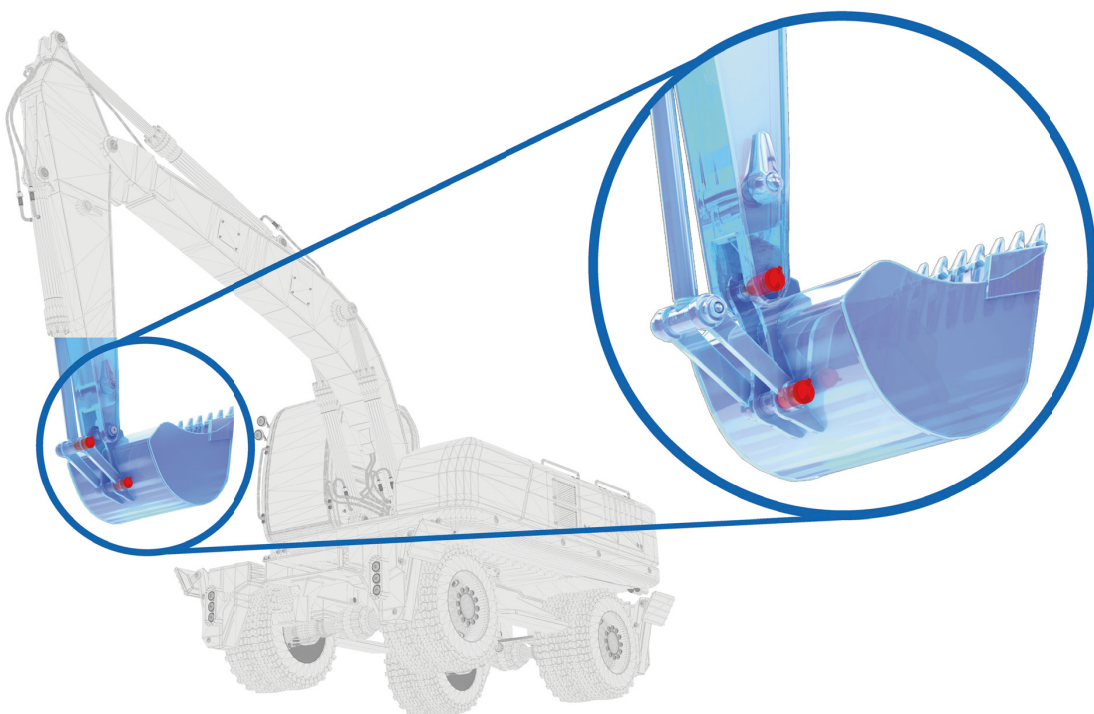


APPLICATION EXAMPLE ▶ Construction machine ▶ Swivel bearing (outside)



Task

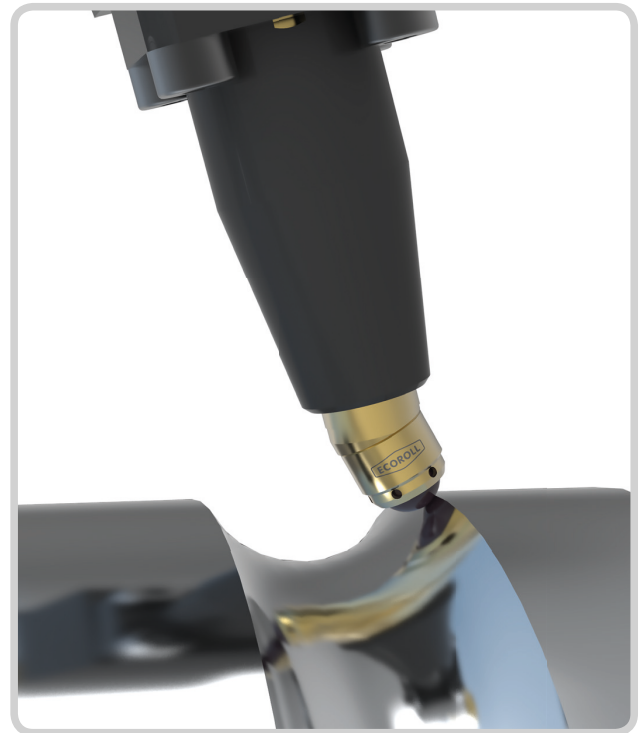
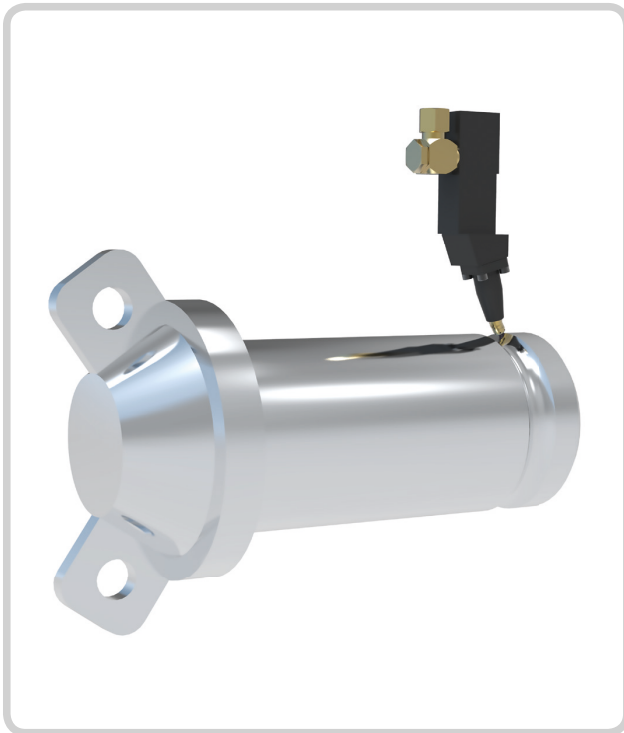
Economical generation of a bearing raceway





Solution

Processing combination of hard turning and hard roller burnishing



User benefits

- Process time reduction by about **50%**
- Surface area increased by a factor of about **1.8x**
- Process stability increased by a factor of **2.5 x**

Details

- Workpiece Swivel bearing
- Part of Excavator shovel
- Material GGG
- Tensile strength 1000 N/mm²
- Hardness 60 HRC

Parameter

- Tool HG6-9
- Circumferential speed ... 20 m/min
- Feed rate 0,1 mm/rev.
- Rolling force 1000 N
- Cycle time ≤ 1 minute