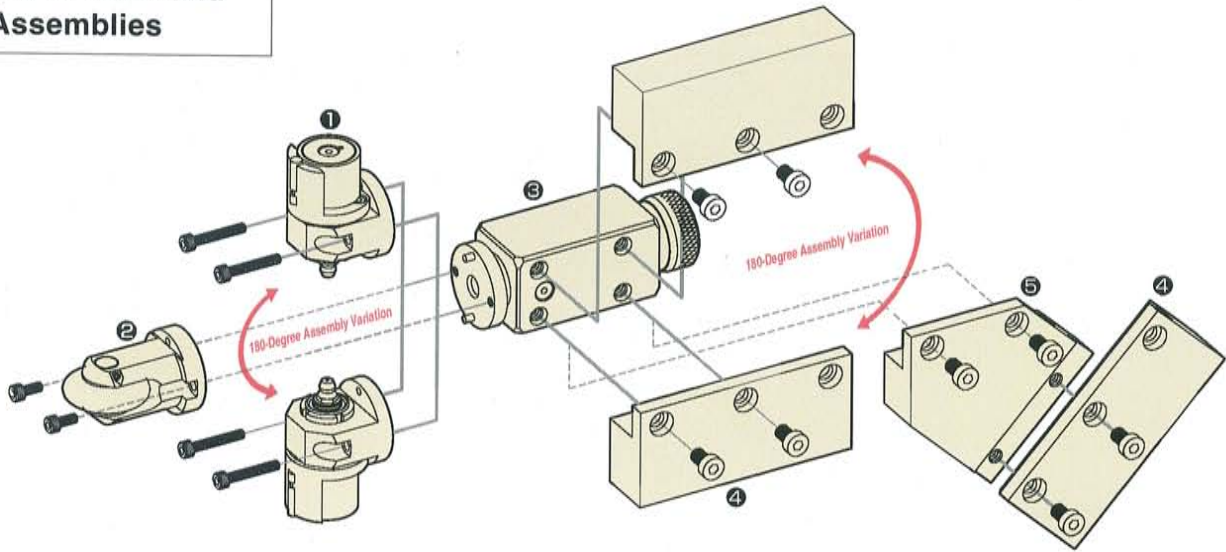


# Variations of Head and Shank Assemblies



## [Assembly Example]

SR5AL-S25 type (For outer and flat surface processing) ① + ③ + ④

SR36M45°L-S25 type (For R surface processing) ② + ③ + ⑤ + ④

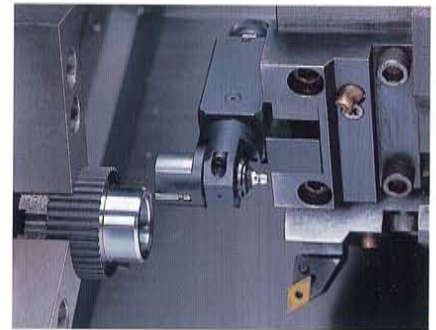
Note: Depending on the work piece and machine tool, several variations of assemblies are available.

- ① SR5 Head Assembly: OD & Flat Surface Processing
- ② R36M Head Assembly: Radial Surface Processing
- ③ Body Assembly
- ④ Shank
- ⑤ Angle Plate

## Processing Parameters

### [Description of Operation]

1. Mount the Superroll tool to one of the turret stations.
2. Adjust the pre-load setting of the control spring.
3. Process the work piece and examine it upon completion. Adjust pre-load as necessary.
4. Make sure to use coolant or another form of lubrication to prolong the tool life.



Typical CNC Lathe Application

### [Machining Parameters]

Material	Surface Speed		Feed Rate				Work Load			
	SR5/SR36M		SR5		SR36M		SR5		SR36M	
	Inch/rev	mm/rev	Inch/rev	mm/rev	Inch/rev	mm/rev	Lbf	N	Lbf	N
Carbon & Alloy steel	1.969-3.937	50-100	.004-.019	0.1 -0.5	.002-.011	0.05-0.3	112.4 -337.2	500-1,500	44.96-112.4	200-500
Stainless steel										
Cast iron										
Aluminum & Cooper alloy	3.973-7.874	100-200	.002-.011	0.05-0.3			22.48- 89.92	100- 400	11.24-33.72	50-150

Note: Use the above table as a guideline for processing. Conditions such as pre-burnish tolerance, material and material hardness will affect the surface finish. Make adjustments accordingly.