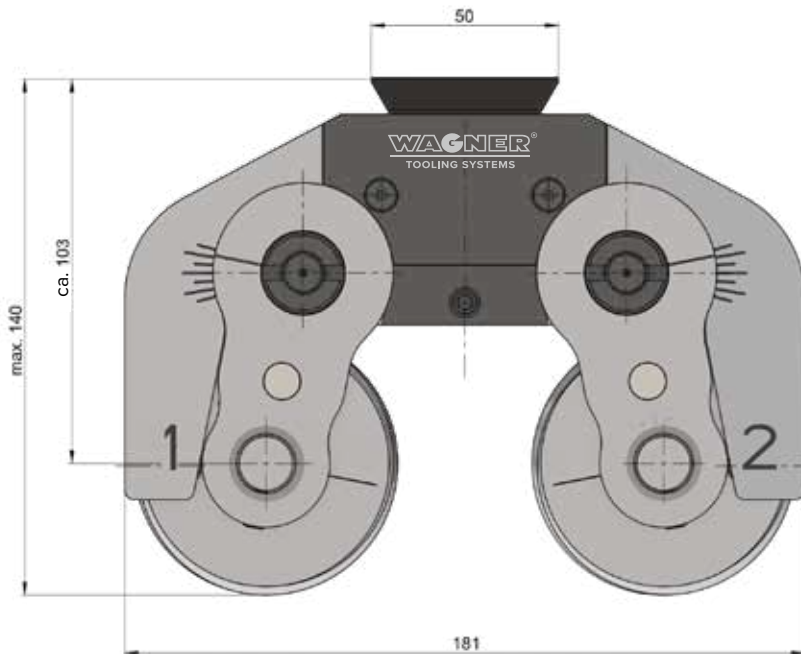




Tangential rolling systems B19 and B19-F



* With rolls DR1: 34,6 mm

Tangential rolling systems B19 and B19-F

Weight of tool with rolls	7.5 kg
Weight of adapter	approx. 3 kg
Max. feed force	9800 N

	mm	inch
Standard thread Ø	8–27	0.3125–1
Fine thread Ø	8–52	0.3125–2
Max. thread length (minus 2 × thread pitch)	31	1.22
Clearance from roll to tool edge	16.5	0.65

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 M48 × 2

Thread length	14 mm
Material	1.7225
Rolling speed	40 m/min
Spindle speed	270 r.p.m.
Feed	0.25 mm
Machining time	4.5 sec.
Lubrication	Oil

Micrometer setting gauge:

