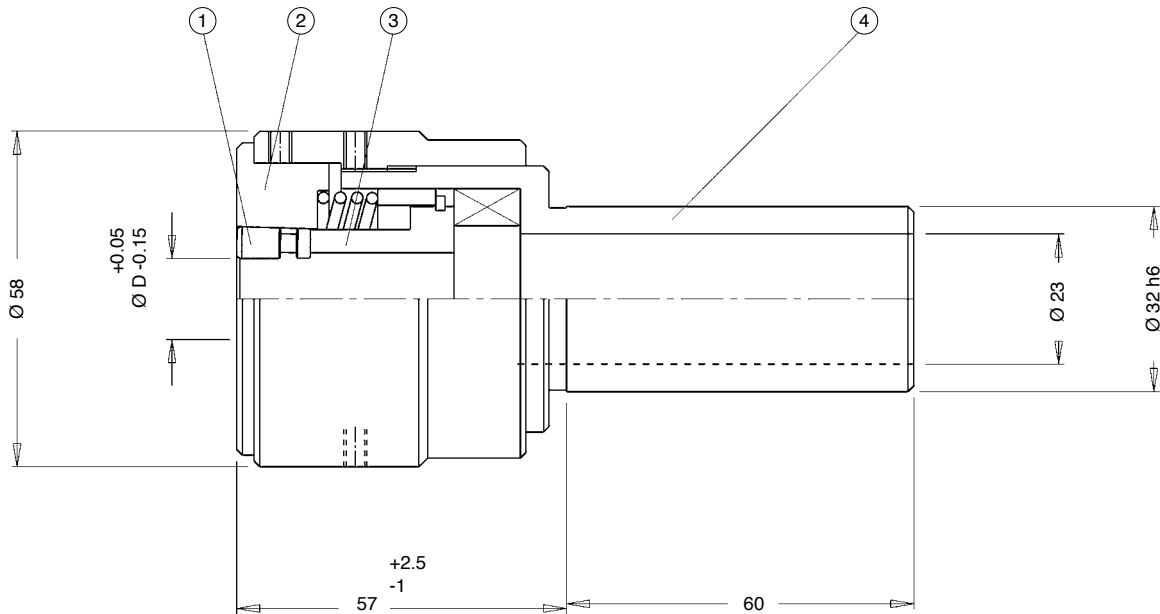
\* 0xxxx = Diameter to work / Diametro da rullare

es. Ø 12,05 = 01205

# EXTRA SHORT ROLLER BURNISHING TOOLS - SERIES RAKO RULLATORI EXTRACORTI - SERIE RAKO

From diam. 12,51 to 22,50 mm.

Da diam. 12,51 a 22,50 mm.



<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	
Adjustment range	Cage	Cone	Rolls	Rolls qty / Qtà rullini
Corpo base completo	Gabbia	Asta	Rullini	
pos.4	pos.3	pos. 2	pos. 1	
RAWO-032-00000	RACO-000-0xxxx*	RATO-000-0xxxx*	RSRY-705-00218	5

Code of the complete roller burnishing tool

Codice del rullatore completo:

RAKO-132-0xxxx \*

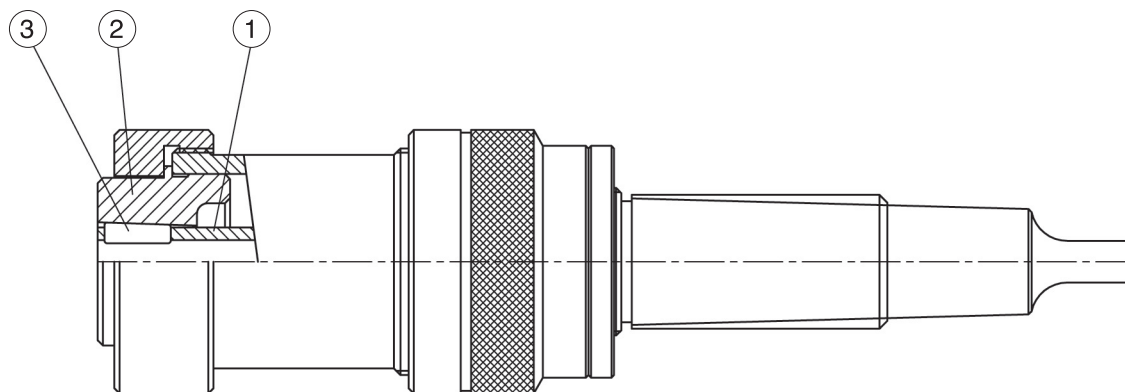
\* 0xxxx = Diameter to work / Diametro da rullare

es. Ø 16,00 = 01600



From diam. 2,74 to 11,95 mm.

Da diam. 2,74 a 11,95 mm.

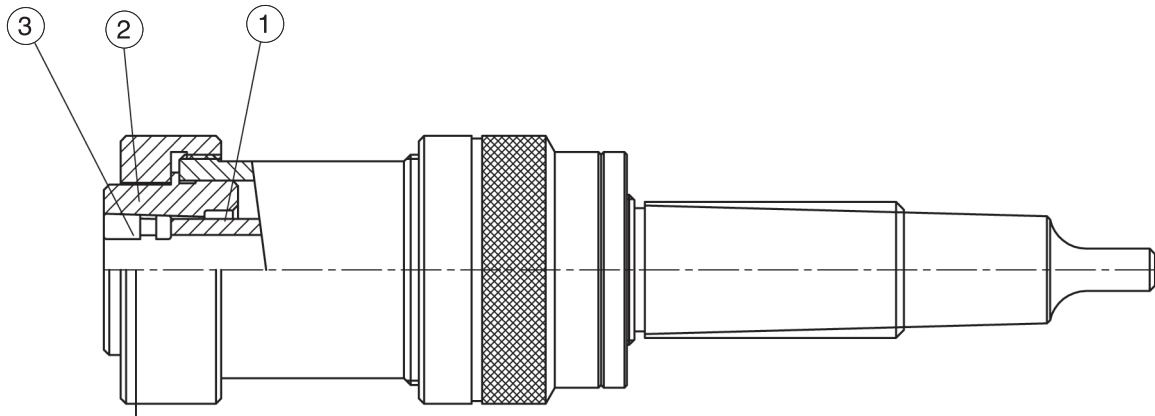


THROUGH STYLE / ESECUZIONE PASSANTE				
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos.1	<b>C</b> Cone Asta pos.2	<b>D</b> Rolls Rulli pos.3	Rolls qty / Qtà rulli
2,74 - 3,24	RACA-011-00008	RATA-031-00008	RDRY-704-00156	4
3,25 - 3,62	RACA-011-00009	RATA-031-00009		
3,63 - 4,03	RACA-011-00010	RATA-031-00010		
4,04 - 4,41	RACA-011-00011	RATA-031-00011		
4,42 - 4,81	RACA-011-00012	RATA-031-00008	RDRY-704-00125	5
4,82 - 5,22	RACA-011-00013	RATA-031-00009		
5,23 - 5,60	RACA-011-00014	RATA-031-00010		
5,61 - 6,01	RACA-011-00015	RATA-031-00011		
6,02 - 6,42	RACA-011-00016	RATA-031-00016	RDRY-704-00156	
6,43 - 6,80	RACA-011-00017	RATA-031-00017		
6,81 - 7,20	RACA-011-00018	RATA-031-00018		
7,21 - 7,58	RACA-011-00019	RATA-031-00019		
7,59 - 7,99	RACA-011-00020	RATA-031-00020	RDRY-704-00125	
8,00 - 8,40	RACA-011-00021	RATA-031-00017		
8,41 - 8,78	RACA-011-00022	RATA-031-00018		
8,79 - 9,18	RACA-011-00023	RATA-031-00019		
9,19 - 9,59	RACA-011-00024	RATA-031-00024	RDRY-704-00218	
9,60 - 9,97	RACA-011-00025	RATA-031-00025		
9,98 - 10,37	RACA-011-00026	RATA-031-00026		
10,38 - 10,76	RACA-011-00027	RATA-031-00027		
10,77 - 11,16	RACA-011-00028	RATA-031-00024	RDRY-707-00187	
11,17 - 11,57	RACA-011-00029	RATA-031-00025		
11,58 - 11,95	RACA-011-00030	RATA-031-00026		

Basic assembly with Morse Taper shank / Corpo base con attacco C.M. RAWA-200-00000  
 Basic assembly with straight shank / Corpo base con attacco cilindrico RAWA-100-00000

From diam. 2,74 to 11,95 mm.

Da diam. 2,74 a 11,95 mm.



BOTTOMING STYLE / ESECUZIONE A BATTUTA				
Adjustment range				Rolls qty / Qtà rulli
Campo di regolazione	<b>B</b>	<b>C</b>	<b>D</b>	
Ø D	Cage Gabbia pos.1	Cone Asta pos.2	Rolls Rulli pos.3	
min. max.				
2,74 - 3,24	RBCA-015-00008	RBTA-03x-00008		3
3,25 - 3,62	RBCA-015-00009	RBTA-03x-00009		
3,63 - 4,03	RBCA-015-00010	RBTA-03x-00010		
4,04 - 4,41	RBCA-015-00011	RBTA-03x-00011	RSRY-708-00156	
4,42 - 4,81	RBCA-011-00012	RBTA-03x-00012		
4,82 - 5,22	RBCA-015-00013	RBTA-03x-00013		
5,23 - 5,60	RBCA-015-00014	RBTA-03x-00014		
5,61 - 6,01	RBCA-015-00015	RBTA-03x-00015	RSRY-708-00156	4
6,02 - 6,42	RBCA-015-00016	RBTA-03x-00016		5
6,43 - 6,80	RBCA-015-00017	RBTA-03x-00017		
6,81 - 7,20	RBCA-015-00018	RBTA-03x-00018	RSRY-708-00156	
7,21 - 7,58	RBCA-015-00019	RBTA-03x-00019		
7,59 - 7,99	RBCA-015-00020	RBTA-03x-00020		
8,00 - 8,40	RBCA-015-00021	RBTA-03x-00017		
8,41 - 8,78	RBCA-015-00022	RBTA-03x-00018	RSRY-708-00125	
8,79 - 9,18	RBCA-015-00023	RBTA-03x-00019		
9,19 - 9,59	RBCA-015-00024	RBTA-03x-00024		
9,60 - 9,97	RBCA-015-00025	RBTA-03x-00025	RSRY-705-00218	
9,98 - 10,37	RBCA-015-00026	RBTA-03x-00026		
10,38 - 10,76	RBCA-015-00027	RBTA-03x-00027		↓
10,77 - 11,16	RBCA-015-00028	RBTA-03x-00024		
11,17 - 11,57	RBCA-015-00029	RBTA-03x-00025	RSRY-705-00187	
11,58 - 11,95	RBCA-015-00030	RBTA-03x-00026		

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished. For the correct identification of "x" value see page 86.

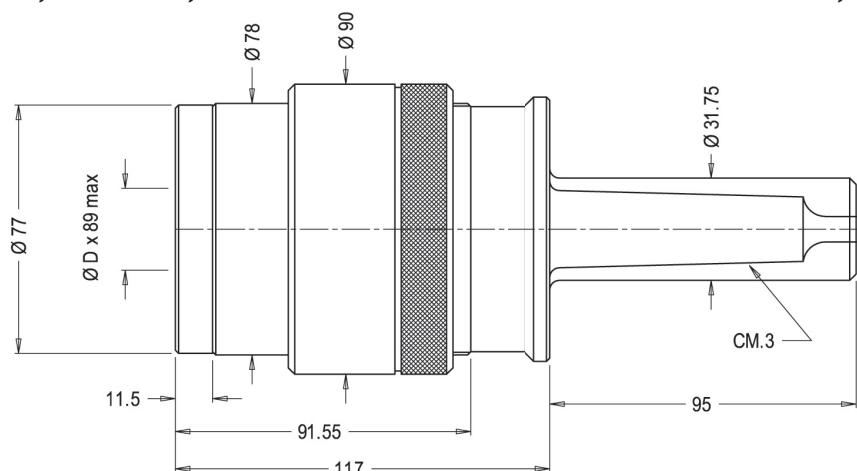
Numero che varia da 2 a 8 in funzione del diametro esatto da rullare.  
Per la corretta identificazione del valore "x" vedi pagina 87.

# ROLLER BURNISHING TOOLS SERIES B RULLATORI SERIE B

S.C.A.M.I.®

From diam. 11,96 to 38,20 mm.

Da diam. 11,96 a 38,20 mm.



NB- To order the tool with the Ø 32 cylindrical shank, add "/32" to the roller code  
N.B. Per ordinare l'utensile con l'attacco cilindrico Ø 32 aggiungere "/32" al codice del rullatore

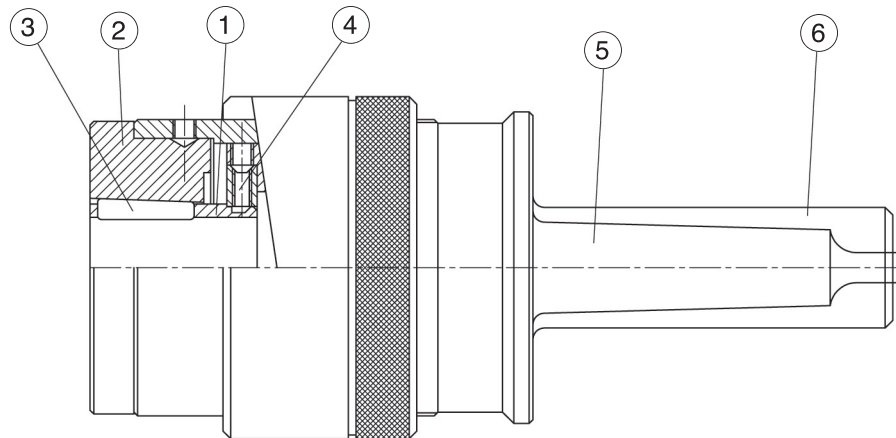
Adjustment range Campo di regolazione Ø D min. max.	Roller burnishing tool for through style with Morse Taper shank Rullatore per esecuzione passante con attacco Cono Morse	Roller burnishing tool for through style with straight shank Rullatore per esecuzione passante con attacco cilindrico	Roller burnishing tool for bottoming style with Morse Taper shank Rullatore per esecuzione a battuta con attacco Cono Morse	Roller burnishing tool for bottoming style with straight shank Rullatore per esecuzione a battuta con attacco cilindrico
11,96 - 12,80	RAKB-200-01280	RAKB-100-01280	RBKB-200-xxxxx	RBKB-100-xxxxx
12,81 - 13,58	RAKB-200-01358	RAKB-100-01358	RBKB-200-xxxxx	RBKB-100-xxxxx
13,59 - 14,37	RAKB-200-01437	RAKB-100-01437	RBKB-200-xxxxx	RBKB-100-xxxxx
14,38 - 15,16	RAKB-200-01516	RAKB-100-01516	RBKB-200-xxxxx	RBKB-100-xxxxx
15,17 - 15,97	RAKB-200-01597	RAKB-100-01597	RBKB-200-xxxxx	RBKB-100-xxxxx
15,98 - 16,76	RAKB-200-01676	RAKB-100-01676	RBKB-200-xxxxx	RBKB-100-xxxxx
16,77 - 17,54	RAKB-200-01754	RAKB-100-01754	RBKB-200-xxxxx	RBKB-100-xxxxx
17,55 - 18,33	RAKB-200-01833	RAKB-100-01833	RBKB-200-xxxxx	RBKB-100-xxxxx
18,34 - 19,15	RAKB-200-01915	RAKB-100-01915	RBKB-200-xxxxx	RBKB-100-xxxxx
19,16 - 19,93	RAKB-200-01993	RAKB-100-01993	RBKB-200-xxxxx	RBKB-100-xxxxx
19,94 - 20,72	RAKB-200-02072	RAKB-100-02072	RBKB-200-xxxxx	RBKB-100-xxxxx
20,73 - 21,51	RAKB-200-02151	RAKB-100-02151	RBKB-200-xxxxx	RBKB-100-xxxxx
21,52 - 22,32	RAKB-200-02232	RAKB-100-02232	RBKB-200-xxxxx	RBKB-100-xxxxx
22,33 - 23,11	RAKB-200-02311	RAKB-100-02311	RBKB-200-xxxxx	RBKB-100-xxxxx
23,12 - 23,89	RAKB-200-02389	RAKB-100-02389	RBKB-200-xxxxx	RBKB-100-xxxxx
23,90 - 24,68	RAKB-200-02468	RAKB-100-02468	RBKB-200-xxxxx	RBKB-100-xxxxx
24,69 - 25,50	RAKB-200-02550	RAKB-100-02550	RBKB-200-xxxxx	RBKB-100-xxxxx
25,51 - 26,28	RAKB-200-02628	RAKB-100-02628	RBKB-200-xxxxx	RBKB-100-xxxxx
26,29 - 27,07	RAKB-200-02707	RAKB-100-02707	RBKB-200-xxxxx	RBKB-100-xxxxx
27,08 - 27,86	RAKB-200-02786	RAKB-100-02786	RBKB-200-xxxxx	RBKB-100-xxxxx
27,87 - 28,67	RAKB-200-02867	RAKB-100-02867	RBKB-200-xxxxx	RBKB-100-xxxxx
28,68 - 29,46	RAKB-200-02946	RAKB-100-02946	RBKB-200-xxxxx	RBKB-100-xxxxx
29,47 - 30,24	RAKB-200-03024	RAKB-100-03024	RBKB-200-xxxxx	RBKB-100-xxxxx
30,25 - 31,03	RAKB-200-03103	RAKB-100-03103	RBKB-200-xxxxx	RBKB-100-xxxxx
31,04 - 31,85	RAKB-200-03185	RAKB-100-03185	RBKB-200-xxxxx	RBKB-100-xxxxx
31,86 - 32,63	RAKB-200-03263	RAKB-100-03263	RBKB-200-xxxxx	RBKB-100-xxxxx
32,64 - 33,42	RAKB-200-03342	RAKB-100-03342	RBKB-200-xxxxx	RBKB-100-xxxxx
33,43 - 34,21	RAKB-200-03421	RAKB-100-03421	RBKB-200-xxxxx	RBKB-100-xxxxx
34,22 - 35,02	RAKB-200-03502	RAKB-100-03502	RBKB-200-xxxxx	RBKB-100-xxxxx
35,03 - 35,81	RAKB-200-03581	RAKB-100-03581	RBKB-200-xxxxx	RBKB-100-xxxxx
35,82 - 36,59	RAKB-200-03659	RAKB-100-03659	RBKB-200-xxxxx	RBKB-100-xxxxx
36,60 - 37,38	RAKB-200-03738	RAKB-100-03738	RBKB-200-xxxxx	RBKB-100-xxxxx
37,39 - 38,20	RAKB-200-03820	RAKB-100-03820	RBKB-200-xxxxx	RBKB-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
e.g. Roller burnishing tools for bottoming style Ø 34,23 mm with M.T. shank: RBKB-200-03423

Numerazione che indica il diametro da rullare in centesimi  
es. Rullatore Ø 34,23 attacco C.M.: RBKB-200-03423

From diam. 11,96 to 38,20 mm.

Da diam. 11,96 a 38,20 mm.



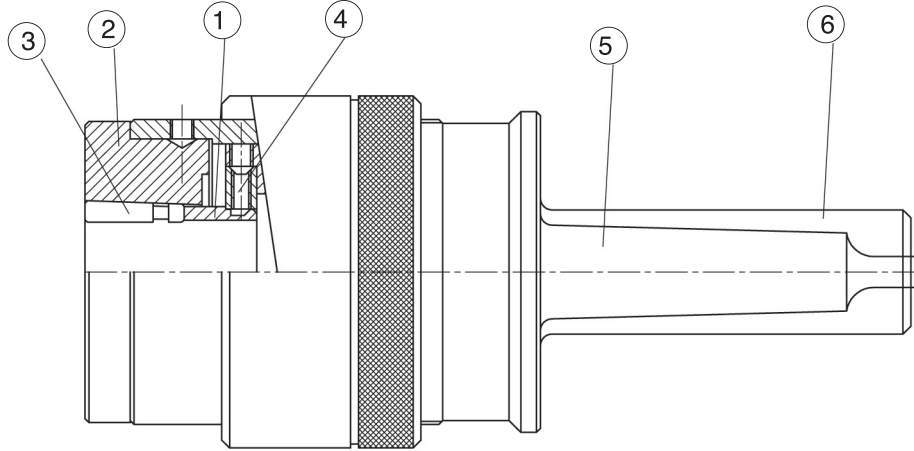
THROUGH STYLE / ESECUZIONE PASSANTE					
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos. 1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	Rolls qty / Qtà rulli
11,96 - 12,80	RACB-011-00032	RATB-031-00032	RAAB-091-00032	RDRY-704-00265	5
12,81 - 13,58	RACB-011-00034	RATB-031-00033	RAAB-091-00032	RDRY-704-00265	
13,59 - 14,37	RACB-011-00036	RATB-031-00034	RAAB-091-00032	RDRY-704-00265	
14,38 - 15,16	RACB-011-00038	RATB-031-00032	RAAB-091-00032	RDRY-707-00218	
15,17 - 15,97	RACB-011-00040	RATB-031-00033	RAAB-091-00032	RDRY-707-00218	
15,98 - 16,76	RACB-011-00042	RATB-031-00034	RAAB-091-00032	RDRY-707-00218	
16,77 - 17,54	RACB-011-00044	RATB-031-00038	RAAB-091-00044	RDRY-704-00265	
17,55 - 18,33	RACB-011-00046	RATB-031-00039	RAAB-091-00044	RDRY-704-00265	
18,34 - 19,15	RACB-011-00048	RATB-031-00040	RAAB-091-00044	RDRY-704-00265	
19,16 - 19,93	RACB-011-00050	RATB-031-00038	RAAB-091-00044	RDRY-707-00218	
19,94 - 20,72	RACB-011-00052	RATB-031-00039	RAAB-091-00044	RDRY-707-00218	
20,73 - 21,51	RACB-011-00054	RATB-031-00040	RAAB-091-00044	RDRY-707-00218	
21,52 - 22,32	RACB-011-00056	RATB-031-00056	RAAB-091-00056	RDRY-704-00265	
22,33 - 23,11	RACB-011-00058	RATB-031-00058	RAAB-091-00056	RDRY-704-00265	
23,12 - 23,89	RACB-011-00060	RATB-031-00060	RAAB-091-00056	RDRY-704-00265	
23,90 - 24,68	RACB-011-00062	RATB-031-00056	RAAB-091-00056	RDRY-707-00218	
24,69 - 25,50	RACB-011-00064	RATB-031-00058	RAAB-091-00056	RDRY-707-00218	
25,51 - 26,28	RACB-011-00066	RATB-031-00060	RAAB-091-00056	RDRY-707-00218	
26,29 - 27,07	RACB-011-00068	RATB-031-00068	RAAB-091-00068	RDRY-704-00265	
27,08 - 27,86	RACB-011-00070	RATB-031-00070	RAAB-091-00068	RDRY-704-00265	
27,87 - 28,67	RACB-011-00072	RATB-031-00072	RAAB-091-00068	RDRY-704-00265	
28,68 - 29,46	RACB-011-00074	RATB-031-00068	RAAB-091-00068	RDRY-707-00218	
29,47 - 30,24	RACB-011-00076	RATB-031-00070	RAAB-091-00068	RDRY-707-00218	
30,25 - 31,03	RACB-011-00078	RATB-031-00072	RAAB-091-00068	RDRY-707-00218	
31,04 - 31,85	RACB-011-00080	RATB-031-00080	RAAB-091-00080	RDRY-707-00312	
31,86 - 32,63	RACB-011-00082	RATB-031-00082	RAAB-091-00080	RDRY-707-00312	
32,64 - 33,42	RACB-011-00084	RATB-031-00084	RAAB-091-00080	RDRY-707-00312	
33,43 - 34,21	RACB-011-00086	RATB-031-00080	RAAB-091-00080	RDRY-704-00265	
34,22 - 35,02	RACB-011-00088	RATB-031-00082	RAAB-091-00080	RDRY-704-00265	
35,03 - 35,81	RACB-011-00090	RATB-031-00084	RAAB-091-00080	RDRY-704-00265	
35,82 - 36,59	RACB-011-00092	RATB-031-00080	RAAB-091-00080	RDRY-707-00218	
36,60 - 37,38	RACB-011-00094	RATB-031-00082	RAAB-091-00080	RDRY-707-00218	
37,39 - 38,20	RACB-011-00096	RATB-031-00084	RAAB-091-00080	RDRY-707-00218	

- Basic assembly with Morse Taper shank / Corpo base con attacco C.M. RAWB-200-00000
- Basic assembly with straight shank / Corpo base con attacco cilindrico RAWB-100-00000
- Basic assembly without shank / Corpo base senza attacco RAWB-001-00000
- Morse Taper shank / Attacco C.M. (pos. 5) RASB-042-00000
- Straight shank / Attacco cilindrico (pos. 6) RASB-041-00000



From diam. 11,96 to 38,20 mm.

Da diam. 11,96 a 38,20 mm.



