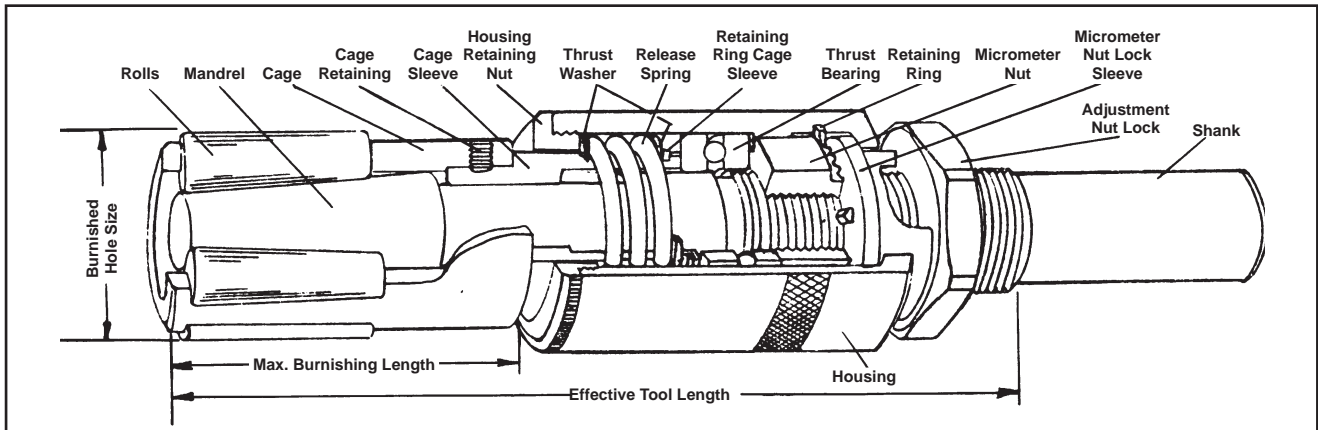


# BURNISHING TOOL DIMENSIONS



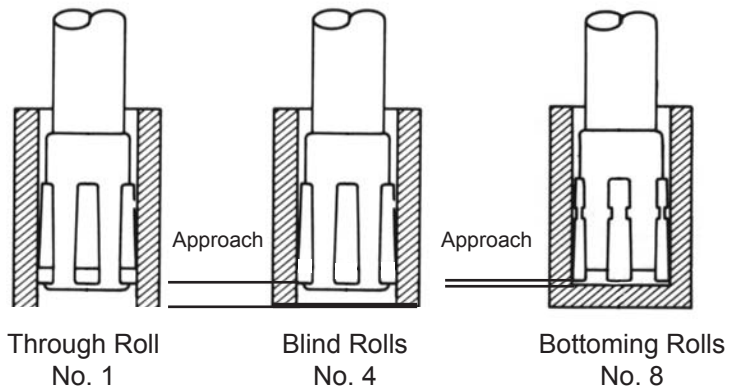
A Size Range	Tool Series	B Effective Tool Reach		C Max. Burnishing Reach				D Housing Dia.	E Drive Shank					
		Stub	Regular	Stub	Regular	Stub	Long		Straight	Morse Taper				
.187 - .484	5418													
.500 - .625	5419	5-1/8	1-5/8	7-1/8	3-5/8	9-1/8	5-7/8	1-3/16	1/2 x 1-1/2	No. 1				
.656 - .937	5433		1-5/8		3-5/8		5-5/8							
.968 - 1.187	5444	5-1/8	1-7/8	7-1/8	3-7/8	9-1/8	5-7/8	1-3/16	1/2 x 1-1/2	No. 1				
1.218 - 1.375	5405	5-3/16						1-3/16	3/4 x 1-1/2	No. 2				
1.406 - 1.812	5406													
1.843 - 2.187	5407													
2.218 - 2.687	5408	7-3/16	HOUSING SMALLER THAN HOLE MAX. BURNISHING LENGTH CONTROLLED BY TOOL LENGTH OR SHANK EXTENSIONS.					1-3/4	1 x 2-1/2	No. 3				
2.718 - 3.312	5409													
3.343 - 4.062	5610													
4.093 - 5.000	5611	9-1/8						2-15/16	1-1/2 x 5	No. 4				
5.031 - 5.875	5612													
5.906 - 6.500	5613													

Special tools with burnishing lengths longer than shown are available and will be quoted upon request. Special deep hole tools with bodies smaller than the cages are available from .375" to 1.187".

## Through Holes and Blind Holes

Tools with relieved rolls are used for through holes (Roll Style 1). These tools are self-feeding and a release clearance is required as described below. The through rolls cannot burnish as close to the bottom of the hole as blind end rolls (Roll Style 4). These rolls are interchangeable within the standard cages.

**Full Bottoming rolls** can be used in blind hole applications to minimize the release clearance (Roll Style 8). These rolls can be used in all standard cages.



## APPROACH TO BOTTOM CHART

Tool Sizes	Standard Tool Through Rolls	Standard Tool Blind Rolls	Bottoming Tool Bottoming Rolls
.187 - .359	---	.093	---
.375 - .593	---	.093	.045
.625 - 1.093	.218	.125	.060
1.125 - 3.312	.375	.156	.060
3.343 - 6.500	.406	.187	.060

Approach includes a release clearance of .030" which may be subtracted to obtain absolute minimum approach.