



Sourcing Technology Globally

Cogsdill Tool Products, Inc.

# Internal Roll-a-Finish® tools

## SR Series

Our premier line of internal Roll-a-Finish® tools, designed to suit all applications. Ideal for applications where tool length is restricted by tool changers, turrets, etc.



Offered in *three styles*:

- Through-hole style with no-helix cage (machine-feeding)
- Through-hole style with helix cage (self-feeding)
- Bottoming-style for blind hole, with no-helix cage (machine-feeding)



Through-Hole (No Helix)



Through-Hole (Helix)



Bottoming (No Helix)

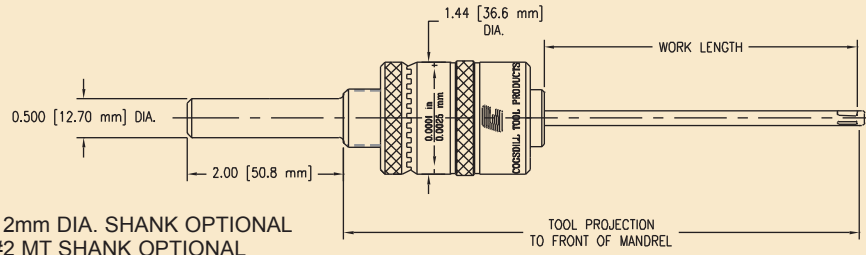
... with up to *four work lengths*:

- Two inch (SR)
- Four inch (SR-4)
- Six inch (SR-6)
- Eight inch (SR-8)

... and *available from stock*:

- for hole sizes from .187 to 2.500 inches (4.75 to 63.5mm).
- Tools are adjustable in increments of .0001 inch (.002mm).

# Standard tool specifications

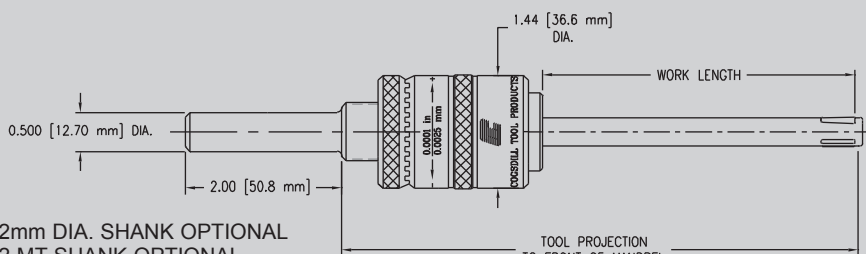


SR-188 ~ SR-242			
WORK LENGTH		TOOL PROJECTION	
in	[mm]	in	[mm]
2.00	50.8	4.69	119.1
4.00	101.6	6.61	167.9
6.00	152.4	8.61	218.7

12mm DIA. SHANK OPTIONAL  
#2 MT SHANK OPTIONAL

## “SR” SERIES ROLL-A-FINISH® TOOLS 3/16 TO 1/4 IN. (4.76 TO 6.35mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
.187-.195	4.75-4.95	SR-188	SRH-188	_____
.194-.202	4.93-5.13	SR-195	SRH-195	_____
.202-.210	5.13-5.33	SR-203	SRH-203	_____
.210-.218	5.33-5.54	SR-211	SRH-211	_____
.218-.226	5.54-5.74	SR-219	SRH-219	_____
.225-.233	5.72-5.92	SR-226	SRH-226	_____
.233-.241	5.92-6.12	SR-234	SRH-234	_____
.241-.249	6.12-6.32	SR-242	SRH-242	_____



SR-250 ~ SR-484			
WORK LENGTH		TOOL PROJECTION	
in	[mm]	in	[mm]
2.00	50.8	4.69	119.1
4.00	101.6	6.60	167.6
6.00	152.4	8.60	218.4

12mm DIA. SHANK OPTIONAL  
#2 MT SHANK OPTIONAL

## “SR” SERIES ROLL-A-FINISH® TOOLS 1/4 TO 1/2 IN. (6.35 TO 12.70mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
.246-.267	6.25-6.78	SR-250	SRH-250	SRB-250
.262-.283	6.65-7.19	SR-266	SRH-266	SRB-266
.277-.298	7.04-7.57	SR-281	SRH-281	SRB-281
.293-.314	7.44-7.98	SR-297	SRH-297	SRB-297
.308-.329	7.82-8.36	SR-312	SRH-312	SRB-312
.324-.345	8.23-8.76	SR-328	SRH-328	SRB-328
.340-.361	8.64-9.17	SR-344	SRH-344	SRB-344
.355-.376	9.02-9.55	SR-359	SRH-359	SRB-359
.371-.392	9.42-9.96	SR-375	SRH-375	SRB-375
.387-.408	9.83-10.36	SR-391	SRH-391	SRB-391
.402-.423	10.21-10.74	SR-406	SRH-406	SRB-406
.418-.439	10.62-11.15	SR-422	SRH-422	SRB-422
.434-.455	11.02-11.56	SR-438	SRH-438	SRB-438
.449-.470	11.40-11.94	SR-453	SRH-453	SRB-453
.465-.486	11.81-12.34	SR-469	SRH-469	SRB-469
.480-.501	12.19-12.73	SR-484	SRH-484	SRB-484

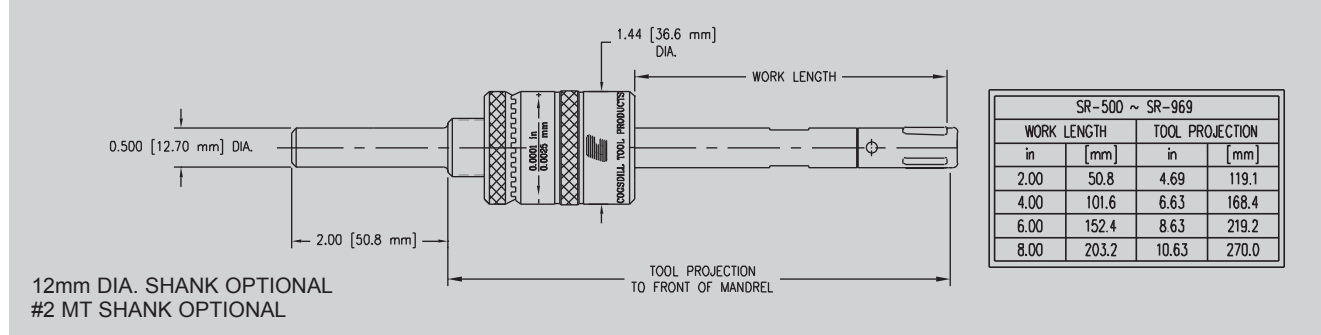
Shanks other than shown above are available upon request.



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Internal Roll-a-Finish® tools **SR series**

# Standard tool specifications

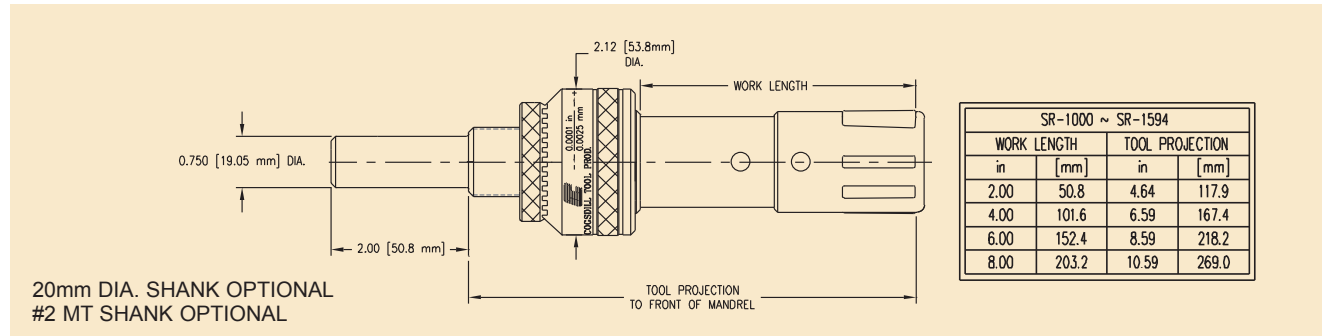


## “SR” SERIES ROLL-A-FINISH® TOOLS 1/2 TO 1 IN. (12.70 TO 25.40 mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
.496-.537	12.60-13.64	SR-500	SRH-500	SRB-500
.527-.568	13.39-14.43	SR-531	SRH-531	SRB-531
.558-.599	14.17-15.21	SR-562	SRH-562	SRB-562
.590-.631	14.99-16.03	SR-594	SRH-594	SRB-594
.621-.662	15.77-16.81	SR-625	SRH-625	SRB-625
.652-.693	16.56-17.60	SR-656	SRH-656	SRB-656
.684-.725	17.37-18.42	SR-688	SRH-688	SRB-688
.715-.756	18.16-19.20	SR-719	SRH-719	SRB-719
.746-.787	18.95-19.99	SR-750	SRH-750	SRB-750
.777-.818	19.74-20.78	SR-781	SRH-781	SRB-781
.808-.849	20.52-21.56	SR-812	SRH-812	SRB-812
.840-.881	21.34-22.38	SR-844	SRH-844	SRB-844
.871-.912	22.12-23.16	SR-875	SRH-875	SRB-875
.902-.943	22.91-23.95	SR-906	SRH-906	SRB-906
.934-.975	23.72-24.77	SR-938	SRH-938	SRB-938
.965-1.006	24.51-25.55	SR-969	SRH-969	SRB-969

