

BORING BAR STYLE CARBIDE-ROLL BURNISHING TOOLS

- Reduce machining cost
- Eliminate secondary operations and machines
- Burnish on CNC turning centers and manual lathes
- Produce 4 to 20 microinch (0.1 to 0.5 μm) surface finishes
- Economical tool life with carbide rolls and roll reconditioning program



Tool Number	Shank Size (cylindrical)	OAL	Effective Reach	Roll Radius
S2289-00	$\varnothing 1.5"$	9.5" (241.3mm)	3.1" (78.74mm)	0.032" (0.787mm)
S2289-00M	$\varnothing 40\text{mm}$	9.5" (241.3mm)	3.1" (78.74mm)	0.032" (0.787mm)
S2289A00	$\varnothing 1.5"$	9.5" (241.3mm)	3.1" (78.74mm)	0.093" (2.36mm)
S2289A00M	$\varnothing 40\text{mm}$	9.5" (241.3mm)	3.1" (78.74mm)	0.093" (2.36mm)
S2289B00	$\varnothing 1.5"$	9.5" (241.3mm)	3.1" (78.74mm)	0.062" (1.57mm)
S2289B00M	$\varnothing 40\text{mm}$	9.5" (241.3mm)	3.1" (78.74mm)	0.062" (1.57mm)
S2320-00	$\varnothing 2"$	12" (304.8mm)	6" (152.4mm)	0.032" (0.787mm)
S2320-00M	$\varnothing 50\text{mm}$	12" (304.8mm)	6" (152.4mm)	0.032" (0.787mm)
S2340-00	$\varnothing 2"$	12" (304.8mm)	6" (152.4mm)	0.093" (2.36mm)
S2340-00M	$\varnothing 50\text{mm}$	12" (304.8mm)	6" (152.4mm)	0.093" (2.36mm)
CB127-00	$\varnothing 2"$	12" (304.8mm)	6" (152.4mm)	0.062" (1.57mm)
CB127-00M	$\varnothing 50\text{mm}$	12" (304.8mm)	6" (152.4mm)	0.062" (1.57mm)
S2320A00	$\varnothing 2"$	18" (457.2mm)	12" (304.8mm)	0.032" (0.787mm)
S2320A00M	$\varnothing 50\text{mm}$	18" (457.2mm)	12" (304.8mm)	0.032" (0.787mm)
CB168-00	$\varnothing 2"$	18" (457.2mm)	12" (304.8mm)	0.062" (1.57mm)
CB168-00M	$\varnothing 50\text{mm}$	18" (457.2mm)	12" (304.8mm)	0.062" (1.57mm)
S2340A00	$\varnothing 2"$	18" (457.2mm)	12" (304.8mm)	0.093" (2.36mm)
S2340A00M	$\varnothing 50\text{mm}$	18" (457.2mm)	12" (304.8mm)	0.093" (2.36mm)

Notes: Other sizes and specials are available on request

Model S2320-00 with a 1.75" diameter roll and a .032" radius is for burnishing parts with a minimum ID of 2.25" and with an OAL of 12" can easily burnish as deep as 8" to 9". This tool is also available with a .062" radius roll (CB127-00) and with a .093" radius roll (S2340-00).

Model S2320A00 is a longer version of model S2320-00. It has an OAL of 18" and can easily burnish as deep as 14" to 15". This tool is also available with a .062" radius roll (CB168-00) and with a .093" radius roll (S2340A00).

Model S2289-00 is ideal for smaller parts being run on turning centers, with a 1.188" diameter roll with a .032" radius roll for burnishing parts with a minimum bore diameter of 1.375" and maximum of approx. 2.25" and to a depth of 3". This tool is also available with a .062" radius roll (S2289B00) and with a .093" radius roll (S2289A00).

The above tools all have the capability to burnish OD surfaces if required. The carbide rollers can be reconditioned several times. Ask us for details on our carbide roll reconditioning program. These tools are also available with metric shanks.



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