



## Skive and Roller Burnishing

Skiving in itself is a process used to remove stock where close tolerances and roundness are required. Skiving produces a surface finish of approximately 60 to 125 micro-inches CLA. The depth of cut can range from as little as 0.002 inch per side and as much as 0.040 inch per side depending on the size of the tool. Skiving also produces optimal peak and valley patterns for subsequent roller burnishing.



Commercial Fluid Power can provide material in various skived and skived and rolled conditions. Skived Only condition. The Skived Only condition is often used to remove excess stock prior to welding. This can be used to reduce the amount of honing stock for finishing after the welding operations.

Roller Burnishing can follow the Skive operation or be done at the same time. The burnishing operation employs rollers which causes material to flow from the "peaks" into the "valleys". The burnishing process produces a more condensed and refined surface finish which reduces seal friction and surface porosity.

## Skive and Skive and Roller Advantages:

- 1.) Reduce the amount of finishing stock required after welding
- 2.) After Rolling the surface hardness can increase up to 10 Points HRC
- 3.) A Skived & Roller Burnished surface compared with a honed finish with the same micro finish will provide a slightly better seal life.
- 4.) Consistent size end for end.

Call the Commercial Fluid Power to discuss how skiving or skive and roller burnishing can help with your material requirements.

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