*Shanks other than shown above are available upon request.*

# Standard tool specifications

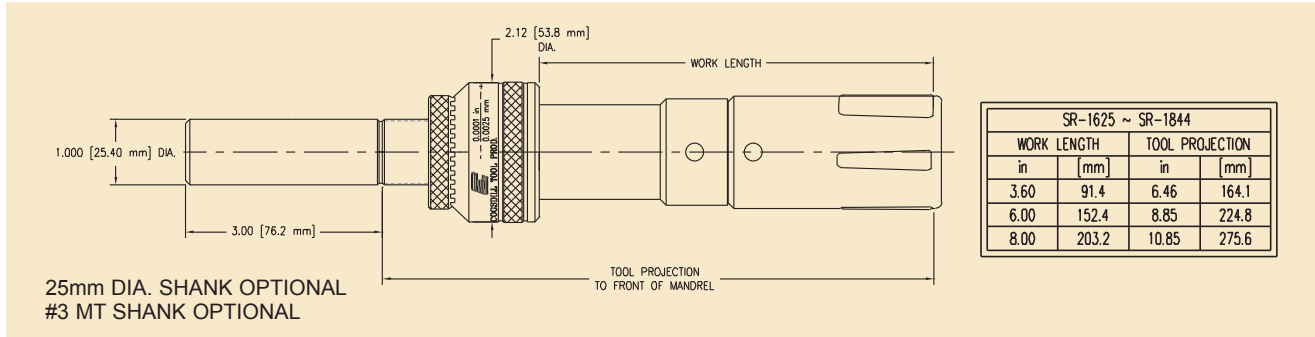


## “SR” SERIES ROLL-A-FINISH® TOOLS 1 TO 1-5/8 IN. (25.4 TO 41.28mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
.996-1.037	25.30-26.34	SR-1000	SRH-1000	SRB-1000
1.027-1.068	26.09-27.13	SR-1031	SRH-1031	SRB-1031
1.058-1.099	26.87-27.91	SR-1062	SRH-1062	SRB-1062
1.090-1.131	27.69-28.73	SR-1094	SRH-1094	SRB-1094
1.121-1.162	28.47-29.51	SR-1125	SRH-1125	SRB-1125
1.152-1.193	29.26-30.30	SR-1156	SRH-1156	SRB-1156
1.184-1.225	30.07-31.12	SR-1188	SRH-1188	SRB-1188
1.215-1.256	30.86-31.90	SR-1219	SRH-1219	SRB-1219
1.246-1.287	31.65-32.69	SR-1250	SRH-1250	SRB-1250
1.277-1.318	32.44-33.48	SR-1281	SRH-1281	SRB-1281
1.308-1.349	33.22-34.26	SR-1312	SRH-1312	SRB-1312
1.340-1.381	34.04-35.08	SR-1344	SRH-1344	SRB-1344
1.371-1.412	34.82-35.86	SR-1375	SRH-1375	SRB-1375
1.402-1.443	35.61-36.65	SR-1406	SRH-1406	SRB-1406
1.434-1.475	36.42-37.47	SR-1438	SRH-1438	SRB-1438
1.465-1.506	37.21-38.25	SR-1469	SRH-1469	SRB-1469
1.496-1.537	38.00-39.04	SR-1500	SRH-1500	SRB-1500
1.527-1.568	38.79-39.83	SR-1531	SRH-1531	SRB-1531
1.558-1.599	39.57-40.61	SR-1562	SRH-1562	SRB-1562
1.590-1.631	40.39-41.43	SR-1594	SRH-1594	SRB-1594

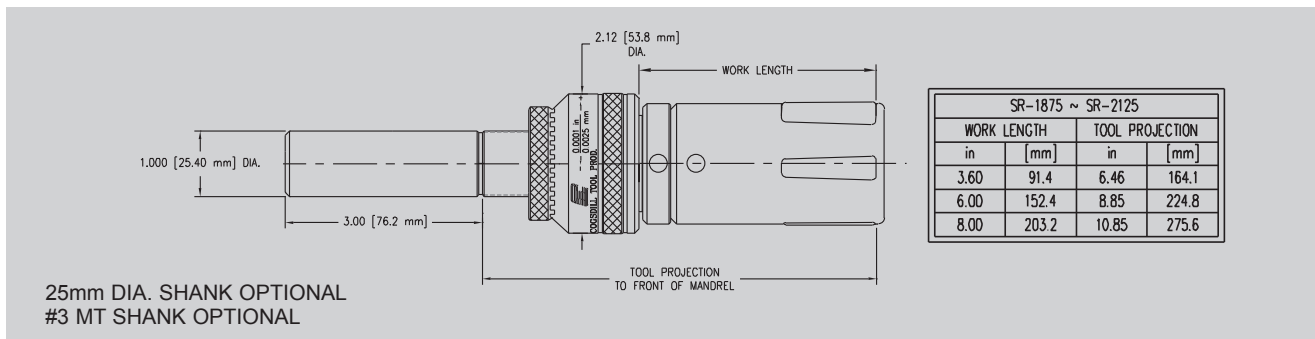
*Shanks other than shown above are available upon request.*

# Standard Tool specifications



## “SR” SERIES ROLL-A-FINISH® TOOLS 1-5/8 TO 1-7/8 IN (41.28 TO 47.63mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
1.621-1.662	41.17-42.21	SR-1625	SRH-1625	SRB-1625
1.652-1.693	41.96-43.00	SR-1656	SRH-1656	SRB-1656
1.684-1.725	42.77-43.82	SR-1688	SRH-1688	SRB-1688
1.715-1.756	43.56-44.60	SR-1719	SRH-1719	SRB-1719
1.746-1.787	44.35-45.39	SR-1750	SRH-1750	SRB-1750
1.777-1.818	45.14-46.18	SR-1781	SRH-1781	SRB-1781
1.808-1.849	45.92-46.96	SR-1812	SRH-1812	SRB-1812
1.840-1.881	46.74-47.78	SR-1844	SRH-1844	SRB-1844

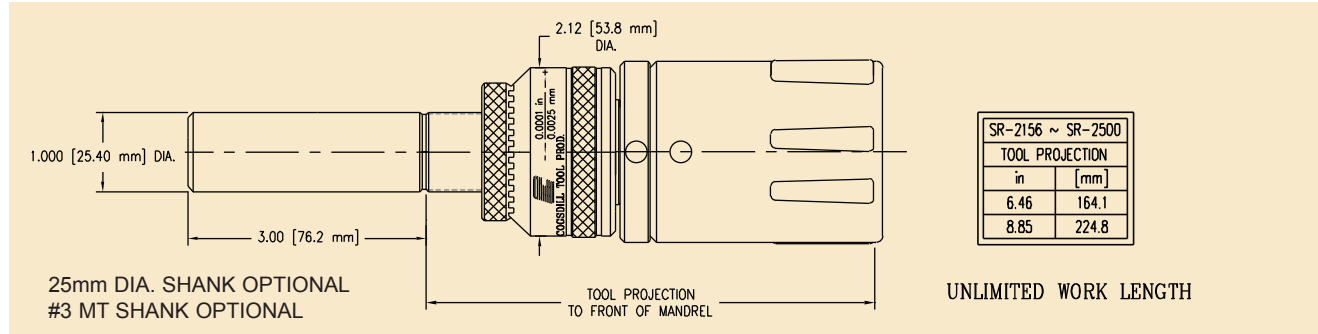


## “SR” SERIES ROLL-A-FINISH® TOOLS 1-7/8 TO 2-5/32 IN. (47.63 TO 54.76mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
1.871-1.912	47.52-48.56	SR-1875	SRH-1875	SRB-1875
1.902-1.943	48.31-49.35	SR-1906	SRH-1906	SRB-1906
1.934-1.975	49.12-50.17	SR-1938	SRH-1938	SRB-1938
1.965-2.006	49.91-50.95	SR-1969	SRH-1969	SRB-1969
1.996-2.037	50.70-51.74	SR-2000	SRH-2000	SRB-2000
2.027-2.068	51.49-52.53	SR-2031	SRH-2031	SRB-2031
2.058-2.099	52.27-53.31	SR-2062	SRH-2062	SRB-2062
2.090-2.131	53.09-54.13	SR-2094	SRH-2094	SRB-2094
2.121-2.162	53.87-54.91	SR-2125	SRH-2125	SRB-2125

Shanks other than shown above are available upon request.

