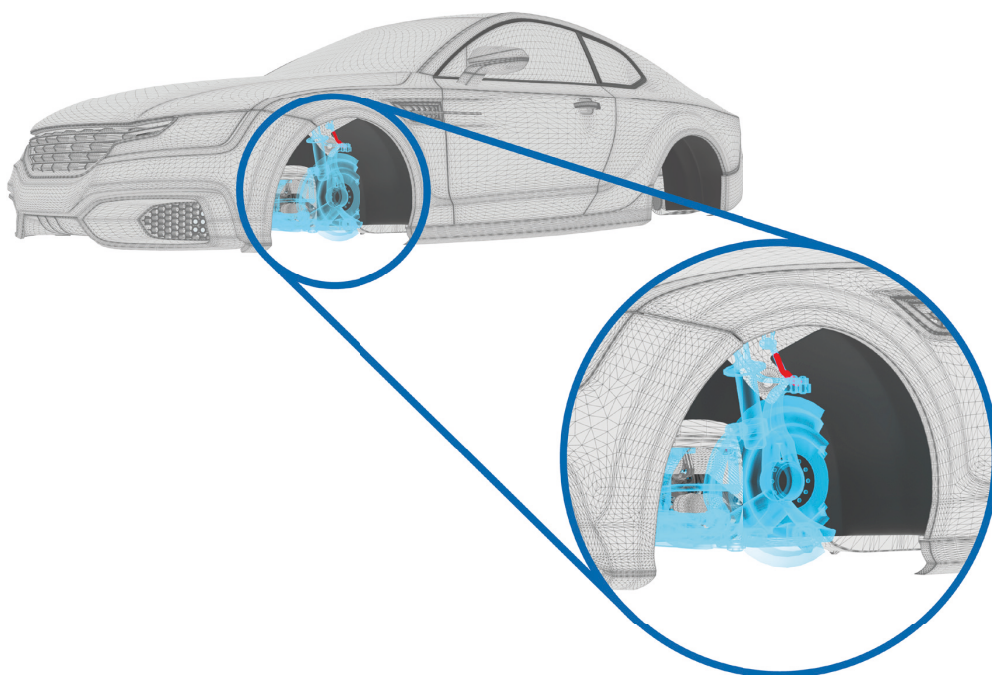


APPLICATION EXAMPLE ▶ Automotive ▶ **Steering lever**



Task

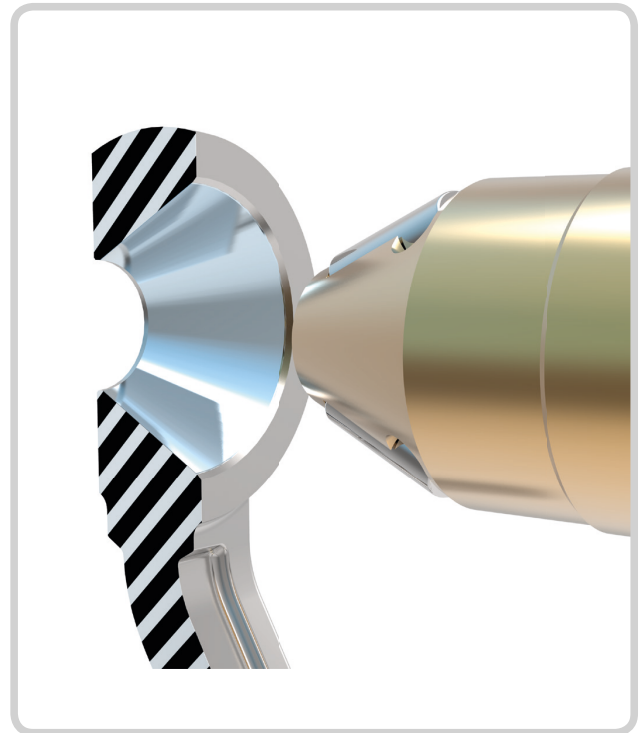
Increase surface area for tight fit and good load transmission





Solution

Processing of the conical bore with RK multi roller tool



User benefits

- Reduction of machining time by about **17%**
- Increased surface area by about **20%**
- In compliance with roughness tolerance of **$R_z = 1,5 \mu\text{m}$**

Details

- Workpiece Steering lever
- Part of Front axle
- Material Forged Steel
- Tensile strength 1100 N/mm²
- Hardness 31 HRC

Parameter

- Tool RK
- Circumferential speed ... 80 m/min
- Feed rate Plunge process
- Rolling force 700 N
- Cycle time 3 seconds