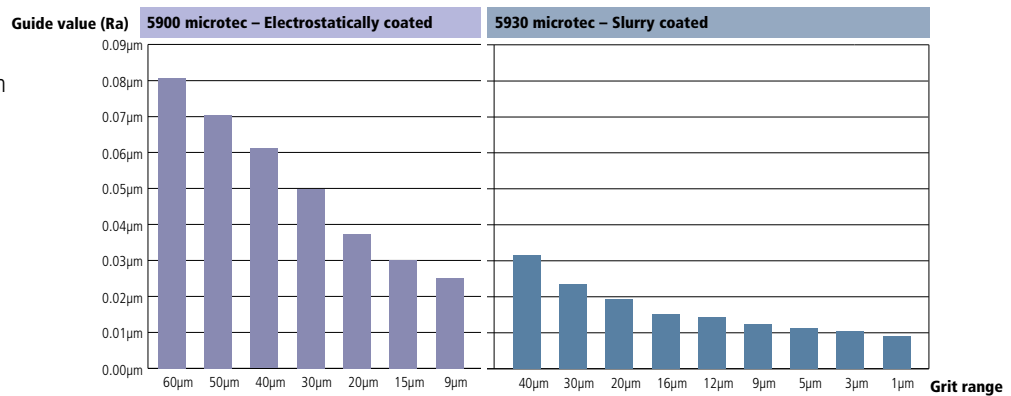


## Surface roughness according to use

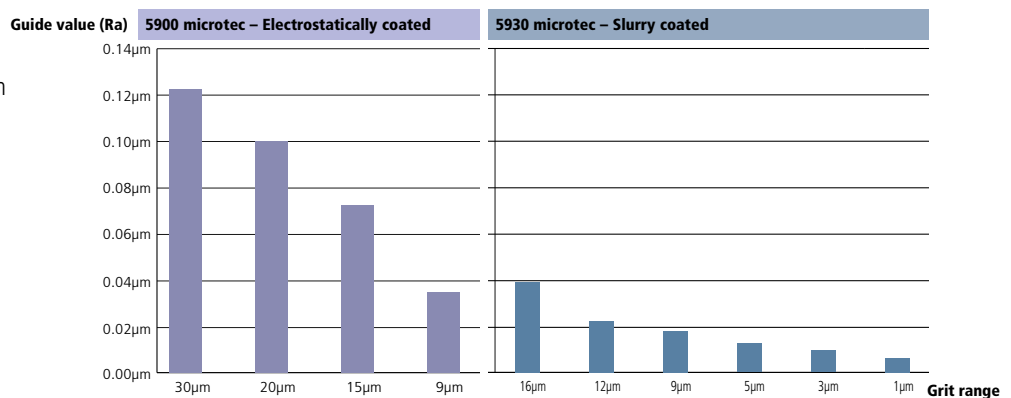
### Chrome roller

Dimensions: Ø 40 mm x 250 mm length  
 Cutting speed: 12 cm/min  
 Speed: 550 rpm  
 Axial feed: 2.5 m/min  
 Transitions: 2 x 2  
 Contact roller: rubber, 65ShA  
 Oscillation: 30 Hz  
 Contact pressure: 3 bar



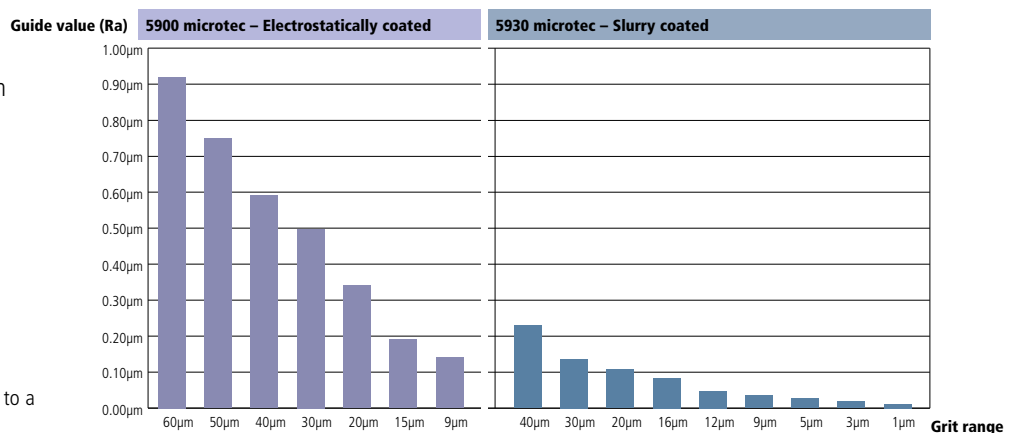
### Hard chrome roller

Dimensions: Ø 34 mm x 250 mm length  
 Cutting speed: 12 cm/min  
 Speed: 550 rpm  
 Axial feed: 2.5 m/min  
 Transitions: 2 x 2  
 Contact roller: rubber, 65ShA  
 Oscillation: 30 Hz  
 Contact pressure: 4 bar



### Copper roller

Dimensions: Ø 40 mm x 250 mm length  
 Cutting speed: 12 cm/min  
 Speed: 550 rpm  
 Axial feed: 2.5 m/min  
 Transitions: 2 x 2  
 Contact roller: rubber, 65ShA  
 Oscillation: 30 Hz  
 Contact pressure: 3 bar



All values were obtained using the specified parameters and to a large extent depend on the workpieces and settings used.

### Tungsten roller

Dimensions: Ø 40 mm x 250 mm length  
 Cutting speed: 6.5 cm/min  
 Speed: 550 rpm  
 Axial feed: 2.5 m/min  
 Transitions: 2 x 2  
 Contact roller: rubber, 65ShA  
 Oscillation: 30 Hz  
 Contact pressure: 3.5 bar

