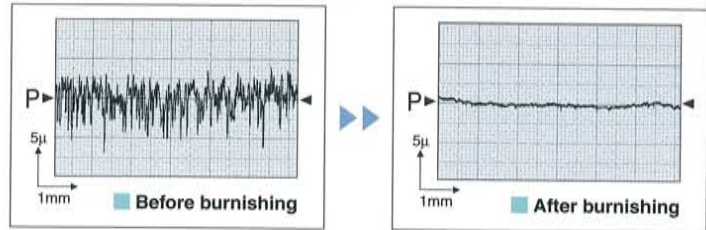




〔Machining Parameters〕

Model Number	CSL900A75L			
Material	C3604			
Processing Diameter	Inch	ø.354 x 1.850L	mm	ø9 x 47L
Surface Roughness	Ry μ inch	Before	173.22	Ry μ m Before 4.4
		After	23.63	Ry μ m After 0.6
Rotation Speed(RPM)	min ⁻¹	1,000		
Feed Rate	Inch/rev	.032	mm/rev	0.8
Cycle Time	Sec.	4.6		

〔Surface Finish Comparison〕



Processing Parameters

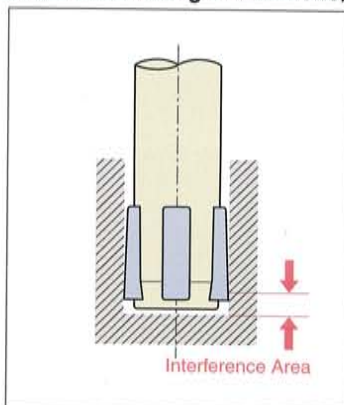
〔Description of Operation〕

- 1) Select the proper Superroll tool for the particular application.
- 2) Select the proper speeds and feeds to operate the tool.
- 3) After processing to depth, reverse the spindle rotation to counter clockwise and rapid traverse the tool out of the work piece.

〔Machining Parameters〕

Processing Diameter		Rotation Speed(RPM)	Feed	
Inch	mm	min ⁻¹	Inch/rev	mm/rev
.119~.157	3 ~ 4	1,200~2,200	.008~.023	0.2~0.6
.178~.295	4.5~ 7.5	900~1,800	.016~.031	0.4~0.8
.315~.551	8 ~14	800~1,200	.020~.047	0.5~1.2

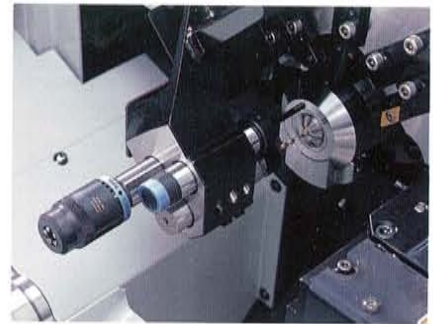
〔Tool Processing Limitations〕



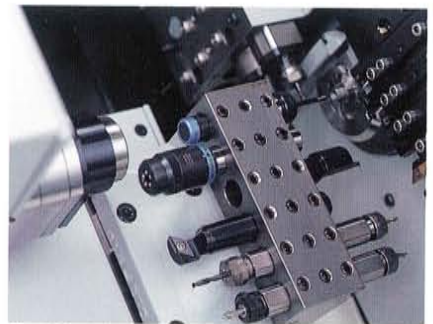
Processing Diameter		Interference Area	
Inch	mm	Inch	mm
.119~.311	3~ 7.9	.079	2.0
.315~.551	8~14	.032	0.8

Note1. There is a .020"[0.5mm] interference area that will not be processed by the tool. Please see the illustration above.

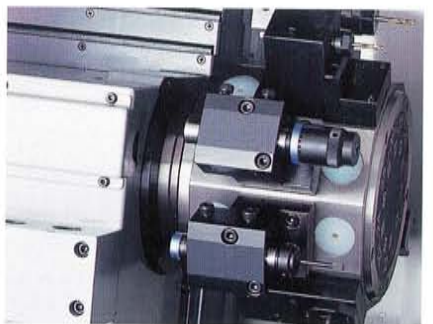
2. To minimize the amount of interference between the bottom of a surface and the tool, the mandrel extrusion may be cut to the length of the roller protrusion.



Vertical Application



Fixed Tool Application



Automatic Turret Application