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SERVICE INSTRUCTIONS:

BURNISHING DIES HABEGGER

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1 GENERAL REMARKS

These burnishing dies permit to smooth the diameters. They work without radial efforts and no pressure is exerted on the workpiece, even for small diameters. The three rollers will give a better surface quality, without improving the turning geometry, however. The rollers will just follow that geometry. It is therefore important to have a good turning job done, as far as concentricity and cylindrical shape are concerned.

Main advantages:

- Good surface finish
- No radial effort exerted on the collet or guide bush
- Possibility to burnish diameters smaller than 1 mm.

2 BURNISHING CONDITIONS

2.1 Diameter before burnishing

Burnishing is obtained by smoothing the material. The turning diameter must be adapted, therefore, according to the hardness of the material and to the quality of the turning operation.

2.2 Peripheral speed

The peripheral speed of the workpiece must be about 20 meters/minute. The speed is smaller when the material to be smoothed is very hard.

2.3 Feed

The indicative value for the feed is 0.2 to 0.5 mm/revolution.

2.4 Lubrication

We also recommend to lubricate very much. Stops during and at the end of the burnishing operation must be avoided.

2.5 Finished diameter

It is absolutely necessary to have the finished diameter size indicated, when requesting an offer or placing an order.

2.6 Return of the die

The return of the burnishing die will be the same as the working feed (0.2 to 0.5 mm/rev). The return spring must be strong enough (cam machines).

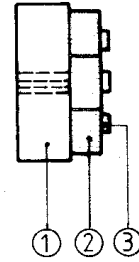
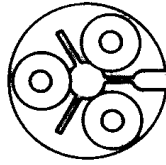
3 DESCRIPTION

3.1 Name

These burnishing dies are always named by the wanted diameter.

Part designation:

- 1 body (1)
- 3 rollers (2)
- 3 studs (3)



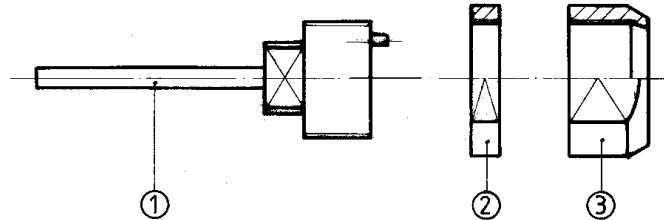
3.2 Mounting

These adjustable burnishing dies are mounted on the machines with the help of the die holders type R (see general catalogue).

4 HABEGGER DIE HOLDER TYPE R

Part designation:

- 1 shaft-body (1)
- 1 counter-nut (2)
- 1 nut (3)



Setting instructions:

- a) After having put the burnishing die on the die holder, tighten the nut (3) until it leans against the burnishing die. Then, loosen it slightly. Lock the counter-nut (2) so that the die remains free. Make sure that it is not too tight from the beginning.
- b) Combine the turned diameter and the setting of the burnishing die, until the wanted diameter has been obtained.

5 SPARE PARTS

We don't supply spare parts for this type of dies.

For spare parts orders and according to the goods, indicate the following points:

Example:

Die holder:	- type of holder - designation	Die holder R 16-8 1 nut
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