# Standard Tool specifications



## “SR” SERIES ROLL-A-FINISH® TOOLS 2-5/32 to 2-1/2 in. (54.76 to 63.5mm)

DIAMETER RANGE		TOOL NUMBER		
INCHES	MM	THRU-HOLE (NO HELIX)	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
2.152-2.193	54.66-55.70	SR-2156	SRH-2156	SRB-2156
2.184-2.225	55.47-56.52	SR-2188	SRH-2188	SRB-2188
2.215-2.256	56.26-57.30	SR-2219	SRH-2219	SRB-2219
2.246-2.287	57.05-58.09	SR-2250	SRH-2250	SRB-2250
2.277-2.318	57.84-58.88	SR-2281	SRH-2281	SRB-2281
2.308-2.349	58.62-59.66	SR-2312	SRH-2312	SRB-2312
2.340-2.381	59.44-60.48	SR-2344	SRH-2344	SRB-2344
2.371-2.412	60.22-61.26	SR-2375	SRH-2375	SRB-2375
2.402-2.443	61.01-62.05	SR-2406	SRH-2406	SRB-2406
2.434-2.475	61.82-62.87	SR-2438	SRH-2438	SRB-2438
2.465-2.506	62.61-63.65	SR-2469	SRH-2469	SRB-2469
2.496-2.537	63.40-64.44	SR-2500	SRH-2500	SRB-2500

*Shanks other than shown above are available upon request.*



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Cogsdill Tool Products, Inc.

# Internal Roll-a-Finish<sup>®</sup> tools

## U series

*For hole diameters from 2.500 to 4.000 inches (63.5 to 101.6mm). Work length is unlimited; extension adapters can be used to increase work length.*



Offered in *two styles*:

- Through-hole style with helix cage (self-feeding)
- Bottoming-style for blind hole, with no-helix cage (machine-feeding)

... and *available from stock*.



Through-Hole (Helix)



Bottoming (No Helix)

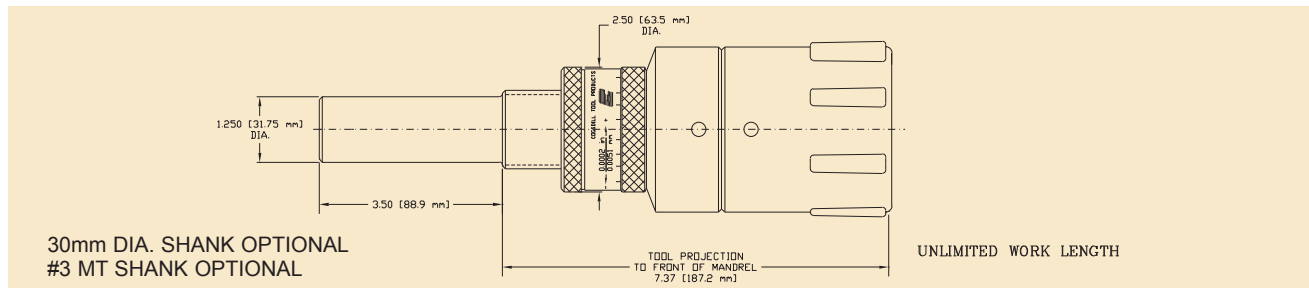
*Note: Also available from stock in through-hole, no-helix style.*



Sourcing Technology Globally

Internal Roll-a-Finish® tools U series

# Standard tool specifications



## “U” SERIES ROLL-A-FINISH® TOOLS 2-17/32 TO 4 IN. (64.3 TO 101.6 MM)

DIAMETER RANGE		TOOL NUMBER	
INCHES	MM	THRU-HOLE (HELIX)	BOTTOMING (NO HELIX)
2.527-2.568	64.19-65.23	U-2531	UB-2531
2.558-2.599	64.97-66.01	U-2562	UB-2562
2.590-2.631	65.79-66.83	U-2594	UB-2594
2.621-2.662	66.57-67.61	U-2625	UB-2625
2.652-2.693	67.36-68.40	U-2656	UB-2656
2.684-2.725	68.17-69.22	U-2688	UB-2688
2.715-2.756	68.96-70.00	U-2719	UB-2719
2.746-2.787	69.75-70.79	U-2750	UB-2750
2.777-2.818	70.54-71.58	U-2781	UB-2781
2.808-2.849	71.32-72.36	U-2812	UB-2812
2.840-2.881	72.14-73.18	U-2844	UB-2844
2.871-2.912	72.92-73.96	U-2875	UB-2875
2.902-2.943	73.71-74.75	U-2906	UB-2906
2.934-2.975	74.52-75.57	U-2938	UB-2938
2.965-3.006	75.31-76.35	U-2969	UB-2969
2.996-3.037	76.10-77.14	U-3000	UB-3000
3.027-3.068	76.89-77.93	U-3031	UB-3031
3.058-3.099	77.67-78.71	U-3062	UB-3062
3.090-3.131	78.49-79.53	U-3094	UB-3094
3.121-3.162	79.27-80.31	U-3125	UB-3125
3.152-3.193	80.06-81.10	U-3156	UB-3156
3.184-3.225	80.87-81.92	U-3188	UB-3188
3.215-3.256	81.66-82.70	U-3219	UB-3219
3.246-3.287	82.45-83.49	U-3250	UB-3250
3.277-3.318	83.24-84.28	U-3281	UB-3281
3.308-3.349	84.02-85.06	U-3312	UB-3312
3.340-3.381	84.84-85.88	U-3344	UB-3344
3.371-3.412	85.62-86.66	U-3375	UB-3375
3.402-3.443	86.41-87.45	U-3406	UB-3406
3.434-3.475	87.22-88.27	U-3438	UB-3438
3.465-3.506	88.01-89.05	U-3469	UB-3469
3.496-3.537	88.80-89.84	U-3500	UB-3500
3.527-3.568	89.59-90.63	U-3531	UB-3531
3.558-3.599	90.37-91.41	U-3562	UB-3562
3.590-3.631	91.19-92.23	U-3594	UB-3594
3.621-3.662	91.97-93.01	U-3625	UB-3625
3.652-3.693	92.76-93.80	U-3656	UB-3656
3.684-3.725	93.57-94.62	U-3688	UB-3688
3.715-3.756	94.36-95.40	U-3719	UB-3719
3.746-3.787	95.15-96.19	U-3750	UB-3750
3.777-3.818	95.94-96.98	U-3781	UB-3781
3.808-3.849	96.72-97.76	U-3812	UB-3812
3.840-3.881	97.54-98.58	U-3844	UB-3844
3.871-3.912	98.32-99.36	U-3875	UB-3875
3.902-3.943	99.11-100.15	U-3906	UB-3906
3.934-3.975	99.92-100.97	U-3938	UB-3938
3.965-4.006	100.71-101.75	U-3969	UB-3969
3.996-4.037	101.50-102.54	U-4000	UB-4000

Shanks other than shown above are available upon request.



## External Roll-a-Finish® tools

## AEX series

*For burnishing the outside diameter of cylindrical parts, such as shafts rotating in bushings or bearings. Provides an ideal surface for grease and oil seals.*



AEX-1

*Available from stock* for nominal diameters from .062 to 2.000 inches (1.57 to 50.8mm)

### *Offered in three styles:*

- **AEX-1**, with a smaller body diameter and shorter overall length suitable for screw machines and automatics. All AEX-1 tools are bottoming-style, designed for machine-feed. Available for nominal diameters from .062 to .625 inch (1.57 to 15.88mm).
- **AEX-2**, for nominal diameters from .062 to 1.000 inch (1.57 to 25.4mm). Features twice the work length as compared to the AEX-1. Available with machine-feeding cage or with bottoming-style cage.
- **AEX-3**, for nominal diameters from 1.000 to 2.000 inches (25.4 to 50.8mm). Available with machine-feeding cage or with bottoming-style cage.

AEX tools are adjustable in increments of .0001 inch (.002mm).

