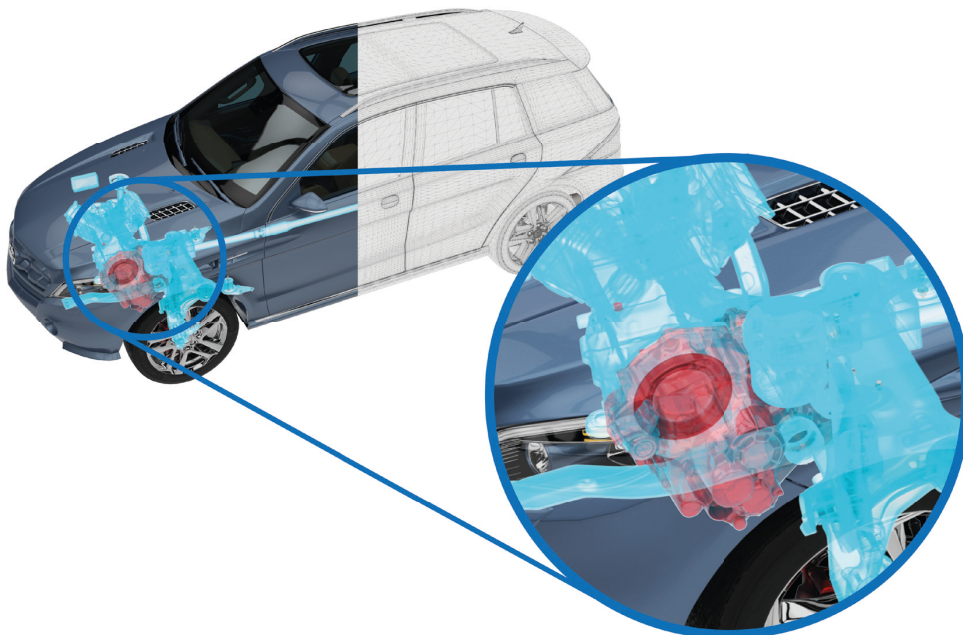


APPLICATION EXAMPLE ▶ Automotive ▶ Primary disc



Task

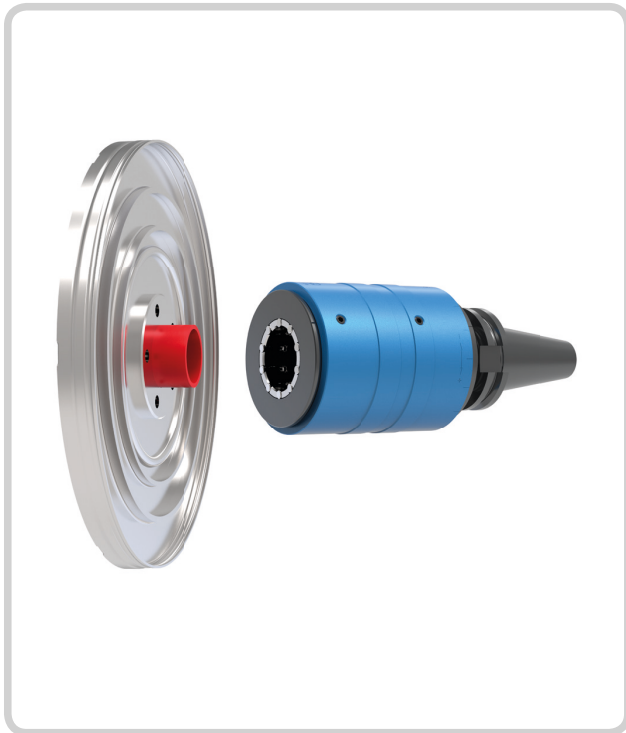
Reaching a surface quality in cast iron material of about $R_z 1,5 \mu\text{m}$; Process stability by reaching a contact area of about 70%





Solution

Processing with RA31 Roller Burnishing tool



User benefits

- Roughness of $R_z = 1,4 \mu\text{m}$ reached
- Reduction of scrap rate by about **20%**
- Processing without coolant

Details

- Workpiece Primary disc
- Part of CV-Transmission
- Material GG25
- Hardness 48 HRC

Parameter

- Tool RA31
- Circumferential speed ... 1500 m/min
- Feed rate 0,6 mm/rev.