

Skive - Burnishing Tools

Type CSX, CX

For hydraulic cylinders, tubes and inner surfaces



CSX Type Combined Skive - Burnishing Tools

Combined Skive -Burnishing Tools skive and burnish the internal surface of the cylinders in one pass. These tools provide low cost working and environment friendly. Tools are developed for processing the internal surface of the tubes in a little while. Combined Skive-Burnishing Tools are designed for the aim of burnishing after skiving process of seamless and welded cold drawn precision tubes (contain welded and drawn DOM Tubes, seamless cold drawn DIN EN 10305-1 Tubes or hot drawn steel tubes).

While skiving head skive the internal surface of the cylinder in exact size and in desired way, roller head which follow the operation from behind burnish the tube. The skiving and burnishing operation which occur at the same time provide very short process time. While providing precision measurement and low surface roughness, this process increase surface hardness too. Thus, cylinders which have more slippery and more strength surfaces according to honed cylinder, can be obtained.

Skive-Burnishing Tools can use on Tube Skive-Burnishing Machine or Special Deep Drilling Machine, which has BTA System.

Automatic Knife Closing System

There is available an automatic knife closing system on the tools. This system automatically discharge by pulling back the skiving knife and roller head after finish the process. So the tool withdraw without giving any damage to the machined surface. Thus, do not need to assemble and disassemble after every cylinder process. This, beside of extra time saving it provides otomation and process convenience.



CX Type Skiving Tools

CX Type Skiving Tools machine seamless and welded Precision steel cylinders with CDX Type roller burnishing tools in two different operation.

In first operation, CX skiving head skive the cylinder; in the second operation, CDX tool roller burnish the surface. So the operation is completed in two pass. Depending upon cylinder, end of the process H8 or H9 diameter allowance and also the surface quality of $Rz < 1 \mu\text{m}$ ($Ra < 0,2 \mu\text{m}$) are obtained.

Samples of application

- Hydraulic and pneumatic cylinders
- Telescopic cylinders
- ST52 or ST35 stainless steel tubes
- Welded precision tube (ST37)
- Stainless cold drawn DIN EN 10305-1 Tubes or hot drawn steel tubes
- Welded and drawn DOM Tubes
- DIN SHE 1020
- DIN SHE 1026 and USA Material

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