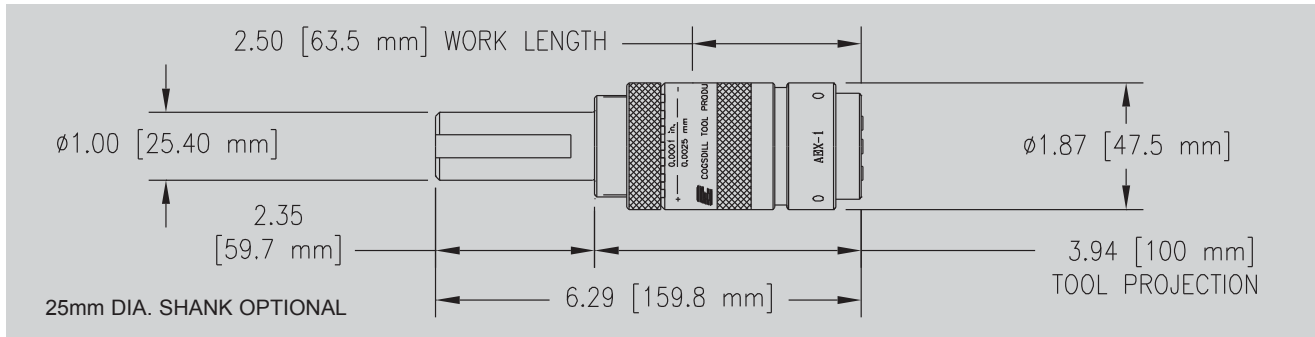


AEX-2



AEX-3

# Standard tool specifications

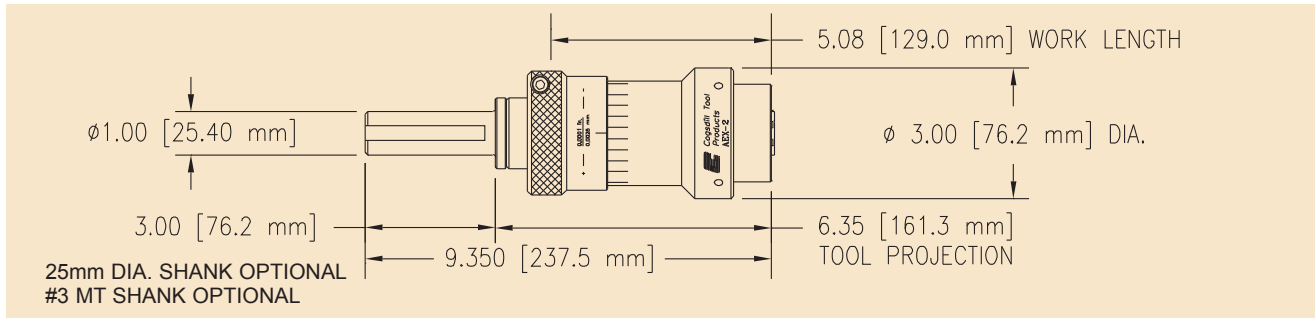


## “AEX-1” SERIES ROLL-A-FINISH® TOOLS .062 TO .625 IN. (1.57 TO 15.88 MM)

DIAMETER RANGE		TOOL NUMBER
INCHES	MM	BOTTOMING (NO HELIX)
.043-.064	1.09-1.63	AEX-1-062
.059-.080	1.50-2.03	AEX-1-078
.075-.096	1.91-2.44	AEX-1-094
.090-.111	2.29-2.82	AEX-1-109
.106-.127	2.69-3.23	AEX-1-125
.122-.143	3.10-3.63	AEX-1-141
.137-.158	3.48-4.01	AEX-1-156
.152-.173	3.86-4.39	AEX-1-171
.168-.189	4.27-4.80	AEX-1-187
.184-.205	4.67-5.21	AEX-1-203
.200-.221	5.08-5.61	AEX-1-219
.215-.236	5.46-5.99	AEX-1-234
.231-.252	5.87-6.40	AEX-1-250
.247-.268	6.27-6.81	AEX-1-266
.262-.283	6.65-7.19	AEX-1-281
.278-.299	7.06-7.59	AEX-1-297
.293-.314	7.44-7.98	AEX-1-312
.309-.330	7.85-8.38	AEX-1-328
.325-.346	8.26-8.79	AEX-1-344
.340-.361	8.64-9.17	AEX-1-359
.356-.377	9.04-9.58	AEX-1-375
.372-.393	9.49-9.98	AEX-1-391
.387-.408	9.83-10.36	AEX-1-406
.403-.424	10.24-10.77	AEX-1-422
.418-.439	10.62-11.15	AEX-1-438
.434-.455	11.02-11.56	AEX-1-453
.450-.471	11.43-11.96	AEX-1-469
.465-.486	11.81-12.34	AEX-1-484
.481-.502	12.22-12.75	AEX-1-500
.497-.518	12.62-13.16	AEX-1-516
.512-.533	13.00-13.54	AEX-1-531
.528-.549	13.41-13.94	AEX-1-547
.543-.564	13.79-14.33	AEX-1-562
.559-.580	14.20-14.73	AEX-1-578
.575-.596	14.61-15.14	AEX-1-594
.590-.611	14.99-15.52	AEX-1-609
.606-.627	15.39-15.93	AEX-1-625

*Shanks other than shown above are available upon request.*

# Standard tool specifications



## “AEX-2” SERIES ROLL-A-FINISH® TOOLS .062 TO 1.000 IN. (1.57 TO 25.4 MM)

DIAMETER RANGE		TOOL NUMBER	
INCHES	MM	MACHINE-FEED (NO HELIX)	BOTTOMING (NO HELIX)
.045-.066	1.14-1.68	AEX-2-062	AEXB-2-062
.061-.082	1.57-2.08	AEX-2-078	AEXB-2-078
.077-.098	1.96-2.49	AEX-2-094	AEXB-2-094
.092-.113	2.34-2.87	AEX-2-109	AEXB-2-109
.108-.129	2.74-3.28	AEX-2-125	AEXB-2-125
.124-.145	3.15-3.68	AEX-2-141	AEXB-2-141
.139-.160	3.53-4.06	AEX-2-156	AEXB-2-156
.154-.175	3.91-4.45	AEX-2-171	AEXB-2-171
.170-.191	4.32-4.85	AEX-2-187	AEXB-2-187
.186-.207	4.72-5.26	AEX-2-203	AEXB-2-203
.202-.223	5.13-5.66	AEX-2-219	AEXB-2-219
.217-.238	5.51-6.05	AEX-2-234	AEXB-2-234
.233-.254	5.92-6.45	AEX-2-250	AEXB-2-250
.249-.270	6.32-6.86	AEX-2-266	AEXB-2-266
.264-.285	6.71-7.24	AEX-2-281	AEXB-2-281
.280-.301	7.11-7.65	AEX-2-297	AEXB-2-297
.295-.316	7.49-8.03	AEX-2-312	AEXB-2-312
.311-.332	7.90-8.43	AEX-2-328	AEXB-2-328
.327-.348	8.31-8.84	AEX-2-344	AEXB-2-344
.342-.363	8.69-9.22	AEX-2-359	AEXB-2-359
.358-.379	9.09-9.63	AEX-2-375	AEXB-2-375
.374-.395	9.50-10.03	AEX-2-391	AEXB-2-391
.389-.410	9.88-10.41	AEX-2-406	AEXB-2-406
.405-.426	10.29-10.82	AEX-2-422	AEXB-2-422
.420-.441	10.67-11.20	AEX-2-438	AEXB-2-438
.436-.457	11.07-11.61	AEX-2-453	AEXB-2-453
.452-.473	11.48-12.01	AEX-2-469	AEXB-2-469
.467-.488	11.86-12.40	AEX-2-484	AEXB-2-484
.483-.504	12.27-12.80	AEX-2-500	AEXB-2-500
.499-.520	12.67-13.21	AEX-2-516	AEXB-2-516
.514-.535	13.06-13.59	AEX-2-531	AEXB-2-531
.530-.551	13.46-14.00	AEX-2-547	AEXB-2-547
.545-.566	13.84-14.38	AEX-2-562	AEXB-2-562
.561-.582	14.25-14.78	AEX-2-578	AEXB-2-578
.577-.598	14.66-15.19	AEX-2-594	AEXB-2-594
.592-.613	15.04-15.57	AEX-2-609	AEXB-2-609
.608-.629	15.44-15.98	AEX-2-625	AEXB-2-625
.624-.645	15.85-16.38	AEX-2-641	AEXB-2-641
.639-.660	16.23-16.76	AEX-2-656	AEXB-2-656
.655-.676	16.64-17.17	AEX-2-672	AEXB-2-672
.671-.692	17.04-17.58	AEX-2-688	AEXB-2-688
.686-.707	17.42-17.96	AEX-2-703	AEXB-2-703
.702-.723	17.83-18.36	AEX-2-719	AEXB-2-719
.717-.738	18.21-18.75	AEX-2-734	AEXB-2-734
.733-.754	18.62-19.15	AEX-2-750	AEXB-2-750
.749-.770	19.02-19.56	AEX-2-766	AEXB-2-766
.764-.785	19.41-19.94	AEX-2-781	AEXB-2-781
.780-.801	19.81-20.35	AEX-2-797	AEXB-2-797
.795-.816	20.19-20.73	AEX-2-812	AEXB-2-812
.811-.832	20.60-21.13	AEX-2-828	AEXB-2-828
.827-.848	21.00-21.54	AEX-2-844	AEXB-2-844
.842-.863	21.39-21.92	AEX-2-859	AEXB-2-859
.858-.879	21.79-22.33	AEX-2-875	AEXB-2-875
.874-.895	22.20-22.73	AEX-2-891	AEXB-2-891
.889-.910	22.58-23.11	AEX-2-906	AEXB-2-906
.905-.926	22.99-23.52	AEX-2-922	AEXB-2-922
.921-.942	23.39-23.93	AEX-2-938	AEXB-2-938
.936-.957	23.77-24.31	AEX-2-953	AEXB-2-953
.952-.973	24.18-24.71	AEX-2-969	AEXB-2-969
.967-.988	24.56-25.10	AEX-2-984	AEXB-2-984
.983-1.004	24.97-25.50	AEX-2-1000	AEXB-2-1000

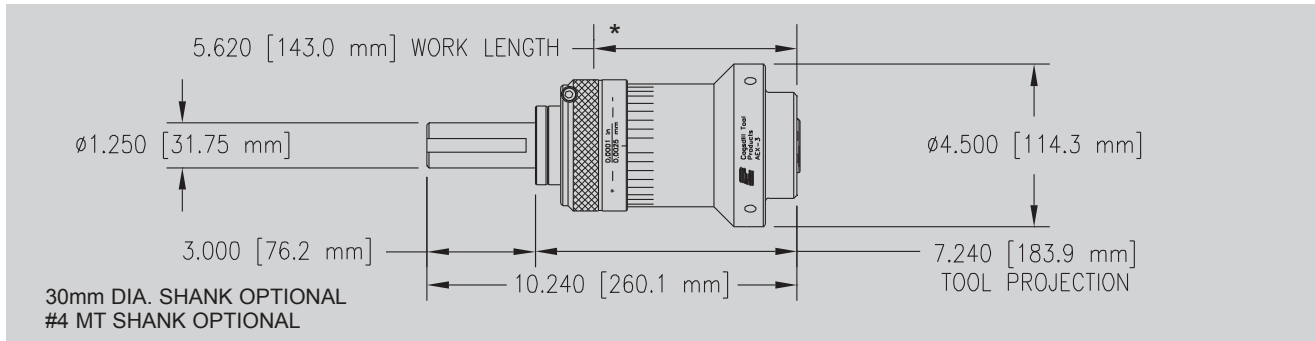
Shanks other than shown above are available upon request.



Sourcing Technology Globally

External Roll-a-Finish® tools **AEX series**

# Standard tool specifications



## “AEX-3” SERIES ROLL-A-FINISH®TOOLS 1.016 TO 2.000 IN. (25.8 TO 50.8 MM)

DIAMETER RANGE		TOOL NUMBER	
INCHES	MM	MACHINE-FEED (NO HELIX)	BOTTOMING (NO HELIX)
.999-1.020	25.37-25.91	AEX-3-1016	AEXB-3-1016
1.014-1.035	25.76-26.29	AEX-3-1031	AEXB-3-1031
1.030-1.051	26.16-26.70	AEX-3-1047	AEXB-3-1047
1.045-1.066	26.54-27.08	AEX-3-1062	AEXB-3-1062
1.061-1.082	26.95-27.48	AEX-3-1078	AEXB-3-1078
1.077-1.098	27.36-27.89	AEX-3-1094	AEXB-3-1094
1.092-1.113	27.74-28.27	AEX-3-1109	AEXB-3-1109
1.108-1.129	28.14-28.68	AEX-3-1125	AEXB-3-1125
1.124-1.145	28.55-29.08	AEX-3-1141	AEXB-3-1141
1.139-1.160	28.93-29.46	AEX-3-1156	AEXB-3-1156
1.155-1.176	29.34-29.87	AEX-3-1172	AEXB-3-1172
1.170-1.191	29.72-30.25	AEX-3-1188	AEXB-3-1188
1.186-1.207	30.12-30.66	AEX-3-1203	AEXB-3-1203
1.202-1.223	30.53-31.06	AEX-3-1219	AEXB-3-1219
1.217-1.238	30.91-31.45	AEX-3-1234	AEXB-3-1234
1.233-1.254	31.32-31.85	AEX-3-1250	AEXB-3-1250
1.249-1.270	31.72-32.26	AEX-3-1266	AEXB-3-1266
1.264-1.285	32.11-32.69	AEX-3-1281	AEXB-3-1281
1.280-1.301	32.51-33.05	AEX-3-1297	AEXB-3-1297
1.295-1.316	32.89-33.43	AEX-3-1312	AEXB-3-1312
1.311-1.332	33.30-33.83	AEX-3-1328	AEXB-3-1328
1.327-1.348	33.71-34.24	AEX-3-1344	AEXB-3-1344
1.342-1.363	34.09-34.62	AEX-3-1359	AEXB-3-1359
1.358-1.379	34.49-35.03	AEX-3-1375	AEXB-3-1375
1.374-1.395	34.90-35.43	AEX-3-1391	AEXB-3-1391
1.389-1.410	35.28-35.81	AEX-3-1406	AEXB-3-1406
1.405-1.426	35.69-36.22	AEX-3-1422	AEXB-3-1422
1.420-1.441	36.07-36.60	AEX-3-1438	AEXB-3-1438
1.436-1.457	36.47-37.01	AEX-3-1453	AEXB-3-1453
1.452-1.473	36.88-37.41	AEX-3-1469	AEXB-3-1469
1.467-1.488	37.26-37.80	AEX-3-1484	AEXB-3-1484
1.483-1.504	37.67-38.20	AEX-3-1500	AEXB-3-1500
1.499-1.520	38.07-38.61	AEX-3-1516	AEXB-3-1516
1.514-1.535	38.46-38.99	AEX-3-1531	AEXB-3-1531
1.530-1.551	38.86-39.40	AEX-3-1547	AEXB-3-1547
1.545-1.566	39.24-39.78	AEX-3-1562	AEXB-3-1562
1.561-1.582	39.65-40.18	AEX-3-1578	AEXB-3-1578
1.577-1.598	40.06-40.59	AEX-3-1594	AEXB-3-1594
1.592-1.613	40.44-40.97	AEX-3-1609	AEXB-3-1609
1.608-1.629	40.84-41.38	AEX-3-1625	AEXB-3-1625
1.619-1.660	41.12-42.16	AEX-3-1656	AEXB-3-1656
1.651-1.692	41.94-42.98	AEX-3-1688	AEXB-3-1688
1.682-1.723	42.72-43.76	AEX-3-1719	AEXB-3-1719
1.713-1.754	43.51-44.55	AEX-3-1750	AEXB-3-1750
1.744-1.785	44.30-45.34	AEX-3-1781	AEXB-3-1781
1.775-1.816	45.09-46.13	AEX-3-1812	AEXB-3-1812
1.807-1.848	45.90-46.94	AEX-3-1844	AEXB-3-1844
1.838-1.879	46.69-47.73	AEX-3-1875	AEXB-3-1875
1.869-1.910	47.47-48.51	AEX-3-1906	AEXB-3-1906
1.901-1.942	48.29-49.33	AEX-3-1938	AEXB-3-1938
1.932-1.973	49.07-50.11	AEX-3-1969	AEXB-3-1969
1.963-2.004	49.86-50.90	AEX-3-2000	AEXB-3-2000

\*Work length for nominal sizes from AEX-3-1719 through AEX-3-2000 is 3.938 in.(100mm).

Shanks other than shown above are available upon request.