**BOTTOMING STYLE / ESECUZIONE CON BATTUTA**

Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos.1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	Rolls qty / Qtà rulli
11,96 - 12,80	RBCB-015-00032	RBTB-03x-00032	RAAB-091-00032	RSRY-708-00265	5
12,81 - 13,58	RBCB-015-00034	RBTB-03x-00033	RAAB-091-00032	RSRY-708-00265	
13,59 - 14,37	RBCB-015-00036	RBTB-03x-00034	RAAB-091-00032	RSRY-708-00265	
14,38 - 15,16	RBCB-015-00038	RBTB-03x-00032	RAAB-091-00032	RSRY-708-00218	
15,17 - 15,97	RBCB-015-00040	RBTB-03x-00033	RAAB-091-00032	RSRY-708-00218	
15,98 - 16,76	RBCB-015-00042	RBTB-03x-00034	RAAB-091-00032	RSRY-708-00218	
16,77 - 17,54	RBCB-015-00044	RBTB-03x-00038	RAAB-091-00044	RSRY-708-00265	
17,55 - 18,33	RBCB-015-00046	RBTB-03x-00039	RAAB-091-00044	RSRY-708-00265	
18,34 - 19,15	RBCB-015-00048	RBTB-03x-00040	RAAB-091-00044	RSRY-708-00265	
19,16 - 19,93	RBCB-015-00050	RBTB-03x-00038	RAAB-091-00044	RSRY-708-00218	
19,94 - 20,72	RBCB-015-00052	RBTB-03x-00039	RAAB-091-00044	RSRY-708-00218	
20,73 - 21,51	RBCB-015-00054	RBTB-03x-00040	RAAB-091-00044	RSRY-708-00218	
21,52 - 22,32	RBCB-015-00056	RBTB-03x-00056	RAAB-091-00056	RSRY-708-00265	
22,33 - 23,11	RBCB-015-00058	RBTB-03x-00058	RAAB-091-00056	RSRY-708-00265	
23,12 - 23,89	RBCB-015-00060	RBTB-03x-00060	RAAB-091-00056	RSRY-708-00265	
23,90 - 24,68	RBCB-015-00062	RBTB-03x-00056	RAAB-091-00056	RSRY-708-00218	
24,69 - 25,50	RBCB-015-00064	RBTB-03x-00058	RAAB-091-00056	RSRY-708-00218	
25,51 - 26,28	RBCB-015-00066	RBTB-03x-00060	RAAB-091-00056	RSRY-708-00218	
26,29 - 27,07	RBCB-015-00068	RBTB-03x-00068	RAAB-091-00068	RSRY-708-00265	
27,08 - 27,86	RBCB-015-00070	RBTB-03x-00070	RAAB-091-00068	RSRY-708-00265	
27,87 - 28,67	RBCB-015-00072	RBTB-03x-00072	RAAB-091-00068	RSRY-708-00265	
28,68 - 29,46	RBCB-015-00074	RBTB-03x-00068	RAAB-091-00068	RSRY-708-00218	
29,47 - 30,24	RBCB-015-00076	RBTB-03x-00070	RAAB-091-00068	RSRY-708-00218	
30,25 - 31,03	RBCB-015-00078	RBTB-03x-00072	RAAB-091-00068	RSRY-708-00218	
31,04 - 31,85	RBCB-015-00080	RBTB-03x-00080	RAAB-091-00080	RSRY-705-00312	
31,86 - 32,63	RBCB-015-00082	RBTB-03x-00082	RAAB-091-00080	RSRY-705-00312	
32,64 - 33,42	RBCB-015-00084	RBTB-03x-00084	RAAB-091-00080	RSRY-705-00312	
33,43 - 34,21	RBCB-015-00086	RBTB-03x-00080	RAAB-091-00080	RSRY-708-00265	
34,22 - 35,02	RBCB-015-00088	RBTB-03x-00082	RAAB-091-00080	RSRY-708-00265	
35,03 - 35,81	RBCB-015-00090	RBTB-03x-00084	RAAB-091-00080	RSRY-708-00265	
35,82 - 36,59	RBCB-015-00092	RBTB-03x-00080	RAAB-091-00080	RSRY-708-00218	
36,60 - 37,38	RBCB-015-00094	RBTB-03x-00082	RAAB-091-00080	RSRY-708-00218	
37,39 - 38,20	RBCB-015-00096	RBTB-03x-00084	RAAB-091-00080	RSRY-708-00218	

Basic assembly with Morse Taper shank / Corpo base con attacco C.M.

Basic assembly with straight shank / Corpo base con attacco cilindrico

Basic assembly without shank / Corpo base senza attacco

Morse Taper shank / Attacco C.M. (pos. 5)

Straight shank / Attacco cilindrico (pos. 6)

RAWB-200-00000

RAWB-100-00000

RAWB-001-00000

RASB-042-00000

RASB-041-00000

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished.

For the correct identification of "x" value see page 86.

Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 87.

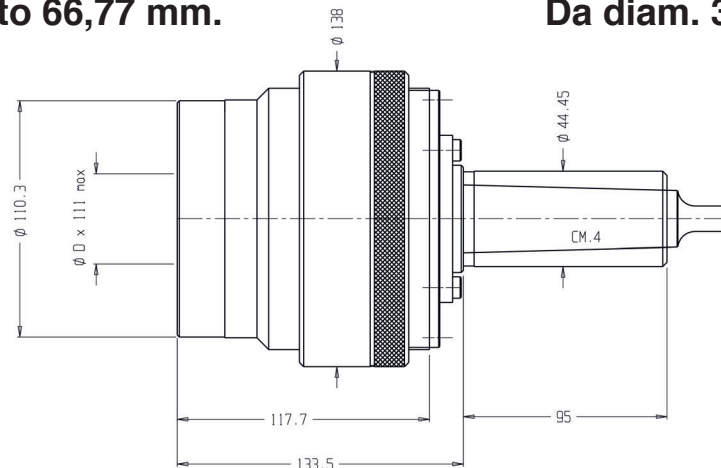
# ROLLER BURNISHING TOOLS

## SERIES C

### RULLATORI SERIE C

From diam. 38,21 to 66,77 mm.

Da diam. 38,21 a 66,77 mm.



NB- To order the tool with the  $\varnothing 40$  cylindrical shank, add "/40" to the roller code  
 N.B. Per ordinare l'utensile con l'attacco cilindrico  $\varnothing 40$  aggiungere "/40" al codice del rullatore

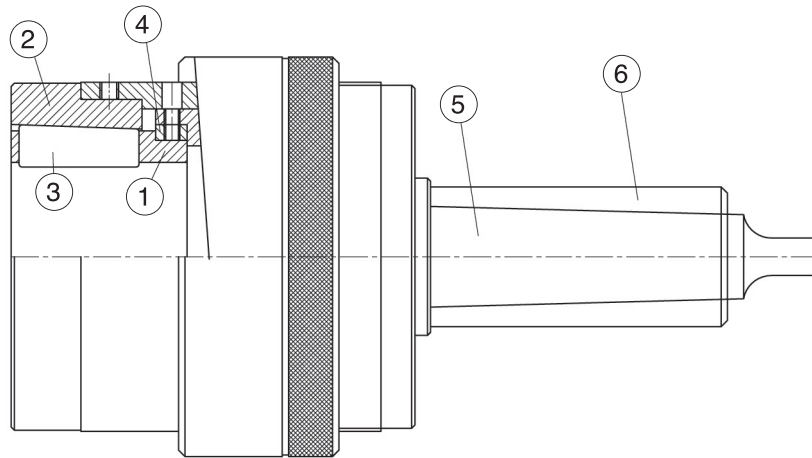
Adjustment range Campo di regolazione $\varnothing D$ min. max.	Roller burnishing tool for through style with Morse Taper shank Rullatore per esecuzione passante con attacco Cono Morse	Roller burnishing tool for through style with straight shank Rullatore per esecuzione passante con attacco cilindrico	Roller burnishing tool for bottoming style with Morse Taper shank Rullatore per esecuzione a battuta con attacco Cono Morse	Roller burnishing tool for bottoming style with straight shank Rullatore per esecuzione a battuta con attacco cilindrico
38,21 - 38,98	RAKC-200-03898	RAKC-100-03898	RBKC-200-xxxxx	RBKC-100-xxxxx
38,99 - 39,77	RAKC-200-03977	RAKC-100-03977	RBKC-200-xxxxx	RBKC-100-xxxxx
39,78 - 40,56	RAKC-200-04056	RAKC-100-04056	RBKC-200-xxxxx	RBKC-100-xxxxx
40,57 - 41,37	RAKC-200-04137	RAKC-100-04137	RBKC-200-xxxxx	RBKC-100-xxxxx
41,38 - 42,16	RAKC-200-04216	RAKC-100-04216	RBKC-200-xxxxx	RBKC-100-xxxxx
42,17 - 42,94	RAKC-200-04294	RAKC-100-04294	RBKC-200-xxxxx	RBKC-100-xxxxx
42,95 - 43,73	RAKC-200-04373	RAKC-100-04373	RBKC-200-xxxxx	RBKC-100-xxxxx
43,74 - 44,55	RAKC-200-04455	RAKC-100-04455	RBKC-200-xxxxx	RBKC-100-xxxxx
44,56 - 45,33	RAKC-200-04533	RAKC-100-04533	RBKC-200-xxxxx	RBKC-100-xxxxx
45,34 - 46,12	RAKC-200-04612	RAKC-100-04612	RBKC-200-xxxxx	RBKC-100-xxxxx
46,13 - 46,91	RAKC-200-04691	RAKC-100-04691	RBKC-200-xxxxx	RBKC-100-xxxxx
46,92 - 47,72	RAKC-200-04772	RAKC-100-04772	RBKC-200-xxxxx	RBKC-100-xxxxx
47,73 - 48,51	RAKC-200-04851	RAKC-100-04851	RBKC-200-xxxxx	RBKC-100-xxxxx
48,52 - 49,29	RAKC-200-04929	RAKC-100-04929	RBKC-200-xxxxx	RBKC-100-xxxxx
49,30 - 50,08	RAKC-200-05008	RAKC-100-05008	RBKC-200-xxxxx	RBKC-100-xxxxx
50,09 - 50,90	RAKC-200-05090	RAKC-100-05090	RBKC-200-xxxxx	RBKC-100-xxxxx
50,91 - 51,68	RAKC-200-05168	RAKC-100-05168	RBKC-200-xxxxx	RBKC-100-xxxxx
51,69 - 52,47	RAKC-200-05247	RAKC-100-05247	RBKC-200-xxxxx	RBKC-100-xxxxx
52,48 - 53,26	RAKC-200-05326	RAKC-100-05326	RBKC-200-xxxxx	RBKC-100-xxxxx
53,27 - 54,07	RAKC-200-05407	RAKC-100-05407	RBKC-200-xxxxx	RBKC-100-xxxxx
54,08 - 54,86	RAKC-200-05486	RAKC-100-05486	RBKC-200-xxxxx	RBKC-100-xxxxx
54,87 - 55,64	RAKC-200-05564	RAKC-100-05564	RBKC-200-xxxxx	RBKC-100-xxxxx
55,65 - 56,43	RAKC-200-05643	RAKC-100-05643	RBKC-200-xxxxx	RBKC-100-xxxxx
56,44 - 57,25	RAKC-200-05725	RAKC-100-05725	RBKC-200-xxxxx	RBKC-100-xxxxx
57,26 - 58,03	RAKC-200-05803	RAKC-100-05803	RBKC-200-xxxxx	RBKC-100-xxxxx
58,04 - 58,82	RAKC-200-05882	RAKC-100-05882	RBKC-200-xxxxx	RBKC-100-xxxxx
58,83 - 59,61	RAKC-200-05961	RAKC-100-05961	RBKC-200-xxxxx	RBKC-100-xxxxx
59,62 - 60,42	RAKC-200-06042	RAKC-100-06042	RBKC-200-xxxxx	RBKC-100-xxxxx
60,43 - 61,21	RAKC-200-06121	RAKC-100-06121	RBKC-200-xxxxx	RBKC-100-xxxxx
61,22 - 61,99	RAKC-200-06199	RAKC-100-06199	RBKC-200-xxxxx	RBKC-100-xxxxx
62,00 - 62,78	RAKC-200-06278	RAKC-100-06278	RBKC-200-xxxxx	RBKC-100-xxxxx
62,79 - 63,60	RAKC-200-06360	RAKC-100-06360	RBKC-200-xxxxx	RBKC-100-xxxxx
63,61 - 64,38	RAKC-200-06438	RAKC-100-06438	RBKC-200-xxxxx	RBKC-100-xxxxx
64,39 - 65,17	RAKC-200-06517	RAKC-100-06517	RBKC-200-xxxxx	RBKC-100-xxxxx
65,18 - 65,96	RAKC-200-06596	RAKC-100-06596	RBKC-200-xxxxx	RBKC-100-xxxxx
65,97 - 66,77	RAKC-200-06677	RAKC-100-06677	RBKC-200-xxxxx	RBKC-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.  
 e.g. Roller burnishing tools for bottoming style  $\varnothing 60,30$  mm with M.T. shank: RBKC-200-06030

Numerazione che indica il diametro da rullare in centesimi  
 es. Rullatore  $\varnothing 60,30$  attacco C.M.: RBKC-200-06030

From diam. 38,21 to 66,77 mm.

Da diam. 38,21 a 66,77 mm.

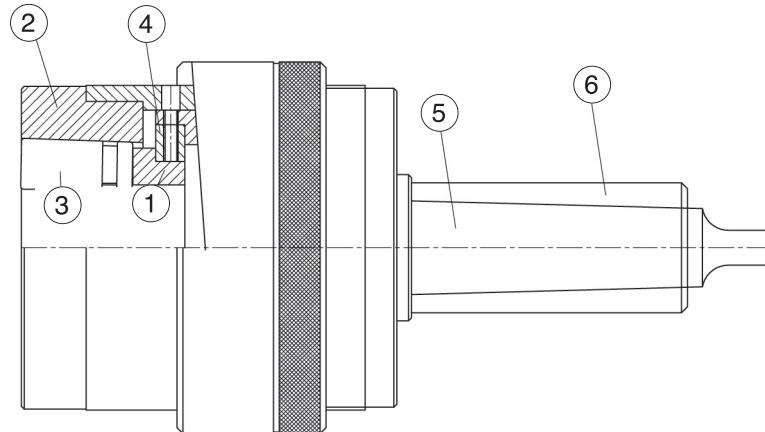


THROUGH STYLE / ESECUZIONE PASSANTE					Rolls qty / Qtà rulli
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos.1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	
38,21 - 38,98	RACC-011-00098	RATC-031-00098	RAAC-091-00098	RDRY-704-00531	7
38,99 - 39,77	RACC-011-00100	RATC-031-00100	RAAC-091-00098	RDRY-704-00531	
39,78 - 40,56	RACC-011-00102	RATC-031-00102	RAAC-091-00098	RDRY-704-00531	
40,57 - 41,37	RACC-011-00104	RATC-031-00104	RAAC-091-00098	RDRY-704-00531	
41,38 - 42,16	RACC-011-00106	RATC-031-00106	RAAC-091-00098	RDRY-704-00531	
42,17 - 42,94	RACC-011-00108	RATC-031-00108	RAAC-091-00098	RDRY-704-00531	
42,95 - 43,73	RACC-011-00110	RATC-031-00102	RAAC-091-00098	RDRY-704-00468	
43,74 - 44,55	RACC-011-00112	RATC-031-00104	RAAC-091-00098	RDRY-704-00468	9
44,56 - 45,33	RACC-011-00114	RATC-031-00106	RAAC-091-00098	RDRY-704-00468	
45,34 - 46,12	RACC-011-00116	RATC-031-00108	RAAC-091-00098	RDRY-704-00468	
46,13 - 46,91	RACC-011-00118	RATC-031-00102	RAAC-091-00098	RDRY-704-00406	
46,92 - 47,72	RACC-011-00120	RATC-031-00104	RAAC-091-00098	RDRY-704-00406	
47,73 - 48,51	RACC-011-00122	RATC-031-00106	RAAC-091-00098	RDRY-704-00406	
48,52 - 49,29	RACC-011-00124	RATC-031-00108	RAAC-091-00098	RDRY-704-00406	
49,30 - 50,08	RACC-011-00126	RATC-031-00098	RAAC-091-00098	RDRY-704-00312	
50,09 - 50,90	RACC-011-00128	RATC-031-00100	RAAC-091-00098	RDRY-704-00312	
50,91 - 51,68	RACC-011-00130	RATC-031-00102	RAAC-091-00098	RDRY-704-00312	
51,69 - 52,47	RACC-011-00132	RATC-031-00104	RAAC-091-00098	RDRY-704-00312	
52,48 - 53,26	RACC-011-00134	RATC-031-00134	RAAC-091-00134	RDRY-704-00531	
53,27 - 54,07	RACC-011-00136	RATC-031-00136	RAAC-091-00134	RDRY-704-00531	
54,08 - 54,86	RACC-011-00138	RATC-031-00138	RAAC-091-00134	RDRY-704-00531	
54,87 - 55,64	RACC-011-00140	RATC-031-00140	RAAC-091-00134	RDRY-704-00531	
55,65 - 56,43	RACC-011-00142	RATC-031-00142	RAAC-091-00134	RDRY-704-00531	
56,44 - 57,25	RACC-011-00144	RATC-031-00144	RAAC-091-00134	RDRY-704-00531	
57,26 - 58,03	RACC-011-00146	RATC-031-00138	RAAC-091-00134	RDRY-704-00468	
58,04 - 58,82	RACC-011-00148	RATC-031-00140	RAAC-091-00134	RDRY-704-00468	
58,83 - 59,61	RACC-011-00150	RATC-031-00142	RAAC-091-00134	RDRY-704-00468	
59,62 - 60,42	RACC-011-00152	RATC-031-00144	RAAC-091-00134	RDRY-704-00468	
60,43 - 61,21	RACC-011-00154	RATC-031-00138	RAAC-091-00134	RDRY-704-00406	
61,22 - 61,99	RACC-011-00156	RATC-031-00140	RAAC-091-00134	RDRY-704-00406	
62,00 - 62,78	RACC-011-00158	RATC-031-00142	RAAC-091-00134	RDRY-704-00406	
62,79 - 63,60	RACC-011-00160	RATC-031-00144	RAAC-091-00134	RDRY-704-00406	
63,61 - 64,38	RACC-011-00162	RATC-031-00134	RAAC-091-00134	RDRY-704-00312	
64,39 - 65,17	RACC-011-00164	RATC-031-00136	RAAC-091-00134	RDRY-704-00312	
65,18 - 65,96	RACC-011-00166	RATC-031-00138	RAAC-091-00134	RDRY-704-00312	
65,97 - 66,77	RACC-011-00168	RATC-031-00140	RAAC-091-00134	RDRY-704-00312	

Basic assembly with Morse Taper shank / Corpo base con attacco C.M. RAWC-200-N0000  
 Basic assembly with straight shank / Corpo base con attacco cilindrico RAWC-100-N0000  
 Basic assembly without shank / Corpo base senza attacco RAWC-001-N0000  
 Morse Taper shank / Attacco C.M. (pos. 5) RASC-042-00001  
 Straight shank / Attacco cilindrico (pos. 6) RASC-041-00001

From diam. 38,21 to 66,77 mm.

Da diam. 38,21 a 66,77 mm.



BOTTOMING STYLE / ESECUZIONE CON BATTUTA					Rolls qty / Qtà rulli
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos. 1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	
38,21 - 38,98	RBCC-015-00098	RBTC-03x-00098	RAAC-091-00098	RSRY-708-00531	5
38,99 - 39,77	RBCC-015-00100	RBTC-03x-00100	RAAC-091-00098	RSRY-708-00531	
39,78 - 40,56	RBCC-015-00102	RBTC-03x-00102	RAAC-091-00098	RSRY-708-00531	
40,57 - 41,37	RBCC-015-00104	RBTC-03x-00104	RAAC-091-00098	RSRY-708-00531	
41,38 - 42,16	RBCC-015-00106	RBTC-03x-00106	RAAC-091-00098	RSRY-708-00531	
42,17 - 42,94	RBCC-015-00108	RBTC-03x-00108	RAAC-091-00098	RSRY-708-00531	
42,95 - 43,73	RBCC-015-00110	RBTC-03x-00102	RAAC-091-00098	RSRY-708-00468	
43,74 - 44,55	RBCC-015-00112	RBTC-03x-00104	RAAC-091-00098	RSRY-708-00468	7
44,56 - 45,33	RBCC-015-00114	RBTC-03x-00106	RAAC-091-00098	RSRY-708-00468	
45,34 - 46,12	RBCC-015-00116	RBTC-03x-00108	RAAC-091-00098	RSRY-708-00468	
46,13 - 46,91	RBCC-015-00118	RBTC-03x-00102	RAAC-091-00098	RSRY-708-00406	
46,92 - 47,72	RBCC-015-00120	RBTC-03x-00104	RAAC-091-00098	RSRY-708-00406	
47,73 - 48,51	RBCC-015-00122	RBTC-03x-00106	RAAC-091-00098	RSRY-708-00406	
48,52 - 49,29	RBCC-015-00124	RBTC-03x-00108	RAAC-091-00098	RSRY-708-00406	
49,30 - 50,08	RBCC-015-00126	RBTC-03x-00098	RAAC-091-00098	RSRY-708-00312	
50,09 - 50,90	RBCC-015-00128	RBTC-03x-00100	RAAC-091-00098	RSRY-708-00312	
50,91 - 51,68	RBCC-015-00130	RBTC-03x-00102	RAAC-091-00098	RSRY-708-00312	
51,69 - 52,47	RBCC-015-00132	RBTC-03x-00104	RAAC-091-00098	RSRY-708-00312	
52,48 - 53,26	RBCC-015-00134	RBTC-03x-00134	RAAC-091-00134	RSRY-708-00531	
53,27 - 54,07	RBCC-015-00136	RBTC-03x-00136	RAAC-091-00134	RSRY-708-00531	
54,08 - 54,86	RBCC-015-00138	RBTC-03x-00138	RAAC-091-00134	RSRY-708-00531	
54,87 - 55,64	RBCC-015-00140	RBTC-03x-00140	RAAC-091-00134	RSRY-708-00531	
55,65 - 56,43	RBCC-015-00142	RBTC-03x-00142	RAAC-091-00134	RSRY-708-00531	
56,44 - 57,25	RBCC-015-00144	RBTC-03x-00144	RAAC-091-00134	RSRY-708-00531	
57,26 - 58,03	RBCC-015-00146	RBTC-03x-00138	RAAC-091-00134	RSRY-708-00468	
58,04 - 58,82	RBCC-015-00148	RBTC-03x-00140	RAAC-091-00134	RSRY-708-00468	
58,83 - 59,61	RBCC-015-00150	RBTC-03x-00142	RAAC-091-00134	RSRY-708-00468	
59,62 - 60,42	RBCC-015-00152	RBTC-03x-00144	RAAC-091-00134	RSRY-708-00468	
60,43 - 61,21	RBCC-015-00154	RBTC-03x-00138	RAAC-091-00134	RSRY-708-00406	
61,22 - 61,99	RBCC-015-00156	RBTC-03x-00140	RAAC-091-00134	RSRY-708-00406	
62,00 - 62,78	RBCC-015-00158	RBTC-03x-00142	RAAC-091-00134	RSRY-708-00406	
62,79 - 63,60	RBCC-015-00160	RBTC-03x-00144	RAAC-091-00134	RSRY-708-00406	
63,61 - 64,38	RBCC-015-00162	RBTC-03x-00134	RAAC-091-00134	RSRY-708-00312	
64,39 - 65,17	RBCC-015-00164	RBTC-03x-00136	RAAC-091-00134	RSRY-708-00312	
65,18 - 65,96	RBCC-015-00166	RBTC-03x-00138	RAAC-091-00134	RSRY-708-00312	
65,97 - 66,77	RBCC-015-00168	RBTC-03x-00140	RAAC-091-00134	RSRY-708-00312	

Basic assembly with Morse Taper shank / Corpo base con attacco C.M.

Basic assembly with straight shank / Corpo base con attacco cilindrico

Basic assembly without shank / Corpo base senza attacco

Morse Taper shank / Attacco C.M. (pos. 5)

Straight shank / Attacco cilindrico (pos. 6)

RAWC-200-N0000

RAWC-100-N0000

RAWC-001-N0000

RASC-042-00001

RASC-041-00001

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished.

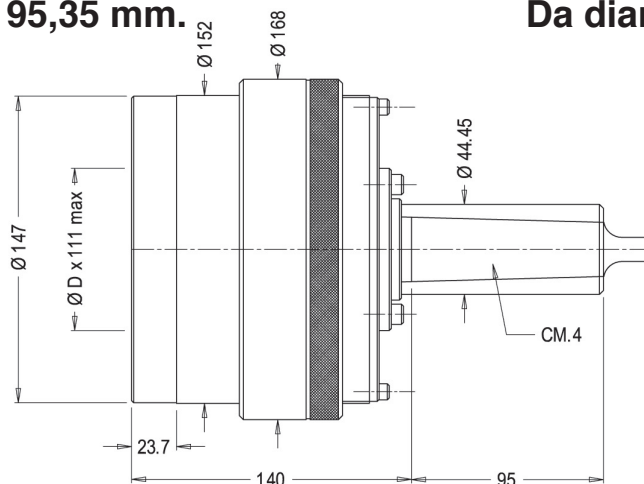
For the correct identification of "x" value see page 86.

Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 87.



From diam. 66,78 to 95,35 mm.

Da diam. 66,78 a 95,35 mm.



