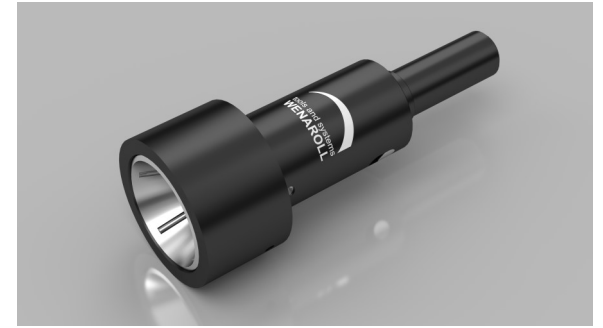


Roller burnishing tool type WAK

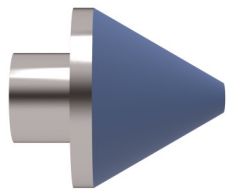


General information:

Details of the order					Tool body	Shank		Dimensions			
Tool type	Diam. ØD	Diam. Ød	Angle α	Shank		Morse taper	Cylindrical	a	b	c	E (Head)
WAK	x,xx	x,xx	x°	MK - ZS - ZA	K1	MK2	Ø20 h6 x 50	78,5	62	33	depending on the work-piece and the surface
					K2	MK3	Ø25 h6 x 56	98	85	48	
					K3	MK4	Ø32 h6 x 60	123	93	65	

All dimensions in mm

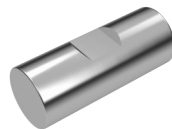
Applications:



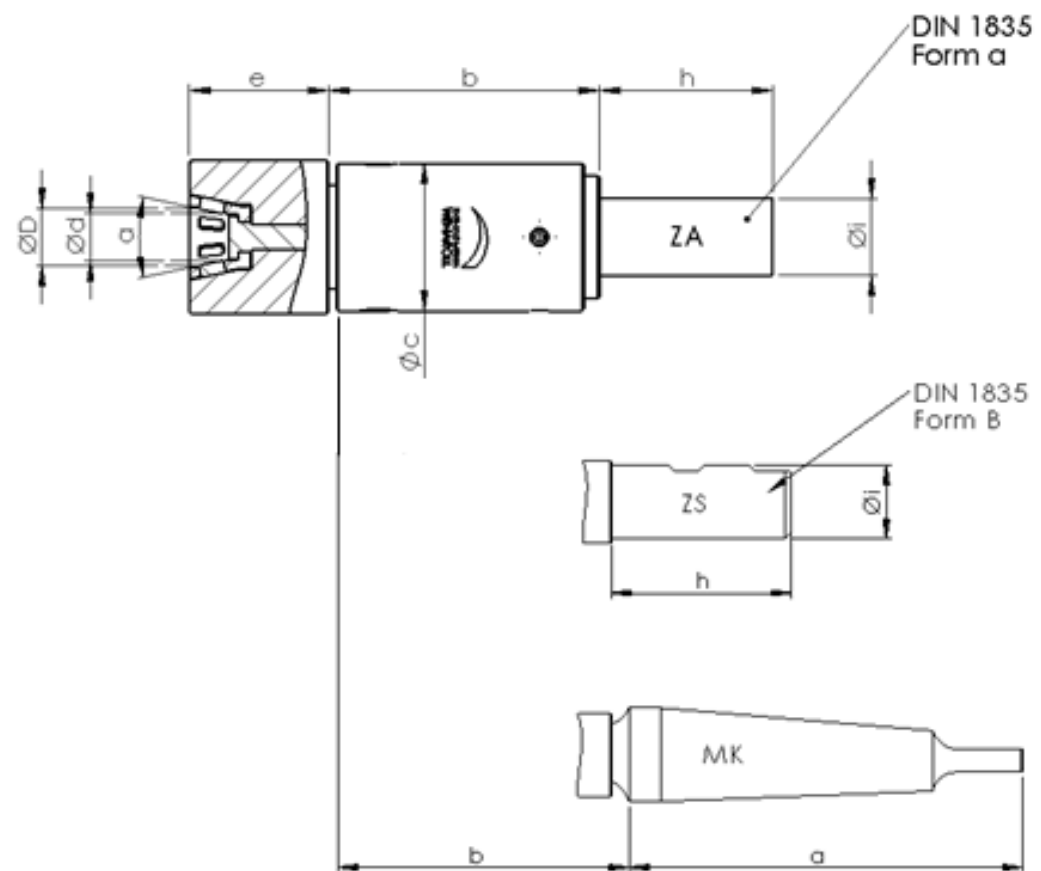
Shanks:



Morse taper



Cylindrical



Order example

WAK - 45,00 - 30,45 - 45° - ZS25

Tool type Diameter ØD Diameter Ød Angle Shank of the tool

Processing parameters:

Circumferential speed: max. 40 m/min.
 Revolution: 0,1—0,3 mm/Umdrehung
 Rolling share: up to 0,01 mm
 Hardness of the material: max. 42—45 HRC
 Pre-roughness: Rz = 5 - 20 µm
 Pre-machining: Turning or grating
 Cooling: Oil or emulsion

