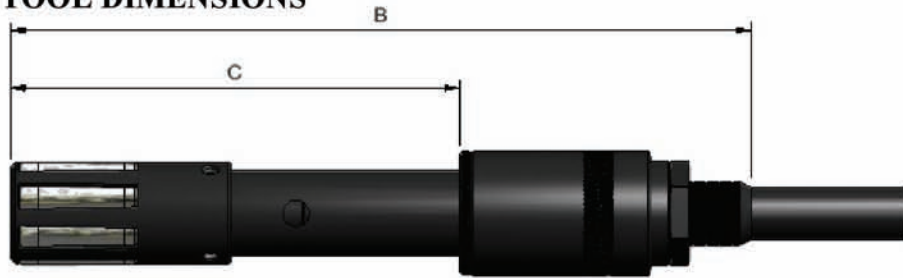
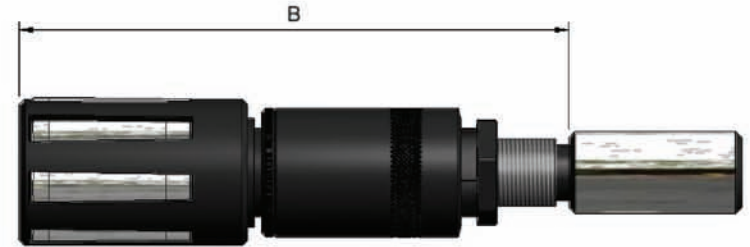


BURNISH TOOL DIMENSIONS



5418, 5419, 5433 & 5444 Series



5405 to 5613 Series

Tool Series	Series Size Range (See catalogue for each tools adjustment range)	B = Effective Tool Length		C = Maximum Burnishing length		Housing Diameter	Drive Shank Options			
		Stub		Regular			Long		Straight Shank	Morse Taper
		B	C	B	C		B	C		
5418	4.75mm – 12.29mm (0.187" - 0.484")	130mm (5.125")	41mm 1.625"	181mm (7.125")	92mm (3.625")	232mm (9.125")	143mm (5.625")	Ø12mm or Ø0.500"	N° 1	
5419	12.70mm – 15.87mm (0.500" - 0.625")		47mm 1.875"		94mm (3.875")		149mm (5.875")			
5433	16.66mm – 23.80mm (0.656" - 0.937")		41mm 1.625"		92mm (3.625")		143mm (5.625")			
5444	24.59mm – 30.15mm (0.968" – 1.187")		47mm 1.875"		94mm (3.875")		149mm (5.875")			
5405	30.94mm – 34.93mm (1.218" – 1.375")	132mm (5.188")	<p>THE HOUSING IS SMALLER THAN THE HOLE.</p> <p>THE MAXIMUM BURNISHING LENGTH IS CONTROLLED BY THE TOOL LENGTH OR SHANK EXTENSIONS CAN BE USED</p>				Ø30.2mm (Ø1.188")	Ø16mm or Ø0.750"	N° 2	
5406	35.71mm – 46.02mm (1.406" – 1.812")	183mm (7.188")						Ø44.45mm (Ø1.750")		Ø25mm or Ø1.000"
5407	46.81mm – 55.55mm (1.843" – 2.187")									
5408	56.34mm – 68.25mm (2.218" – 2.687")									
5409	69.04mm – 84.13mm (2.718" – 3.312")									
5610	84.91mm – 103.18mm (3.343" – 4.062")	232mm (9.125")					Ø74.61mm (Ø2.938")	Ø40mm or Ø1.500"	N° 4	
5611	103.96mm – 127.00mm (4.093" – 5.000")									
5612	127.79mm – 149.23mm (5.031" – 5.875")									
5613	150.01mm – 165.10mm (5.906" – 6.500")									

Special tools with longer burnishing lengths are available upon request. Special deep hole tools with bodies smaller than the cages are available below Ø30.15mm (Ø1.187").

BURNISH TOOL DIMENSIONS

THROUGH & BLIND TOOLS

These tools are self-feeding and need sufficient clearance as shown in the table.

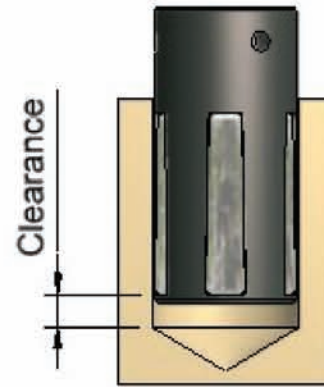
Roll style N°1 is used for through holes.

Roll style N°2 is used where there is limited clearance at the bottom of the hole.

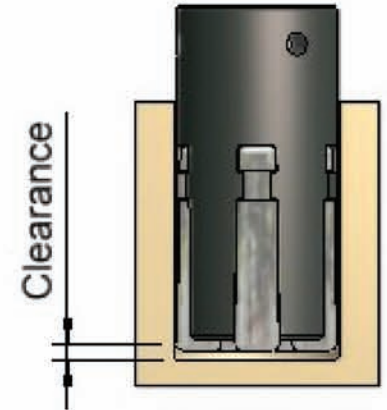
The rolls are interchangeable within the same cages.



Through Style N°1



Blind Style N°4



Bottoming Style N°8

Tool Size Range	THROUGH TOOL CLEARANCE Roll Style N°1 (5100-701-00xxx)	BLIND TOOL CLEARANCE Roll Style N°4 (5100-704-00xxx)	FULL BOTTOMING CLEARANCE Roll Style N°8 (5100-708-00xxx)
Ø4.75 – 9.12mm (0.187” – 0.359”)	NA	2.36mm (0.093”)	NA
Ø9.53 – 15.06mm (0.375” – 0.593”)	NA	2.36mm (0.093”)	1.14mm (0.045”)
Ø15.87 – 27.76mm (0.625” – 1.093”)	5.54mm (0.218”)	3.18mm (0.125”)	1.53mm (0.060”)
Ø28.58 – 84.12mm (1.125” – 3.312”)	9.53mm (0.375”)	3.96mm (0.156”)	1.53mm (0.060”)
Ø84.92 – 165.1mm (3.343” – 6.500”)	10.31mm (0.406”)	4.75mm (0.187”)	1.53mm (0.060”)

NOTE! The clearance length includes a release length of 0.76mm (0.030”) which may be subtracted to obtain the absolute minimum approach.