NB- To order the tool with the  $\varnothing 40$  cylindrical shank, add "/40" to the roller code

N.B. Per ordinare l'utensile con l'attacco cilindrico  $\varnothing 40$  aggiungere "/40" al codice del rullatore

Adjustment range Campo di regolazione $\varnothing D$ min. max.	Roller burnishing tool for through style with Morse Taper shank Rullatore per esecuzione passante con attacco Cono Morse	Roller burnishing tool for through style with straight shank Rullatore per esecuzione passante con attacco cilindrico	Roller burnishing tool for bottoming style with Morse Taper shank Rullatore per esecuzione a battuta con attacco Cono Morse	Roller burnishing tool for bottoming style with straight shank Rullatore per esecuzione a battuta con attacco cilindrico
66,78 - 67,56	RAKD-200-06756	RAKD-100-06756	RBKD-200-xxxxx	RBKD-100-xxxxx
67,57 - 68,34	RAKD-200-06834	RAKD-100-06834	RBKD-200-xxxxx	RBKD-100-xxxxx
68,35 - 69,13	RAKD-200-06913	RAKD-100-06913	RBKD-200-xxxxx	RBKD-100-xxxxx
69,14 - 69,95	RAKD-200-06995	RAKD-100-06995	RBKD-200-xxxxx	RBKD-100-xxxxx
69,96 - 70,73	RAKD-200-07073	RAKD-100-07073	RBKD-200-xxxxx	RBKD-100-xxxxx
70,74 - 71,52	RAKD-200-07152	RAKD-100-07152	RBKD-200-xxxxx	RBKD-100-xxxxx
71,53 - 72,31	RAKD-200-07231	RAKD-100-07231	RBKD-200-xxxxx	RBKD-100-xxxxx
72,32 - 73,12	RAKD-200-07312	RAKD-100-07312	RBKD-200-xxxxx	RBKD-100-xxxxx
73,13 - 73,91	RAKD-200-07391	RAKD-100-07391	RBKD-200-xxxxx	RBKD-100-xxxxx
73,92 - 74,69	RAKD-200-07469	RAKD-100-07469	RBKD-200-xxxxx	RBKD-100-xxxxx
74,70 - 75,48	RAKD-200-07548	RAKD-100-07548	RBKD-200-xxxxx	RBKD-100-xxxxx
75,49 - 76,30	RAKD-200-07630	RAKD-100-07630	RBKD-200-xxxxx	RBKD-100-xxxxx
76,31 - 77,08	RAKD-200-07708	RAKD-100-07708	RBKD-200-xxxxx	RBKD-100-xxxxx
77,09 - 77,87	RAKD-200-07787	RAKD-100-07787	RBKD-200-xxxxx	RBKD-100-xxxxx
77,88 - 78,66	RAKD-200-07866	RAKD-100-07866	RBKD-200-xxxxx	RBKD-100-xxxxx
78,67 - 79,47	RAKD-200-07947	RAKD-100-07947	RBKD-200-xxxxx	RBKD-100-xxxxx
79,48 - 80,26	RAKD-200-08026	RAKD-100-08026	RBKD-200-xxxxx	RBKD-100-xxxxx
80,27 - 81,04	RAKD-200-08104	RAKD-100-08104	RBKD-200-xxxxx	RBKD-100-xxxxx
81,05 - 81,83	RAKD-200-08183	RAKD-100-08183	RBKD-200-xxxxx	RBKD-100-xxxxx
81,84 - 82,65	RAKD-200-08265	RAKD-100-08265	RBKD-200-xxxxx	RBKD-100-xxxxx
82,66 - 83,43	RAKD-200-08343	RAKD-100-08343	RBKD-200-xxxxx	RBKD-100-xxxxx
83,44 - 84,22	RAKD-200-08422	RAKD-100-08422	RBKD-200-xxxxx	RBKD-100-xxxxx
84,23 - 85,01	RAKD-200-08501	RAKD-100-08501	RBKD-200-xxxxx	RBKD-100-xxxxx
85,02 - 85,82	RAKD-200-08582	RAKD-100-08582	RBKD-200-xxxxx	RBKD-100-xxxxx
85,83 - 86,61	RAKD-200-08661	RAKD-100-08661	RBKD-200-xxxxx	RBKD-100-xxxxx
86,62 - 87,39	RAKD-200-08739	RAKD-100-08739	RBKD-200-xxxxx	RBKD-100-xxxxx
87,40 - 88,18	RAKD-200-08818	RAKD-100-08818	RBKD-200-xxxxx	RBKD-100-xxxxx
88,19 - 89,00	RAKD-200-08900	RAKD-100-08900	RBKD-200-xxxxx	RBKD-100-xxxxx
89,01 - 89,78	RAKD-200-08978	RAKD-100-08978	RBKD-200-xxxxx	RBKD-100-xxxxx
89,79 - 90,57	RAKD-200-09057	RAKD-100-09057	RBKD-200-xxxxx	RBKD-100-xxxxx
90,58 - 91,36	RAKD-200-09136	RAKD-100-09136	RBKD-200-xxxxx	RBKD-100-xxxxx
91,37 - 92,17	RAKD-200-09217	RAKD-100-09217	RBKD-200-xxxxx	RBKD-100-xxxxx
92,18 - 92,96	RAKD-200-09296	RAKD-100-09296	RBKD-200-xxxxx	RBKD-100-xxxxx
92,97 - 93,74	RAKD-200-09374	RAKD-100-09374	RBKD-200-xxxxx	RBKD-100-xxxxx
93,75 - 94,53	RAKD-200-09453	RAKD-100-09453	RBKD-200-xxxxx	RBKD-100-xxxxx
94,54 - 95,35	RAKD-200-09535	RAKD-100-09535	RBKD-200-xxxxx	RBKD-100-xxxxx

xxxxx = Indicate to 2 metric decimal places the size to be burnished.

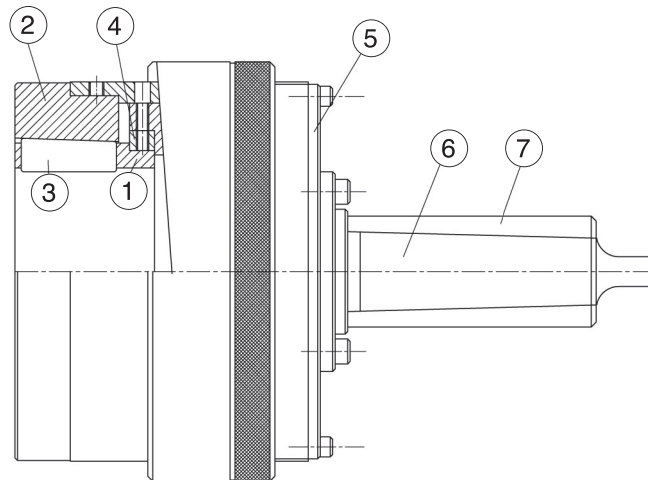
e.g. Roller burnishing tools for bottoming style  $\varnothing 90,10$  mm with M.T. shank: RBKD-200-09010

Numerazione che indica il diametro da rullare in centesimi

es. Rullatore  $\varnothing 90,10$  attacco C.M. : RBKD-200-09010

From diam. 66,78 to 95,35 mm.

Da diam. 66,78 a 95,35 mm.



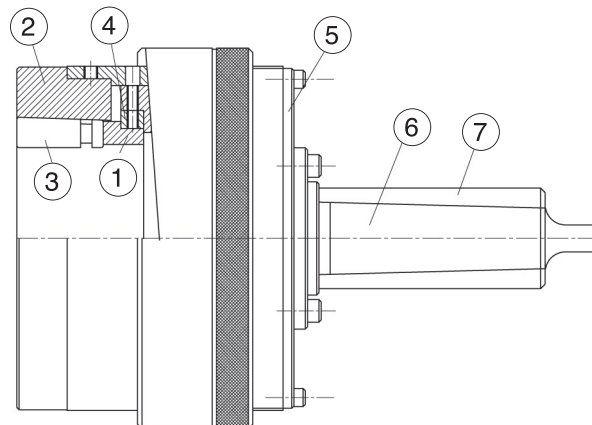
THROUGH STYLE / ESECUZIONE PASSANTE					Rolls qty / Qtà rulli
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos. 1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	
66,78 - 67,56	RACD-011-00170	RATD-031-00170	RAAD-091-00170	RDRY-704-00531	11
67,57 - 68,34	RACD-011-00172	RATD-031-00172	RAAD-091-00170	RDRY-704-00531	
68,35 - 69,13	RACD-011-00174	RATD-031-00174	RAAD-091-00170	RDRY-704-00531	
69,14 - 69,95	RACD-011-00176	RATD-031-00176	RAAD-091-00170	RDRY-704-00531	
69,96 - 70,73	RACD-011-00178	RATD-031-00178	RAAD-091-00170	RDRY-704-00531	
70,74 - 71,52	RACD-011-00180	RATD-031-00180	RAAD-091-00170	RDRY-704-00531	
71,53 - 72,31	RACD-011-00182	RATD-031-00174	RAAD-091-00170	RDRY-704-00468	
72,32 - 73,12	RACD-011-00184	RATD-031-00176	RAAD-091-00170	RDRY-704-00468	
73,13 - 73,91	RACD-011-00186	RATD-031-00178	RAAD-091-00170	RDRY-704-00468	
73,92 - 74,69	RACD-011-00188	RATD-031-00180	RAAD-091-00170	RDRY-704-00468	
74,70 - 75,48	RACD-011-00190	RATD-031-00174	RAAD-091-00170	RDRY-704-00406	
75,49 - 76,30	RACD-011-00192	RATD-031-00176	RAAD-091-00170	RDRY-704-00406	
76,31 - 77,08	RACD-011-00194	RATD-031-00178	RAAD-091-00170	RDRY-704-00406	
77,09 - 77,87	RACD-011-00196	RATD-031-00180	RAAD-091-00170	RDRY-704-00406	
77,88 - 78,66	RACD-011-00198	RATD-031-00170	RAAD-091-00170	RDRY-704-00312	
78,67 - 79,47	RACD-011-00200	RATD-031-00172	RAAD-091-00170	RDRY-704-00312	
79,48 - 80,26	RACD-011-00202	RATD-031-00174	RAAD-091-00170	RDRY-704-00312	
80,27 - 81,04	RACD-011-00204	RATD-031-00176	RAAD-091-00170	RDRY-704-00312	
81,05 - 81,83	RACD-011-00206	RATD-031-00206	RAAD-091-00206	RDRY-704-00468	
81,84 - 82,65	RACD-011-00208	RATD-031-00208	RAAD-091-00206	RDRY-704-00468	
82,66 - 83,43	RACD-011-00210	RATD-031-00210	RAAD-091-00206	RDRY-704-00468	
83,44 - 84,22	RACD-011-00212	RATD-031-00212	RAAD-091-00206	RDRY-704-00468	
84,23 - 85,01	RACD-011-00214	RATD-031-00206	RAAD-091-00206	RDRY-704-00406	
85,02 - 85,82	RACD-011-00216	RATD-031-00208	RAAD-091-00206	RDRY-704-00406	
85,83 - 86,61	RACD-011-00218	RATD-031-00210	RAAD-091-00206	RDRY-704-00406	
86,62 - 87,39	RACD-011-00220	RATD-031-00212	RAAD-091-00206	RDRY-704-00406	
87,40 - 88,18	RACD-011-00222	RATD-031-00222	RAAD-091-00206	RDRY-704-00406	
88,19 - 89,00	RACD-011-00224	RATD-031-00224	RAAD-091-00206	RDRY-704-00406	
89,01 - 89,78	RACD-011-00226	RATD-031-00206	RAAD-091-00206	RDRY-704-00312	
89,79 - 90,57	RACD-011-00228	RATD-031-00208	RAAD-091-00206	RDRY-704-00312	
90,58 - 91,36	RACD-011-00230	RATD-031-00210	RAAD-091-00206	RDRY-704-00312	
91,37 - 92,17	RACD-011-00232	RATD-031-00212	RAAD-091-00206	RDRY-704-00312	
92,18 - 92,96	RACD-011-00234	RATD-031-00222	RAAD-091-00206	RDRY-704-00312	
92,97 - 93,74	RACD-011-00236	RATD-031-00224	RAAD-091-00206	RDRY-704-00312	
93,75 - 94,53	RACD-011-00238	RATD-031-00238		RDRY-704-00468	
94,54 - 95,35	RACD-011-00240	RATD-031-00240		RDRY-704-00468	

Basic assembly with Morse Taper shank / Corpo base con attacco C.M.  
 Basic assembly with straigh shank / Corpo base con attacco cilindrico  
 Basic assembly without shank and flange/ Corpo base senza attacco e flangia  
 Flange / Flangia (pos. 5)  
 Morse Taper shank / Attacco C.M. (pos. 6)  
 Straight shank / Attacco cilindrico (pos. 7)

RAWD-200-00000  
 RAWD-100-00000  
 RAWD-001-00000  
 RASD-000-00000  
 RASD-042-00000  
 RASD-041-00000

From diam. 66,78 to 95,35 mm.

Da diam. 66,78 a 95,35 mm.