**COGSDILL TOOL PRODUCTS, INC.**

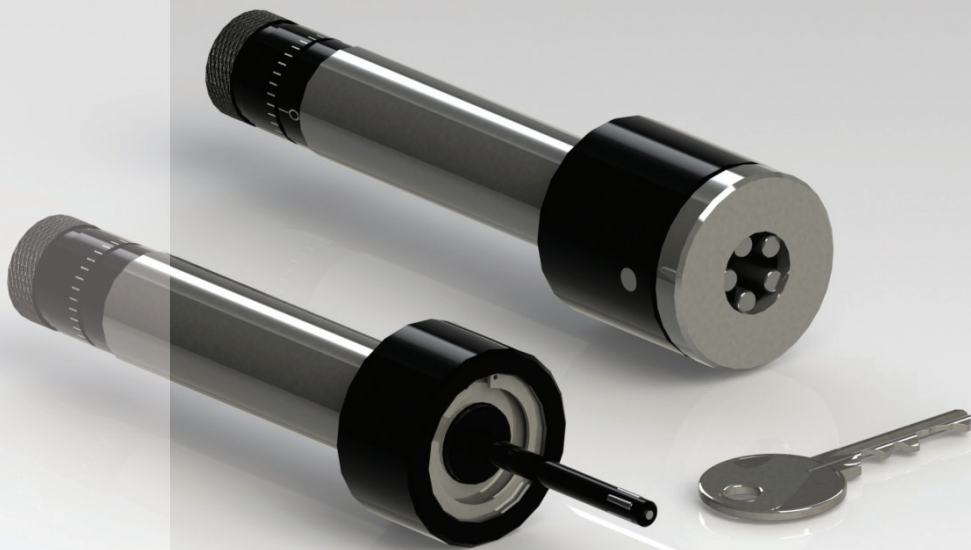


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# MRRBT

■ **Micro Roller  
Burnishing TOOLS**

Micro Roller Burnishing

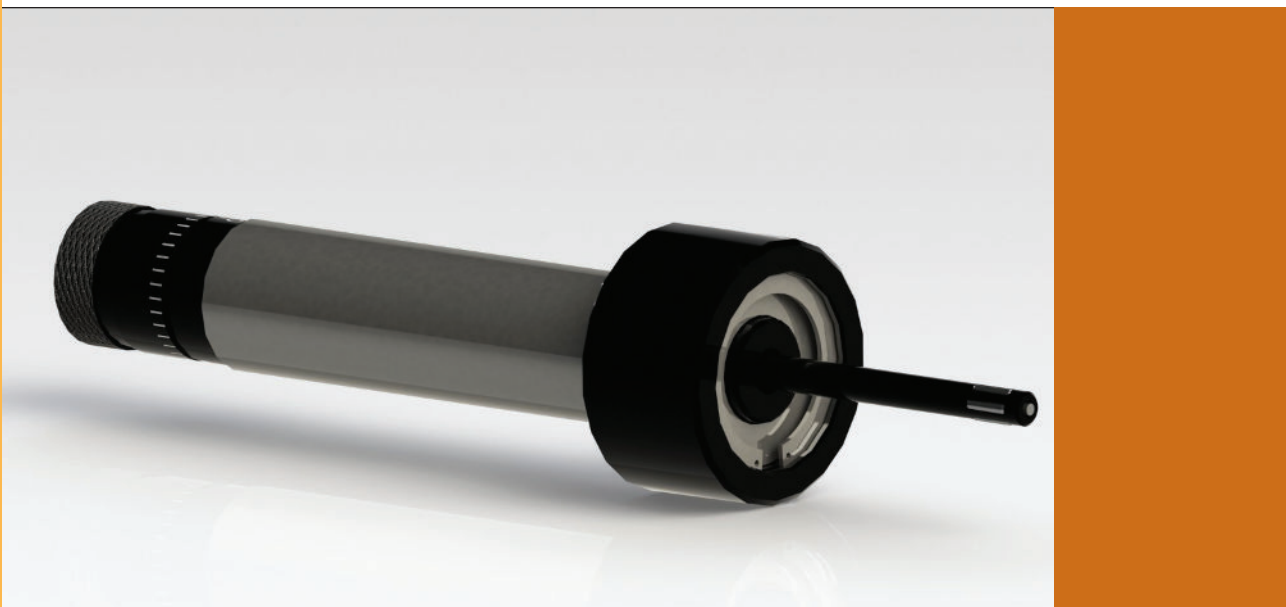


- ▶ Compact design for use where limited space is available on multi-spindle automatic and screw type machines.
- ▶ Internal tools from 0.187–0.501 inch (4.75–12.73mm) in thru style, and bottoming style larger than 0.246 inch (6.25mm).
- ▶ External tools from 0.054–0.254 inch (1.37–6.45mm) in bottoming style.
- ▶ Unique rear adjustment mechanism.

# Internal Micro Roller Burnishing Tool

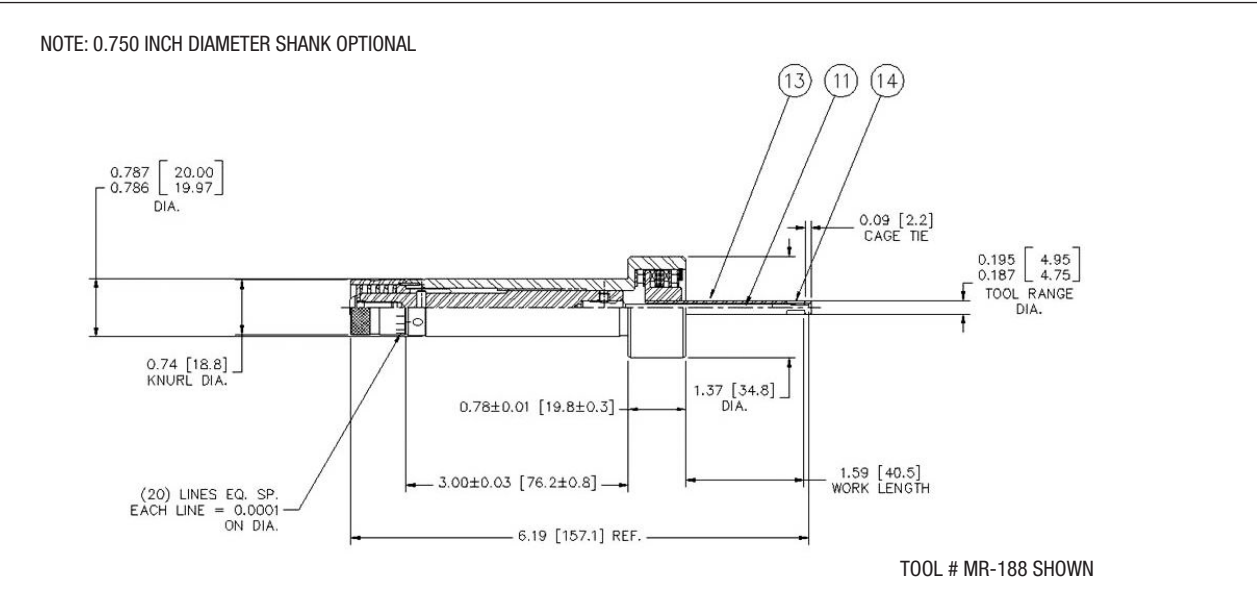


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	NOMINAL SIZE	DIAMETER RANGE		THRU ( NO HELIX)	BOTTOMING ( NO HELIX)		
		INCHES	MM				
	0.188	0.187	0.195	4.75	4.95	MR-188	–
	0.195	0.194	0.202	4.93	5.13	MR-195	–
	0.203	0.202	0.210	5.13	5.33	MR-203	–
	0.211	0.210	0.218	5.33	5.54	MR-211	–
	0.219	0.218	0.226	5.54	5.74	MR-219	–
	0.226	0.225	0.233	5.72	5.92	MR-226	–
	0.234	0.233	0.241	5.92	6.12	MR-234	–
	0.242	0.241	0.249	6.12	6.32	MR-242	–
	0.250	0.246	0.267	6.25	6.78	MR-250	MRB-250
	0.266	0.262	0.283	6.65	7.19	MR-266	MRB-266
	0.281	0.277	0.298	7.04	7.57	MR-281	MRB-281
	0.297	0.293	0.314	7.44	7.98	MR-297	MRB-297
	0.312	0.308	0.329	7.82	8.36	MR-312	MRB-312
	0.328	0.324	0.345	8.23	8.76	MR-328	MRB-328
	0.344	0.340	0.361	8.64	9.17	MR-344	MRB-344
	0.359	0.355	0.376	9.02	9.55	MR-359	MRB-359
	0.375	0.371	0.392	9.42	9.96	MR-375	MRB-375
	0.391	0.387	0.408	9.83	10.36	MR-391	MRB-391
	0.406	0.402	0.423	10.21	10.74	MR-406	MRB-406
	0.422	0.418	0.439	10.62	11.15	MR-422	MRB-422
	0.438	0.434	0.455	11.02	11.56	MR-438	MRB-438
	0.453	0.449	0.470	11.40	11.94	MR-453	MRB-453
	0.469	0.465	0.486	11.81	12.34	MR-469	MRB-469
	0.484	0.480	0.501	12.19	12.73	MR-484	MRB-484

