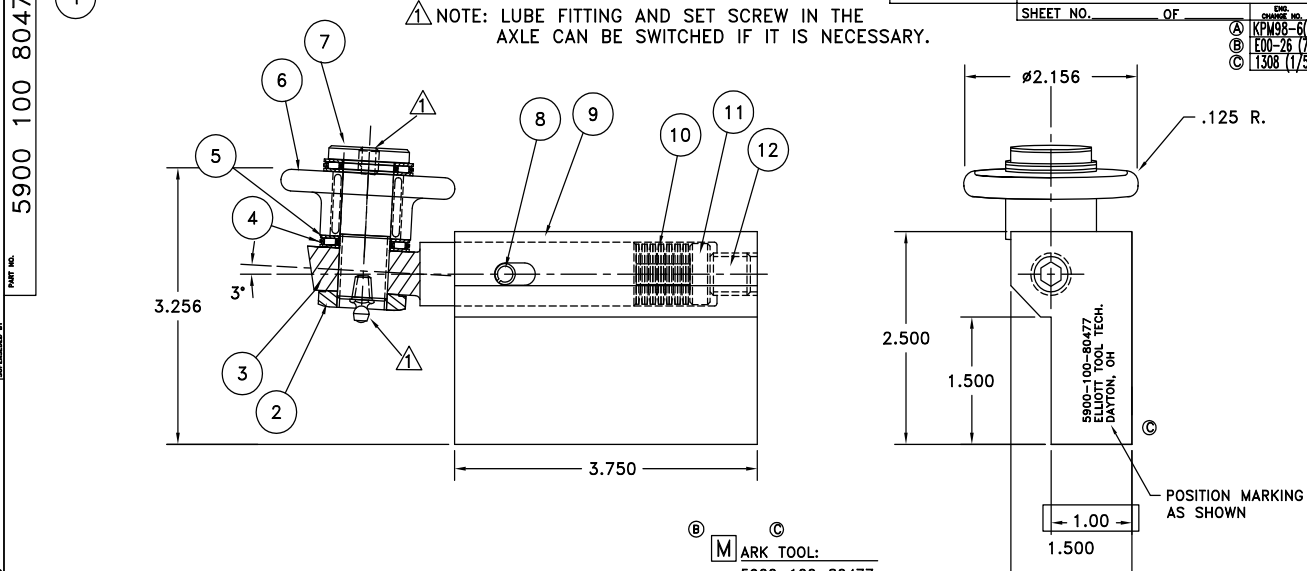


# Spherical Carbide Burnishing Tools

5900 100 80477  
 PART NO.

USED ON: \_\_\_\_\_ PART NO. 5900 100 80477  
 SHEET NO. \_\_\_\_\_ OF \_\_\_\_\_  
 DATE: \_\_\_\_\_  
 CHANGE NO. \_\_\_\_\_  
 (A) KPM98-6(4/2)  
 (B) E00-26 (7-13)  
 (C) 1308 (1/5/11)

⚠ NOTE: LUBE FITTING AND SET SCREW IN THE AXLE CAN BE SWITCHED IF IT IS NECESSARY.




QTY	PART NAME	PART NUMBER	REQ.
13	CASE	S2300C	1
12	SET SCREW	128B	1
11	SLUG	ED18	1
10	BELLEVILLE SPRINGS	579-44	13
9	TOOL HOLDER	S2075D13	1
8	SPRING PIN	P8386-24	1
7	AXLE	S2075D10	1
6	ROLL	5900 700 80282	1
5	THRUST BEARING	P1067-1	2
4	THRUST RACE	P1067B	4
3	SHANK	S2075D3	1
2	LOCK NUT	PC76-0050818	1
1	ASSEMBLY	5900 100 80477	~

(M) MARK TOOL:  
 5900-100-80477  
 ELLIOTT TOOL TECH.  
 DAYTON, OH

(C) INSPECT THE BOXED DIMENSION

NOTE:  
 BELLEVILLE SPRINGS DET.10 TO  
 BE STACKED IN SERIES.

DET. 10	
DEFLECTION	FORCE
.064(1.62)	65 LBS
.127(3.22)	119 LBS
.191(4.85)	165 LBS
.250(6.35)	208 LBS



THE DRAWING CONTAINS INFORMATION OF A PROPRIETARY NATURE AND IS INTENDED FOR  
 INTERNAL USE ONLY AND NOT BE REPRODUCED OR USED TO REPRODUCE  
 WITHOUT EXPRESS WRITTEN PERMISSION.

NAME: SPECIAL MONAGHAN CARBIDE ROLL TOOL  
 DR. BY: KPM 12-18-96  
 SCALE: NONE  
 PART NO. 5900 100 80477

Cutting tool operation: 4000 RPM  
 Feed rate: .010" IPR  
 Pre-burnish finish: 80 Ra

Burnish from front of ball to stem.

Burnishing: 2000 RPM  
 Feed rate: .003"/.004" IPR  
 Surface finish after burnishing: 4 to 8 Ra

For spring pressure, tighten set screw (detail 12) to fully compress the springs. Then, back the screw off a quarter turn. Touch off then press into the part .005"/.010". Feed across surface.

This is a typical set up for burnishing a ball stud. Adjustments to the burnishing feed rate and the spring pressure may be required.

