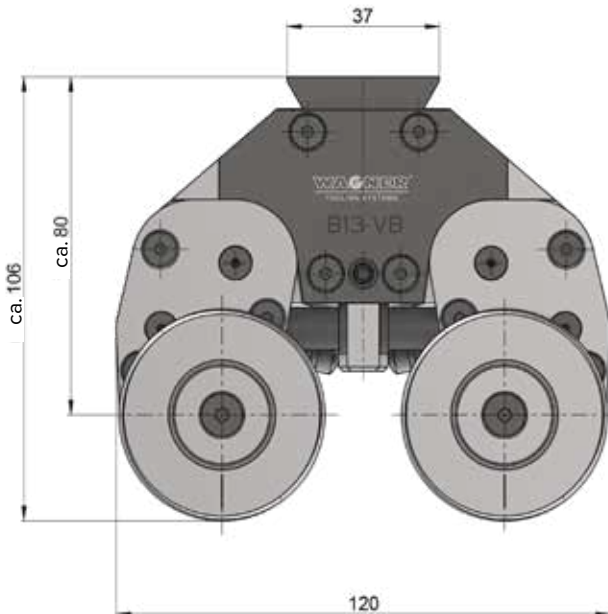




Tangential rolling system B13-VB



Tangential rolling system B13-VB

Weight of tool with rolls	4.5 kg
Weight of adapter	approx. 2.0 kg
Max. feed force	4000 N

	mm	inch
Standard thread Ø	3–10	0.12–0.375
Fine thread Ø	3–24	0.12–0.9375
Max. thread length (minus 2 × thread pitch)	17	0.67

Required Accessories

- Adapter machine-specific
- Micrometer setting gauge (standard)
- Thread specific setting gauge (optional)

Application parameters

Please note that this information represents standard values which must be adapted to the individual cases.

Rolling speed	30–80 m/min
Lubrication	emulsion or oil; filtration of the lubricant (< 40 µm) can improve the surface quality and the tool life

Example Thread M12

Thread length	16 mm
Material	3.4365
Rolling speed	50 m/min
Spindle speed	1500 r.p.m.
Feed	0.22 mm
Machining time	1.3 sec.
Lubrication	Emulsion

Micrometer setting gauge:

