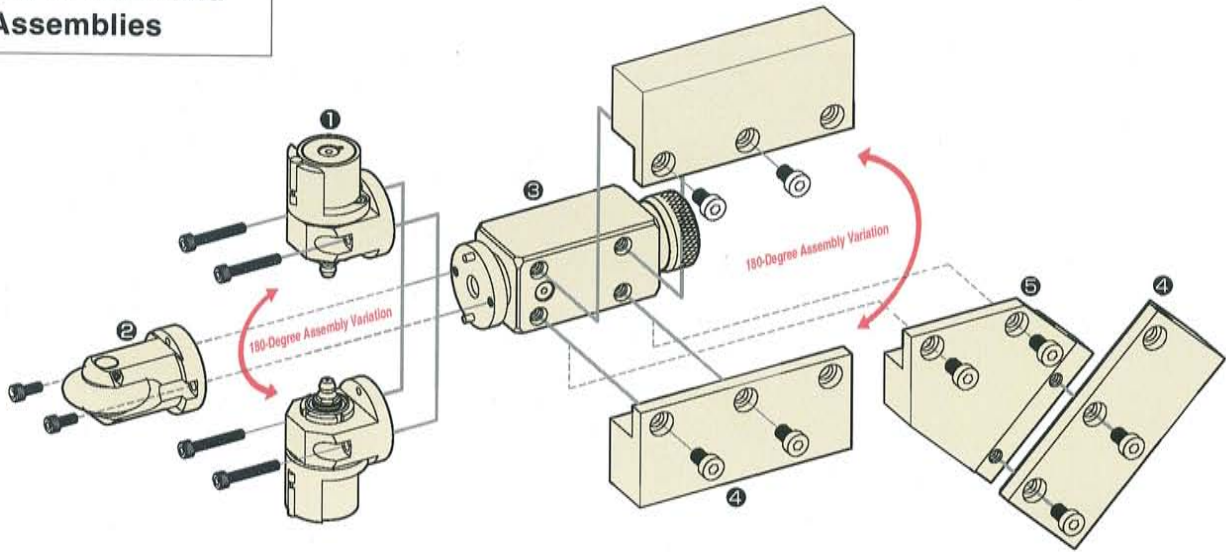


Variations of Head and Shank Assemblies



[Assembly Example]

SR5AL-S25 type (For outer and flat surface processing) ① + ③ + ④

SR36M45°L-S25 type (For R surface processing) ② + ③ + ⑤ + ④

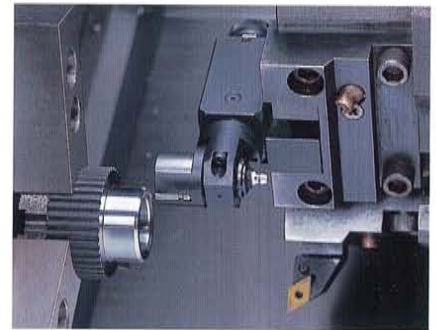
Note: Depending on the work piece and machine tool, several variations of assemblies are available.

- ① SR5 Head Assembly: OD & Flat Surface Processing
- ② R36M Head Assembly: Radial Surface Processing
- ③ Body Assembly
- ④ Shank
- ⑤ Angle Plate

Processing Parameters

[Description of Operation]

1. Mount the Superroll tool to one of the turret stations.
2. Adjust the pre-load setting of the control spring.
3. Process the work piece and examine it upon completion. Adjust pre-load as necessary.
4. Make sure to use coolant or another form of lubrication to prolong the tool life.



Typical CNC Lathe Application

[Machining Parameters]

| Material | Surface Speed | | Feed Rate | | | | Work Load | | | |
|-------------------------|---------------|---------|-----------|----------|-----------|----------|--------------|-----------|-------------|---------|
| | SR5/SR36M | | SR5 | | SR36M | | SR5 | | SR36M | |
| | Inch/rev | mm/rev | Inch/rev | mm/rev | Inch/rev | mm/rev | Lbf | N | Lbf | N |
| Carbon & Alloy steel | 1.969-3.937 | 50-100 | .004-.019 | 0.1 -0.5 | .002-.011 | 0.05-0.3 | 112.4 -337.2 | 500-1,500 | 44.96-112.4 | 200-500 |
| Stainless steel | | | | | | | | | | |
| Cast iron | | | | | | | | | | |
| Aluminum & Cooper alloy | 3.973-7.874 | 100-200 | .002-.011 | 0.05-0.3 | | | 22.48- 89.92 | 100- 400 | 11.24-33.72 | 50-150 |

Note: Use the above table as a guideline for processing. Conditions such as pre-burnish tolerance, material and material hardness will affect the surface finish. Make adjustments accordingly.