# Internal Micro Roller Burnishing Tool



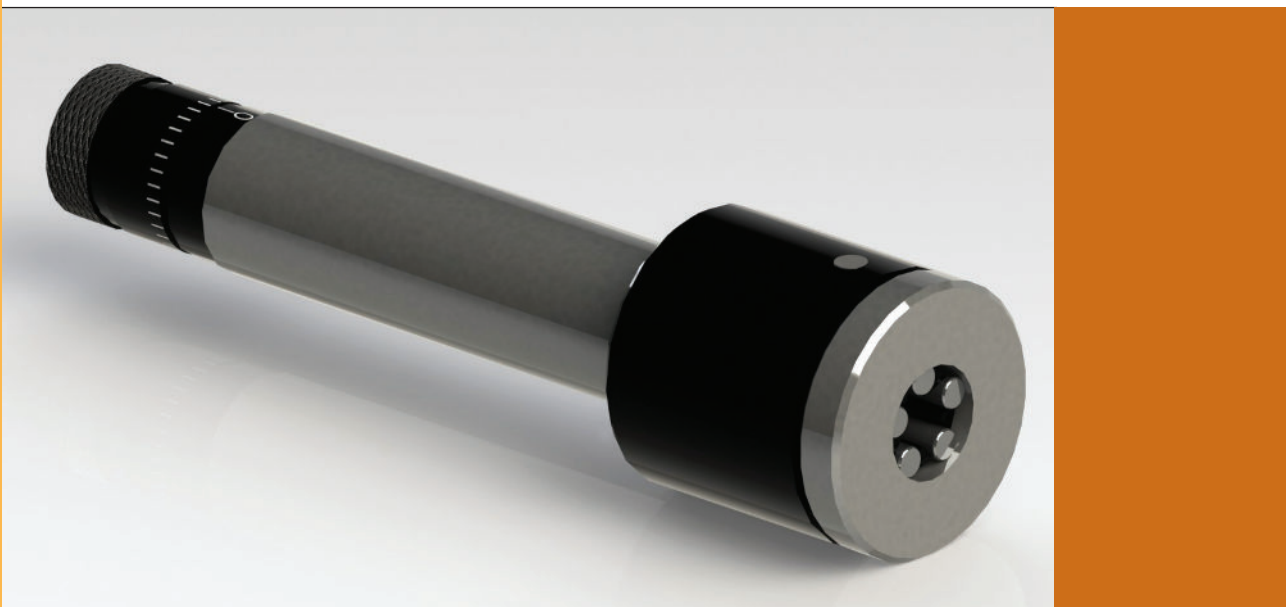
SIZE	DETAIL NO. 11 MANDREL	DETAIL NO. 13 CAGE	DETAIL NO. 14 ROLLS	QUANTITY REQUIRED
MR-188	MR-188-D11	MR-188-D13	SR-187	3
MR-195	MR-195-D11	MR-195-D13	"	"
MR-203	MR-203-D11	MR-203-D13	"	"
MR-211	MR-211-D11	MR-211-D13	"	"
MR-219	MR-219-D11	MR-219-D13	"	"
MR-226	MR-226-D11	MR-226-D13	"	"
MR-234	MR-234-D11	MR-234-D13	"	"
MR-242	MR-242-D11	MR-242-D13	"	"
MR-250	MR-250-D11	MR-250-D13	SR-250	5
MR-266	MR-266-D11	MR-266-D13	"	"
MR-281	MR-281-D11	MR-281-D13	"	"
MR-297	MR-297-D11	MR-297-D13	"	"
MR-312	MR-312-D11	MR-312-D13	SR-312	"
MR-328	MR-328-D11	MR-328-D13	"	"
MR-344	MR-344-D11	MR-344-D13	"	"
MR-359	MR-359-D11	MR-359-D13	"	"
MR-375	MR-375-D11	MR-375-D13	SR-375	"
MR-391	MR-391-D11	MR-391-D13	"	"
MR-406	MR-406-D11	MR-406-D13	SR-438	"
MR-422	MR-422-D11	MR-422-D13	"	"
MR-438	MR-438-D11	MR-438-D13	"	"
MR-453	MR-453-D11	MR-453-D13	"	"
MR-469	MR-469-D11	MR-469-D13	"	"
MR-484	MR-484-D11	MR-484-D13	"	"

- Notes:
- For bottoming cage, use prefix MRB. Only for tools larger than 0.246 inch (6.25mm).
  - For bottoming rolls, use prefix SRB. Only for tools larger than 0.246 inch (6.25mm).

# External Micro Roller Burnishing Tool



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	NOMINAL SIZE	DIAMETER RANGE				BOTTOMING ( NO HELIX)
		INCHES		MM		
	0.062	0.054	0.066	1.37	1.68	EMR-062
	0.070	0.062	0.074	1.57	1.88	EMR-070
	0.078	0.070	0.082	1.78	2.08	EMR-078
	0.086	0.078	0.090	1.98	2.29	EMR-086
	0.094	0.086	0.098	2.18	2.49	EMR-094
	0.102	0.094	0.106	2.39	2.69	EMR-102
	0.111	0.103	0.115	2.62	2.92	EMR-111
	0.117	0.109	0.121	2.77	3.07	EMR-117
	0.125	0.117	0.129	2.97	3.28	EMR-125
	0.133	0.125	0.137	3.18	3.48	EMR-133
	0.141	0.133	0.145	3.38	3.68	EMR-141
	0.149	0.141	0.153	3.58	3.89	EMR-149
	0.156	0.148	0.160	3.76	4.06	EMR-156
	0.164	0.156	0.168	3.96	4.27	EMR-164
	0.171	0.163	0.175	4.14	4.45	EMR-171
	0.180	0.172	0.184	4.37	4.67	EMR-180
	0.187	0.179	0.191	4.55	4.85	EMR-187
	0.195	0.187	0.199	4.75	5.05	EMR-195
	0.203	0.195	0.207	4.95	5.26	EMR-203
	0.211	0.203	0.215	5.16	5.46	EMR-211
	0.219	0.211	0.223	5.36	5.66	EMR-219
	0.227	0.219	0.231	5.56	5.87	EMR-227
	0.234	0.226	0.238	5.74	6.05	EMR-234
	0.242	0.234	0.246	5.94	6.25	EMR-242
	0.250	0.242	0.254	6.15	6.45	EMR-250

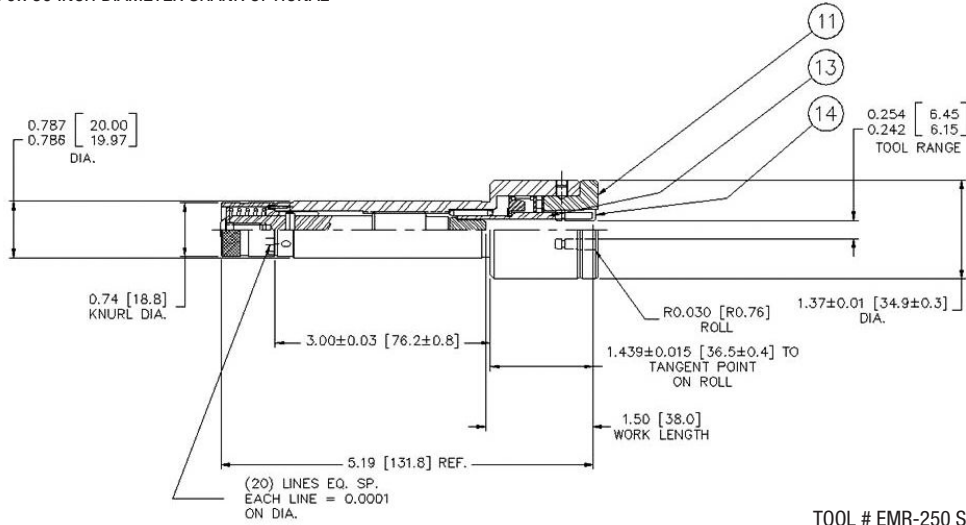


# External Micro Roller Burnishing Tool



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NOTE: 0.750 INCH DIAMETER SHANK OPTIONAL