BOTTOMING STYLE / ESECUZIONE CON BATTUTA					Rolls qty / Qtà rulli
Adjustment range Campo di regolazione Ø D min. max.	<b>B</b> Cage Gabbia pos. 1	<b>C</b> Cone Asta pos. 2	<b>E</b> Ring Anello pos. 4	<b>D</b> Rolls Rulli pos. 3	
66,78 - 67,56	RBCD-015-00170	RBTD-03x-00170	RAAD-091-00170	RSRY-708-00531	9
67,57 - 68,34	RBCD-015-00172	RBTD-03x-00172	RAAD-091-00170	RSRY-708-00531	
68,35 - 69,13	RBCD-015-00174	RBTD-03x-00174	RAAD-091-00170	RSRY-708-00531	
69,14 - 69,95	RBCD-015-00176	RBTD-03x-00176	RAAD-091-00170	RSRY-708-00531	
69,96 - 70,73	RBCD-015-00178	RBTD-03x-00178	RAAD-091-00170	RSRY-708-00531	
70,74 - 71,52	RBCD-015-00180	RBTD-03x-00180	RAAD-091-00170	RSRY-708-00531	
71,53 - 72,31	RBCD-015-00182	RBTD-03x-00174	RAAD-091-00170	RSRY-708-00468	
72,32 - 73,12	RBCD-015-00184	RBTD-03x-00176	RAAD-091-00170	RSRY-708-00468	
73,13 - 73,91	RBCD-015-00186	RBTD-03x-00178	RAAD-091-00170	RSRY-708-00468	
73,92 - 74,69	RBCD-015-00188	RBTD-03x-00180	RAAD-091-00170	RSRY-708-00468	
74,70 - 75,48	RBCD-015-00190	RBTD-03x-00174	RAAD-091-00170	RSRY-708-00406	
75,49 - 76,30	RBCD-015-00192	RBTD-03x-00176	RAAD-091-00170	RSRY-708-00406	
76,31 - 77,08	RBCD-015-00194	RBTD-03x-00178	RAAD-091-00170	RSRY-708-00406	
77,09 - 77,87	RBCD-015-00196	RBTD-03x-00180	RAAD-091-00170	RSRY-708-00406	
77,88 - 78,66	RBCD-015-00198	RBTD-03x-00170	RAAD-091-00170	RSRY-708-00312	
78,67 - 79,47	RBCD-015-00200	RBTD-03x-00172	RAAD-091-00170	RSRY-708-00312	
79,48 - 80,26	RBCD-015-00202	RBTD-03x-00174	RAAD-091-00170	RSRY-708-00312	
80,27 - 81,04	RBCD-015-00204	RBTD-03x-00176	RAAD-091-00170	RSRY-708-00312	
81,05 - 81,83	RBCD-015-00206	RBTD-03x-00206	RAAD-091-00206	RSRY-708-00468	
81,84 - 82,65	RBCD-015-00208	RBTD-03x-00208	RAAD-091-00206	RSRY-708-00468	
82,66 - 83,43	RBCD-015-00210	RBTD-03x-00210	RAAD-091-00206	RSRY-708-00468	
83,44 - 84,22	RBCD-015-00212	RBTD-03x-00212	RAAD-091-00206	RSRY-708-00468	
84,23 - 85,01	RBCD-015-00214	RBTD-03x-00206	RAAD-091-00206	RSRY-708-00406	
85,02 - 85,82	RBCD-015-00216	RBTD-03x-00208	RAAD-091-00206	RSRY-708-00406	
85,83 - 86,61	RBCD-015-00218	RBTD-03x-00210	RAAD-091-00206	RSRY-708-00406	
86,62 - 87,39	RBCD-015-00220	RBTD-03x-00212	RAAD-091-00206	RSRY-708-00406	
87,40 - 88,18	RBCD-015-00222	RBTD-03x-00222	RAAD-091-00206	RSRY-708-00406	
88,19 - 89,00	RBCD-015-00224	RBTD-03x-00224	RAAD-091-00206	RSRY-708-00406	
89,01 - 89,78	RBCD-015-00226	RBTD-03x-00206	RAAD-091-00206	RSRY-708-00312	
89,79 - 90,57	RBCD-015-00228	RBTD-03x-00208	RAAD-091-00206	RSRY-708-00312	
90,58 - 91,36	RBCD-015-00230	RBTD-03x-00210	RAAD-091-00206	RSRY-708-00312	
91,37 - 92,17	RBCD-015-00232	RBTD-03x-00212	RAAD-091-00206	RSRY-708-00312	
92,18 - 92,96	RBCD-015-00234	RBTD-03x-00222	RAAD-091-00206	RSRY-708-00312	
92,97 - 93,74	RBCD-015-00236	RBTD-03x-00224	RAAD-091-00206	RSRY-708-00312	
93,75 - 94,53	RBCD-015-00238	RBTD-03x-00238		RSRY-708-00468	
94,54 - 95,35	RBCD-015-00240	RBTD-03x-00240		RSRY-708-00468	

Basic assembly with Morse Taper shank / Corpo base con attacco C.M.  
 Basic assembly with straight shank / Corpo base con attacco cilindrico  
 Basic assembly without shank and flange / Corpo base senza attacco e flangia  
 Flange / Flangia (pos. 5)  
 Morse Taper shank / Attacco C.M. (pos. 6)  
 Straight shank / Attacco cilindrico (pos. 7)

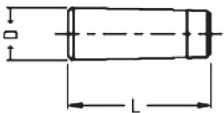
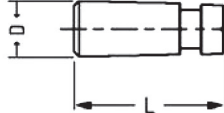
RAWD-200-00000  
 RAWD-100-00000  
 RAWD-001-00000  
 RASD-000-00000  
 RASD-042-00000  
 RASD-041-00000

x = A number in the range from 2 to 8 depending upon the exact diameter to be burnished.

For the correct identification of "x" value see page 86.

Numero che varia da 2 a 8 in funzione del diametro esatto da rullare. Per la corretta identificazione del valore "x" vedi pagina 87.

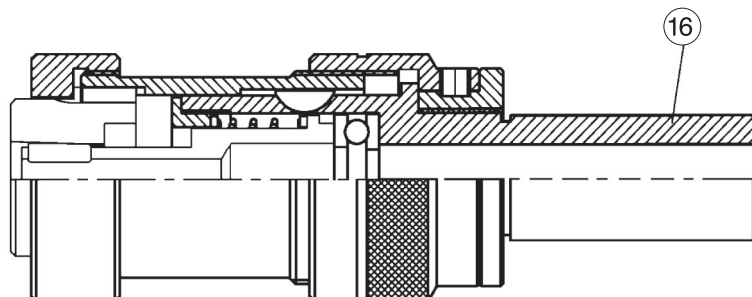


Rolls 704 and 707 Rulli 704 e 707			Rolls 708 and 705 Rulli 708 e 705		
					
Code/Codice	D	L	Code/Codice	D	L
RDRY-704-00062	1,57	6,35			
RDRY-704-00070	1,77	7,94			
RDRY-704-00078	1,97	9,53			
RDRY-704-00086	2,17	9,53	RSRY-708-00086	2,17	9,53
RDRY-704-00093	2,36	9,53			
RDRY-704-00109	2,75	12,70			
RDRY-704-00125	3,16	12,70	RSRY-708-00125	3,16	12,70
RDRY-704-00148	3,74	12,70			
RDRY-704-00156	3,95	12,70	RSRY-708-00156	3,95	12,70
RDRY-704-00172	4,34	15,88	RSRY-708-00172	4,35	15,88
RDRY-704-00187	4,72	22,28	RSRY-708-00187	4,72	22,28
RDRY-707-00187	4,72	12,70	RSRY-708-00187	4,74	12,70
RDRY-704-00218	5,52	12,70	RSRY-708-00218	5,52	25,40
RDRY-707-00218	5,52	25,40	RSRY-708-00218	5,52	12,70
RDRY-704-00265	6,70	28,58	RSRY-708-00265	6,70	28,58
RDRY-704-00312	7,90	38,10	RSRY-708-00312	7,90	38,10
RDRY-707-00312	7,92	28,58	RSRY-708-00312	7,90	28,58
RDRY-704-00406	10,28	38,10	RSRY-708-00406	10,29	38,10
RDRY-704-00468	11,86	38,10	RSRY-708-00468	11,86	38,10
RDRY-704-00531	13,46	38,10	RSRY-708-00531	13,46	38,10
RDRY-704-00625	15,85	38,10	RSRY-708-00625	15,85	38,10
RDRY-704-00687	17,42	38,10	RSRY-708-00687	17,42	38,10
RDRY-704-00812	20,60	38,10	RSRY-708-00812	20,60	38,10

# BODY COMPONENTS COMPONENTI DEL CORPO SERIES / SERIE RAWA

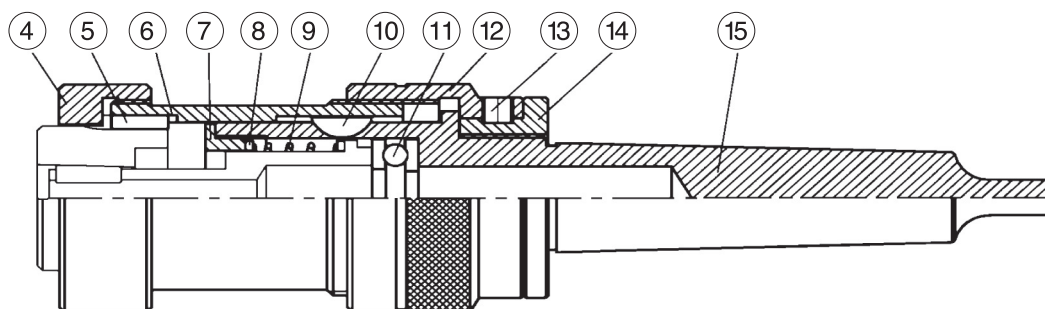
S.C.A.M.I.®

## SERIES / SERIE RAWA - 100 - 00000



Item Pos.	Description Descrizione	Code Codice	Qty Qtà
16	Straight Shank / Attacco cilindrico	RASA - 041 - 00000	1

## SERIES / RAWA - 200 - 00000



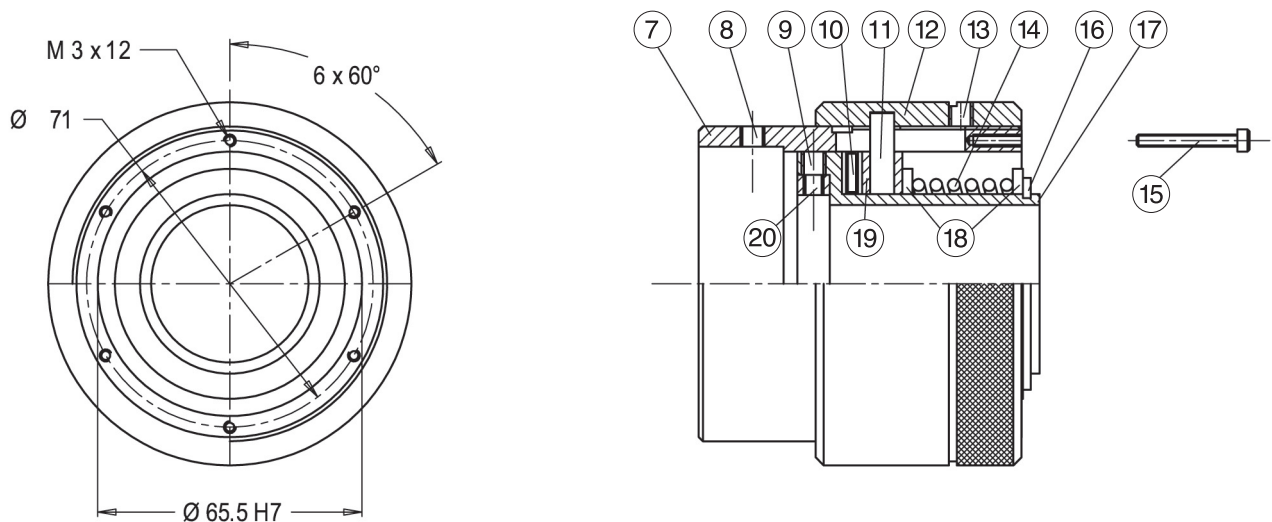
Item Pos.	Description Descrizione	Code Codice	Qty Qtà
4	Mandrel tip nut / Ghiera di bloccaggio	RAZA - 051 - 00000	1
5	Key / Chiavetta	RAZA - 006 - 010121	1
6	Cone sleeve / Porta asta	RAZA - 211 - 00000	1
7	Retaining nut / Tappo	RAZA - 201 - 00000	1
8	Thrust washer / Ralla	RAZA - 008 - 00000	2
9	Release spring / Molla	RDZH - 003 - 00005	1
10	Key / Chiavetta	RAZA - 006 - 01022	1
11	Thrust bearing / Cuscinetto	RAZA - 025 - 05002	1
12	Micrometer nut / Ghiera graduata	RAZA - 152 - 00000	1
13	Retaining collar screw / Grano di bloccaggio	RAZA - 030 - 11067	1
14	Retaining collar / Anello	RAZA - 161 - 00000	1
15	M.T. 3 Shank / Attacco C.M. 3	RASA - 042 - 00000	1