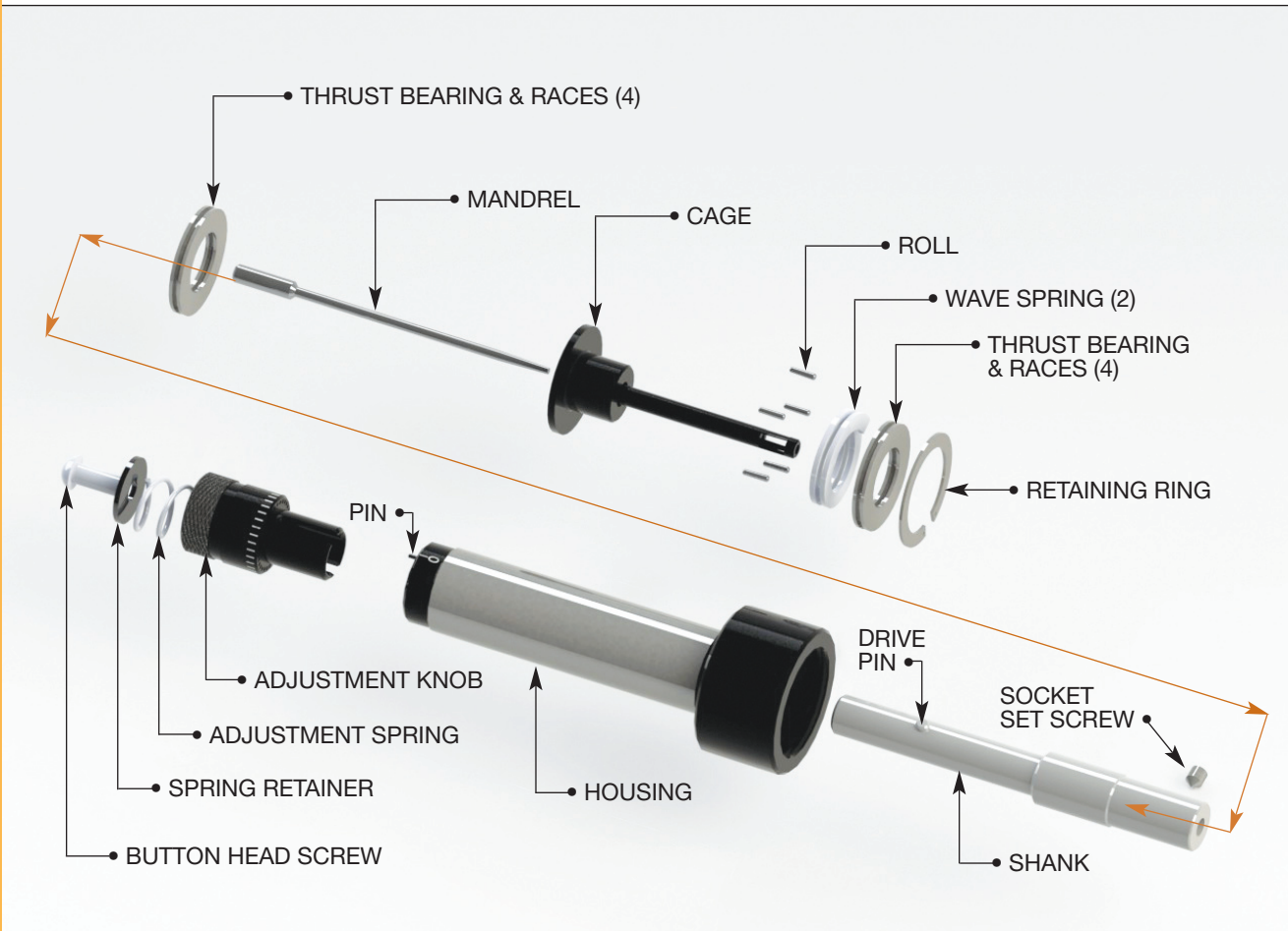
TOOL # EMR-250 SHOWN

SIZE	DETAIL NO. 11 RACE	DETAIL NO. 13 CAGE	DETAIL NO. 14 ROLLS	QUANTITY REQUIRED
EMR-062	EMR-062-D11	EMR-062-D13	B-500	3
EMR-070	EMR-070-D11	EMR-070-D13	"	3
EMR-078	EMR-078-D11	EMR-078-D13	"	3
EMR-086	EMR-086-D11	EMR-086-D13	"	3
EMR-094	EMR-094-D11	EMR-094-D13	"	3
EMR-102	EMR-102-D11	EMR-102-D13	"	3
EMR-111	EMR-111-D11	EMR-111-D13	"	3
EMR-117	EMR-117-D11	EMR-117-D13	"	3
EMR-125	EMR-125-D11	EMR-125-D13	"	3
EMR-133	EMR-133-D11	EMR-133-D13	"	3
EMR-141	EMR-141-D11	EMR-141-D13	"	3
EMR-149	EMR-149-D11	EMR-149-D13	"	3
EMR-156	EMR-156-D11	EMR-156-D13	"	3
EMR-164	EMR-164-D11	EMR-164-D13	"	3
EMR-171	EMR-171-D11	EMR-171-D13	"	3
EMR-180	EMR-180-D11	EMR-180-D13	"	3
EMR-187	EMR-187-D11	EMR-187-D13	"	3
EMR-195	EMR-195-D11	EMR-195-D13	"	3
EMR-203	EMR-203-D11	EMR-203-D13	"	3
EMR-211	EMR-211-D11	EMR-211-D13	"	3
EMR-219	EMR-219-D11	EMR-219-D13	"	3
EMR-227	EMR-227-D11	EMR-227-D13	"	3
EMR-234	EMR-234-D11	EMR-234-D13	"	3
EMR-242	EMR-242-D11	EMR-242-D13	"	3
EMR-250	EMR-250-D11	EMR-250-D13	"	5

# Internal Micro Roller Burnishing Tool



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## ASSEMBLY/DISASSEMBLY FOR CHANGING ROLLS, MANDREL & CAGE

- **To replace Cage and/or Rolls**, remove carefully the Retaining Ring at the front of the Housing. Note that this area is under spring pressure. Remove all of the components from over the Mandrel.
- Inspect all components.
- Clean and lubricate all components.
- Replace Rolls and Cage if required. Note that Rolls should be replaced as a complete set.
- Re-assemble and check tool adjustment.

- **To replace Mandrel and/or Rolls**, pull Adjustment Knob away from the Housing and unscrew the Adjustment Knob to remove the Shank and Mandrel from the Housing. Loosen the Socket Set Screw in the Shank to remove the Mandrel.

▶ **ASSEMBLY/DISASSEMBLY TIP:** As the Rolls are small and easy to lose, it is suggested to wrap a clear plastic tape around the roll pocket area of the cage. This will retain the Rolls in the Cage and can also be used as an aid when assembling Rolls back into the Cage.

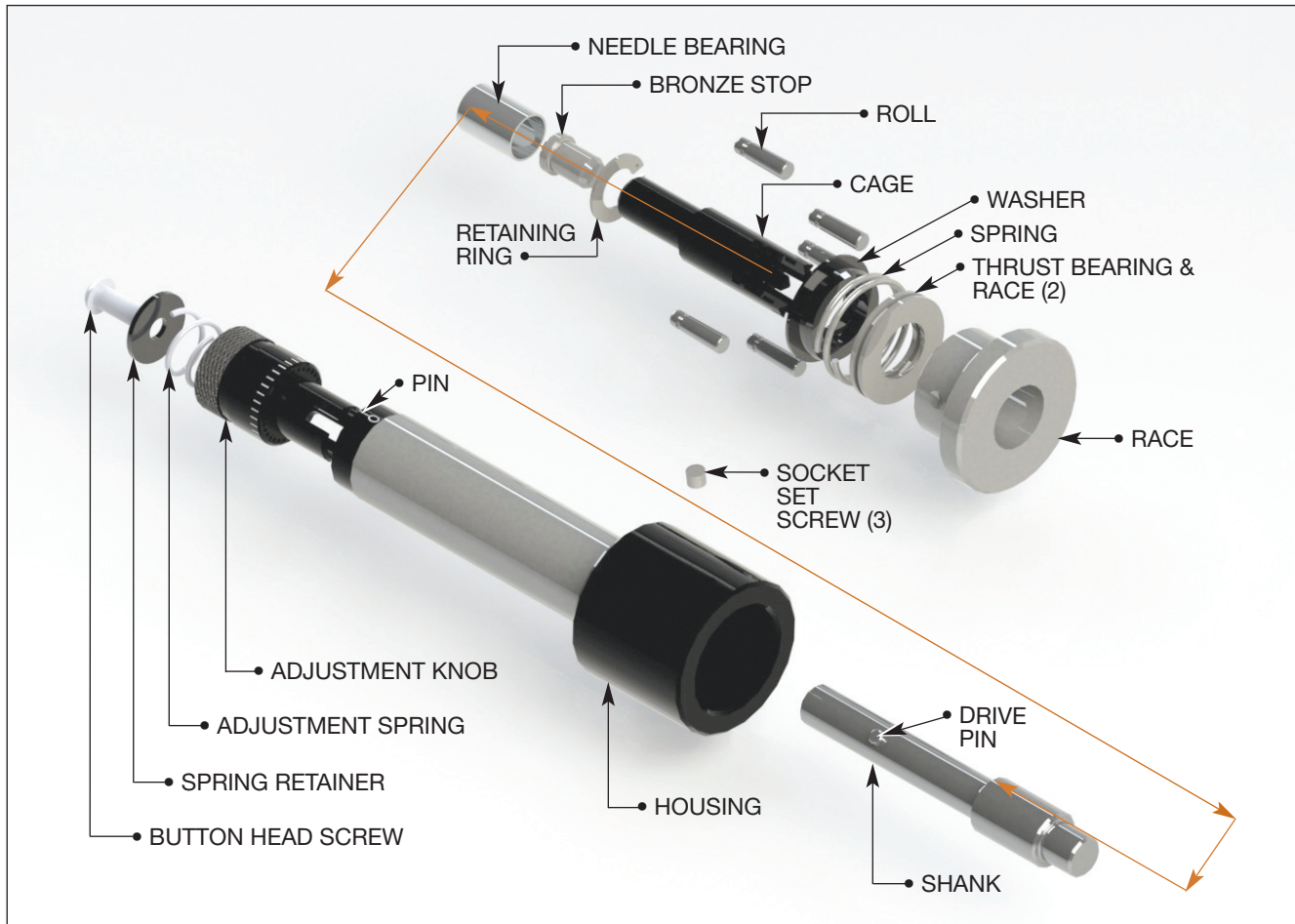
- The Rolls will be free to be removed from the Cage at this time.
- Inspect all components.
- Replace Rolls and Mandrel if required. Note that Rolls should be replaced as a set.
- Re-assemble and check tool adjustment.

**Refer to the Burnishing Tools & Machines catalog for part preparation and operating parameters, including speed and feed recommendations and coolant requirements.**

# External Micro Roller Burnishing Tool



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## ASSEMBLY/DISASSEMBLY FOR CHANGING ROLLS, RACE & CAGE

- Loosen the three Socket Set Screws in the Housing to allow removal of the complete Race Assembly.
- Inspect all components.
- Clean and lubricate all components.
- Replace Rolls, Race and Cage if required. Note that Rolls should be replaced as a complete set.
- Re-assemble and check tool adjustment.

## TOOL ADJUSTMENT – INTERNAL & EXTERNAL



- Adjustment is made from the back end of the tool.
- Adjustment Knob has 20 equally spaced lines that represent an adjustment of 0.0001 inch (0.0025mm) on the diameter.
- Pull Adjustment Knob away from the Housing to disengage the Pin in the Housing from the Adjustment Knob.
- Turn Adjustment Knob as required to adjust the Burnishing tool diameter.
- Release the spring loaded Adjustment Knob to engage the Pin in the Housing.
- Check and make further adjustments as required.