# BODY COMPONENTS

## COMPONENTI DEL CORPO

### SERIES / SERIE RAWB

SERIES / SERIE RAWB - 000 - 00000

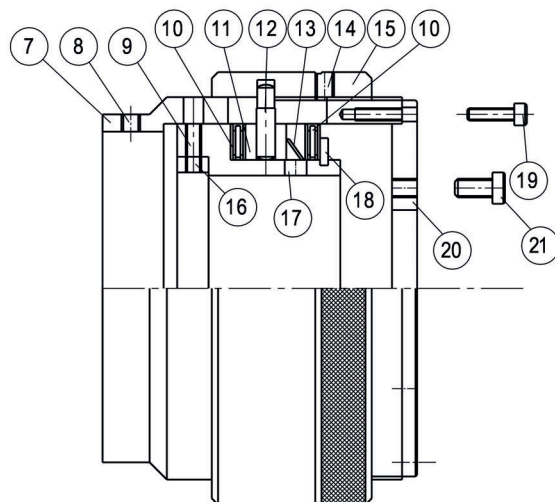
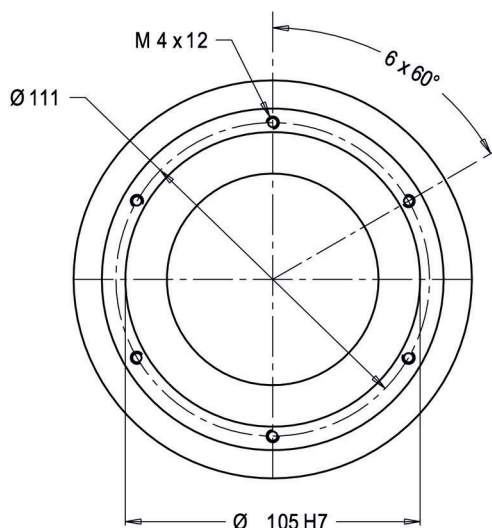


Item Pos.	Description Descrizione	Code Codice	Qty Qtà
7	Mandrel sleeve / Cannotto	RAZB - 211 - 00000	1
8	Screw / Grano	RDZK - 060 - 00400	3
9	Screw / Grano	RDZK - 060 - 00500	3
10	Thrust bearing / Cuscinetto	RAZB - 031 - 00009	1
11	Pin / Perno	RAZB - 261 - 00000	3
12	Micrometer nut / Ghiera graduata	RAZB - 152 - 00000	1
13	Retaining nut / Grano di bloccaggio	RAZB - 152 - 06070	1
14	Release spring / Molla	RAZB - 003 - 00036	1
15	Shank screw / Vite per attacco	RAZB - 001 - 10077	6
16	Seeger / Seeger	RAZB - 010 - 10007	1
17	Cage sleeve / Guidagabbia	RAZB - 074 - 00000	1
18	Thrust washer / Ralla	RAZB - 031 - 01004	2
19	Pin ring / Portaperni	RAZB - 251 - 00000	1
20	Screw / Grano	RDZK - 050 - 00500	3
21	Shank screw / Vite per attacco	RAZB - 001 - 01077	6

# BODY COMPONENTS COMPONENTI DEL CORPO SERIES / SERIE RAWC

S.C.A.M.I.®

## SERIES / SERIE RAWC - 000 - N0000



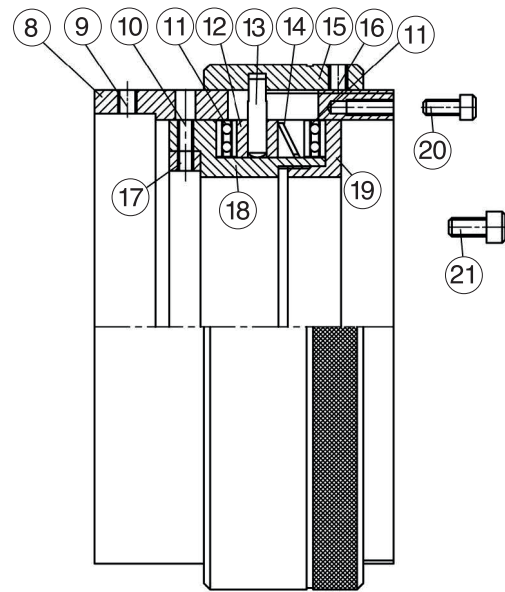
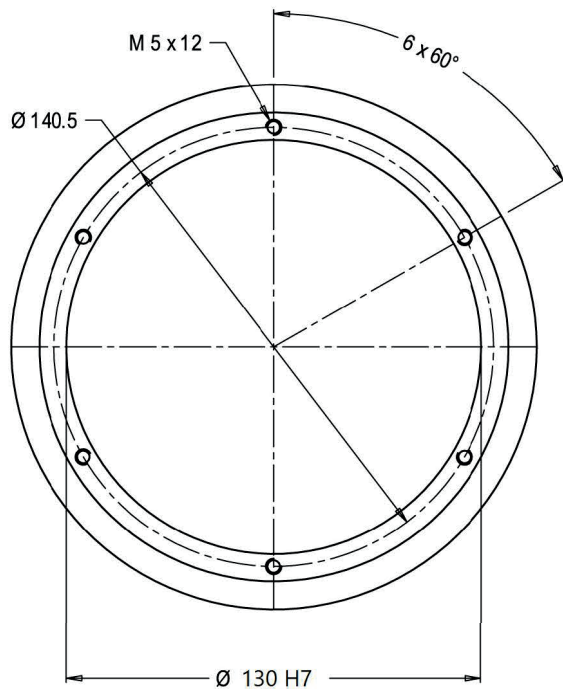
Item Pos.	Description Descrizione	Code Codice	Qty Qtà
7	Mandrel sleeve / Cannotto	RAZC - 211 - 00000	1
8	Screw / Grano	RDZK - 060 - 00600	3
9	Screw / Grano	RDZK - 050 - 00500	3
10	Thrust bearing / Cuscinetto	RAZC - 031 - N0011	2
11	Pin ring / Portaperni	RAZC - 251 - N0000	1
12	Pin / Perno	RAZC - 261 - N0000	6
13	Release spring / Molla	RAZC - 006 - N9002	1
14	Retaining nut / Grano di bloccaggio	RAZC - 152 - 06090	1
15	Micrometer nut / Ghiera graduata	RAZC - 152 - N0000	1
16	Screw / Grano	RDZK - 050 - 00500	3
17	Cage sleeve / Guidagabbia	RAZC - 074 - N0000	1
18	Seeger	RAZC - 018 - N0000	1
19	Shank screw / Vite per attacco	RAZC - 019 - N0000	6
20	Flange shank / Flangia attacco	RASC - 040 - 00000	1
21	Flange screw / Vite Flangia	RAZC - 021 - N0000	6

# BODY COMPONENTS

## COMPONENTI DEL CORPO

### SERIES / SERIE RAWD

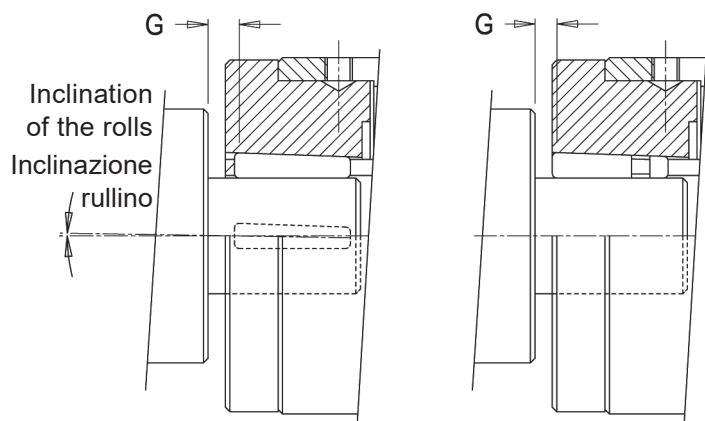
#### SERIES / SERIE RAWD - 000 - 00000



Item Pos.	Description Descrizione	Code Codice	Qty Qtà
8	Mandrel sleeve / Cannotto	RAZD - 211 - 00000	1
9	Screw / Grano	RDZK - 060 - 00800	3
10	Screw / Grano	RDZK - 050 - 00500	3
11	Thrust bearing / Cuscinetto	RAZD - 031 - 00012	2
12	Pin ring / Portaperni	RAZD - 251 - 00000	1
13	Pin / Perno	RAZD - 261 - 00000	6
14	Release spring / Molla	RAZD - 006 - 90003	1
15	Micrometer nut / Ghiera graduata	RAZD - 152 - 06100	1
16	Retaining nut / Grano di bloccaggio	RAZD - 152 - 00000	1
17	Screw / Grano	RDZK - 050 - 00500	3
18	Cage sleeve / Guidagabbia	RAZD - 074 - 00000	1
19	Nut / Ghiera	RAZD - 019 - 00000	1
20	Flange screw / Vite per flangia	RAZD - 020 - 00000	6
21	Shank screw / Vite per attacco	RAZD - 021 - 00000	6

# ADJUSTMENT & HOW THE ROLLER BURNISHING TOOL WORKS

## REGISTRAZIONE E FUNZIONAMENTO RULLATORE



Adjustment range Campo di regolazione Ø D min. max.	Dimension / Quota "G"	
	Through Passante Rolls / Rullini 704 - 707 min. max.	Bottoming style Con Battuta Rolls / Rullini 705 - 705
2,86 - 11,95	2,40 - 8,5	0,60
11,96 - 95,35	4,00 - 14,5	1,00

### Adjustment

The roller burnishing tool incorporates a shank, a body and a planetary system of conical rolls which are evenly spaced by a retaining cage. Before use, the burnishing tool must be adjusted to the required working diameter using the following steps:

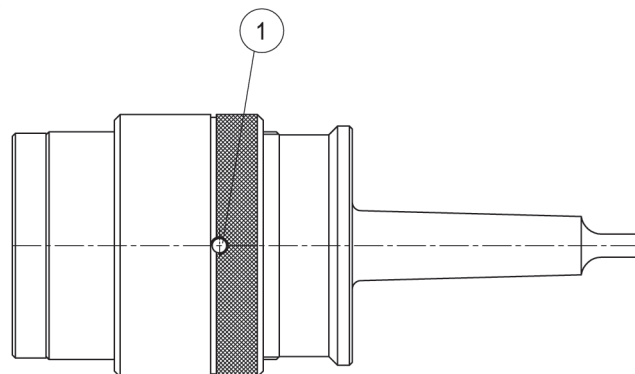
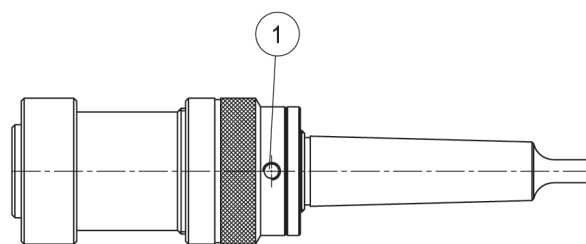
- 1) unscrew the lock screw (item 1);
- 2) turn the adjustment housing for increase or decrease the diameter;
- 3) tighten the lock screw.

### Registrazione

Il rullatore è costituito da un attacco, un corpo ed un sistema planetario di rullini conici tenuti in posizione da una gabbia.

L'impiego del rullatore deve essere preceduto dalla regolazione alla misura di lavoro; tale operazione si esegue:

- 1) svitare il grano di bloccaggio (part. 1);
- 2) ruotare la boccia di registrazione a seconda se si vuole aumentare o diminuire il diametro;
- 3) avvitare il grano di bloccaggio.



### How it works

The roller burnishing tool must be aligned with the workpiece (maximum error 0,1); if there are doubts on the alignment error, a floating shank is needed. When the tool is in the bore, the cone pushes the rolls onto the surface to be burnished. The cage retains the rolls in an angled position to the axis of the tool, so the pressure of the burnishing generates a self feed that draws the tool into the bore. When self feed is not required, i.e. bottoming style, you must use a cage which holds the rolls parallel with the axis of the tool. If the burnishing tool is not used with correct self feed, the rolls pull the cage, held in position by the release spring, and they then release from the surface. The release of the rolls permits the quick retraction (see table dimension "G").

The release spring will ensure the rolls are in the correct position to burnishing the required diameter. The roller burnishing tool requires lubrication not cooling. A plentiful supply of lubricant must be fed directly to tool to provide a good flushing and cleaning action. It is recommended that a filter is fitted to the lubrication system to prevent the circulation of chips which may cause damage to the burnished surface and the tool.

### Funzionamento

L'utensile deve essere allineato con il pezzo (errore massimo 0,1); quando esistono dubbi sull'errore di allineamento, si deve utilizzare un attacco flottante. Quando l'utensile entra in presa sul pezzo, l'asta conica forza i rullini contro la superficie da rullare. I rullini conici sono tenuti dalla gabbia in una posizione inclinata rispetto all'asse dell'utensile pertanto, la pressione di rullatura genera una componente assiale che tira l'utensile nel pezzo e viceversa. Quando si richiede la rullatura con battuta, si ricorre alla gabbia che tiene i rullini dritti. Se il rullatore non viene utilizzato con l'avanzamento richiesto da tale componente, i rullini trascinano in avanti la gabbia che è tenuta in posizione dalla molla e si sganciano dalla superficie lavorata con conseguente discontinuità di finitura e di misura. Peraltro, la possibilità di sganciare i rullini dalla superficie lavorata consente l'estrazione rapida del pezzo (vedi tabella quota "G"). Provvederà la molla a riportare i rulli in posizione di lavoro alla misura fissata. Il rullatore necessita di lubrificazione. Qualsiasi olio lubrificante o miscela di olio solubile è utilizzabile. Il lubrificante deve arrivare sull'utensile con continuità ed abbondanza. È indispensabile l'impiego di un filtro per impedire che i trucioli siano trascinati in circolo, con conseguente danno all'utensile ed alla superficie del pezzo rullato.



# TECHNICAL INFORMATION

## INDICAZIONI TECNICHE

Material to work Materiale da lavorare	Diameter Diametro mm	Stock allowance on Ø Sovrametallo sul Ø	Surface finish (Ra) / Rugosità (Ra)	
			Before roller burnishing Prima della rullatura	After roller burnishing Dopo la rullatura
High ductility Molto duttile	3 - 12	0,010 0,015	2,0 2,5	0,2 0,2
	12 - 25	0,012 0,025	2,0 4,5	0,2 0,2
	25 - 50	0,017 0,025	2,5 4,5	0,2 0,2
	50 - 95	0,025 0,050	3,1 10,0	0,2 0,2
Low ductility Poco duttile	3 - 12	0,008 0,012	1,5 2,3	0,4 0,4
	12 - 25	0,012 0,018	2,5 3,5	0,4 0,4
	25 - 50	0,012 0,025	2,5 4,5	0,4 0,4
	50 - 95	0,020 0,035	3,1 5,0	0,4 0,4

Diameter Diametro mm	Feed mm/rev Auto avanzamento mm/giro	Speed RPM Velocità giri/min.
4	0,05	1400
8	0,20	
10	0,23	
13	0,25	
16	0,29	1000
18	0,35	
20	0,42	
25	0,48	
30	0,60	750
35	0,67	
40	0,80	
45	0,86	
50	1,20	500
55	1,40	
60	1,50	
70	1,60	
85	1,90	
95	2,50	

### High ductility materials

Have less than 30 RC and more than 18% elongation  
E.g.: stainless steel, annealed steel, aluminium brass, bronze and malleable iron.

### Low ductility materials

Have less than 40 RC and less than 18% elongation  
E.g.: nodular iron, grey cast iron, heat treated steel, magnesium alloys and hard copper alloys.

### Materiali molto duttili

Durezza inferiore a 30 HRC, con allungamento percentuale dopo rottura superiore al 18%

Es.: acciai a basso tenore di carbonio, acciai da costruzione ricotti, acciai inox, alluminio, ottone, ghisa malleabile, rame.

### Materiali poco duttili

Durezza inferiore a 40 HRC, con allungamento percentuale dopo rottura inferiore al 18%

Es.: ghisa grigia, acciai bonificati, leghe al magnesio.

RPM can be increased or decreased according to the material to work.

The chart is for guide purposes only; in different conditions the results may vary.

Excessive roller burnishing accelerates tool wear and can produce flaking on the burnished surface.

Il numero dei giri/min pu essere aumentato o diminuito in funzione del tipo di materiale lavorato.

Mantenersi sui valori della tabella; valori eccessivi della velocit o dell'avanzamento riducono la durata dell'utensile.

# INSTRUCTIONS FOR ASSEMBLY AND DISASSEMBLY

## External roller burnishing tools for cylindrical surfaces bottoming style and through style (from Ø 2,74 to Ø 11,95)

### Rolls disassembly

- 1 - Turn the adjustment housing for bringing forward the cage
- 2 - Pull the cage forward manually or with a screwdriver
- 3 - Remove the rolls



### Assembly

Reassembly the components in the inverted order of disassembly.  
Grease the rolls before their assembly.

### Cone disassembly

- 1 - Disassembly the rolls as already instructed above
- 2 - Unscrew the lock nut
- 3 - Extract the cone

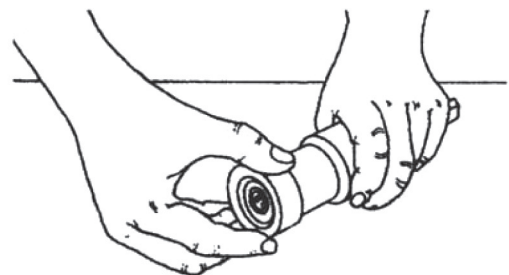


### Assembly

Reassembly the components in the inverted order of disassembly.

### Cage disassembly

- 1 - Disassembly the rolls and the cone
- 2 - Unscrew the lock nut
- 3 - Extract the cage



### Assembly

Reassembly the components in the inverted order of disassembly.

# ISTRUZIONI PER IL MONTAGGIO E LO SMONTAGGIO

## Rullatori per esterni per superfici cilindriche con battuta e passanti (dal Ø 2,74 al Ø 11,95)

### Smontaggio dei rullini

- 1 - Girare la boccia di registrazione per portare il più avanti possibile la gabbia
- 2 - Tirare la gabbia in avanti, a mano o con l'aiuto di un cacciavite
- 3 - Togliere i rullini

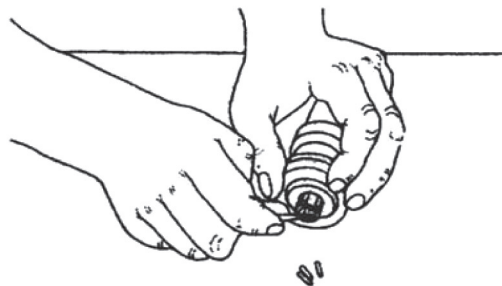


### Montaggio

Montare i pezzi dell'utensile nell'ordine inverso dalle operazioni di smontaggio.  
Prima di montare i rullini ricoprirli con del grasso.

### Smontaggio dell'asta

- 1 - Smontare i rullini come indicato
- 2 - Svitare la ghiera di bloccaggio
- 3 - Sfilare l'asta

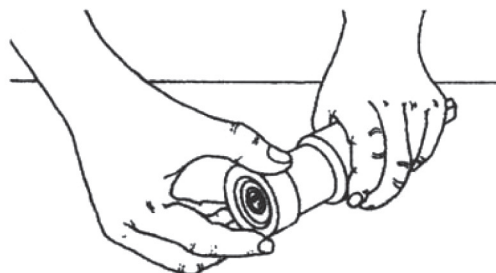


### Montaggio

Montare i pezzi nell'ordine inverso dalle operazioni di smontaggio.

### Smontaggio della gabbia

- 1 - Smontare i rullini e l'asta come indicato
- 2 - Svitare la ghiera di bloccaggio all'interno dell'utensile
- 3 - Sfilare la gabbia



### Montaggio

Montare i pezzi nell'ordine inverso dalle operazioni di smontaggio.

# INSTRUCTIONS FOR ASSEMBLY AND DISASSEMBLY

## External roller burnishing tools for cylindrical surfaces bottoming style and through style (from Ø 11,96 to Ø 95,35)

### Cage and rolls disassembly

- 1 - Turn forward the adjustment housing towards the cage till the holes without screws of the cone are aligned with the screws of the cage sleeve. For the series "B" the holes coincide to ones for locking the cone.
- 2 - Unscrew the cage sleeve screws
- 3 - Disassembly the cage
- 4 - Remove the rolls

### Assembly

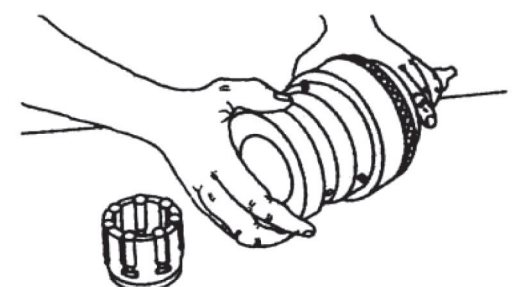
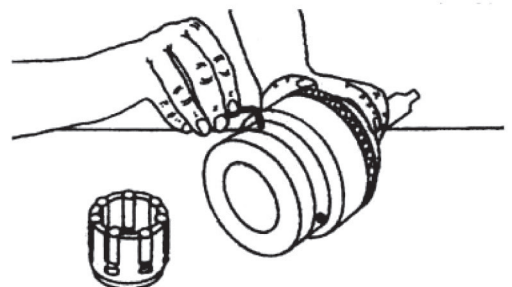
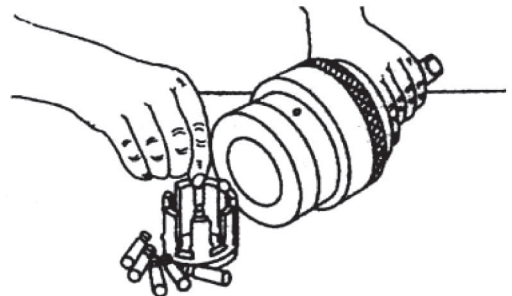
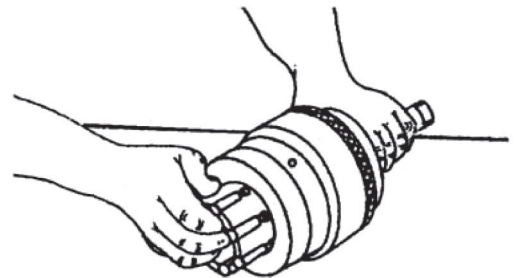
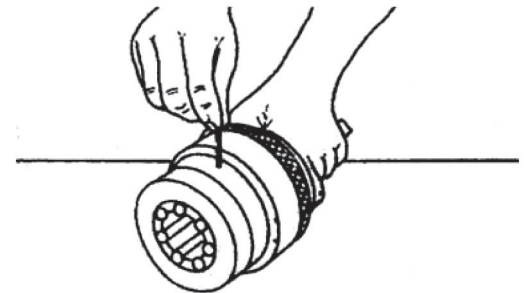
Reassembly the components in the inverted order of disassembly. Grease the rolls before their assembly.

### Cone disassembly

- 1 - Disassembly the cage and the rolls as already instructed above
- 2 - Extract the cone

### Assembly

Reassembly the components in the inverted order of disassembly.



# ISTRUZIONI PER IL MONTAGGIO E LO SMONTAGGIO

## Rullatori per esterni per superfici cilindriche con battuta e passanti (dal Ø 11,96 al Ø 95,35)

### Smontaggio della gabbia e dei rullini

- Girare la boccola di registrazione in avanti verso la gabbia fino a che i fori senza viti dell'asta siano in linea con le viti del guidagabbia. Nel tipo B i fori corrispondono a quelli di bloccaggio dell'asta.

Se i fori non si trovano in linea con le viti, girare la gabbia per portarli in linea.

2 - Svitare le viti sul guidagabbia

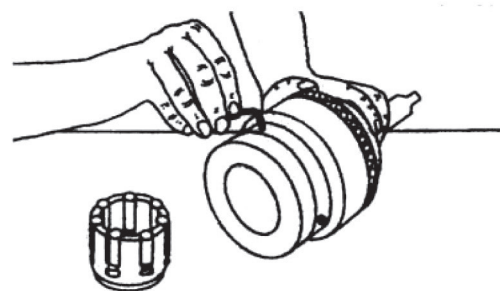
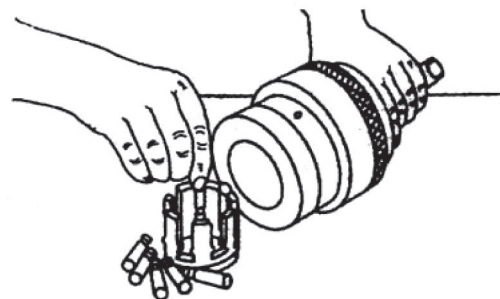
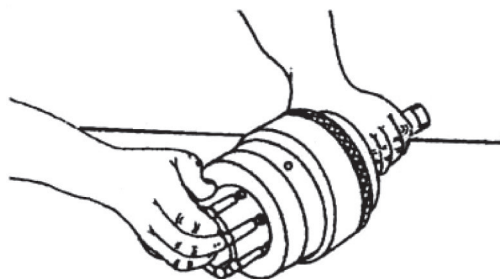
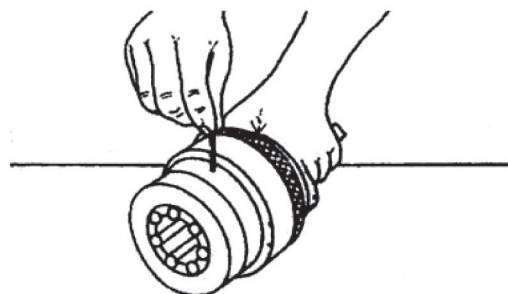
3 - Smontare la gabbia

4 - Togliere i rullini

### Montaggio

Montare i pezzi dell'utensile nell'ordine inverso dalle operazioni di smontaggio.

Prima di montare i rullini ricoprirli con del grasso.



### Smontaggio dell'asta

1 - Smontare la gabbia ed i rullini come indicato

2 - Sfilare l'asta

### Montaggio

Montare i pezzi dell'utensile nell'ordine inverso dalle operazioni di smontaggio.