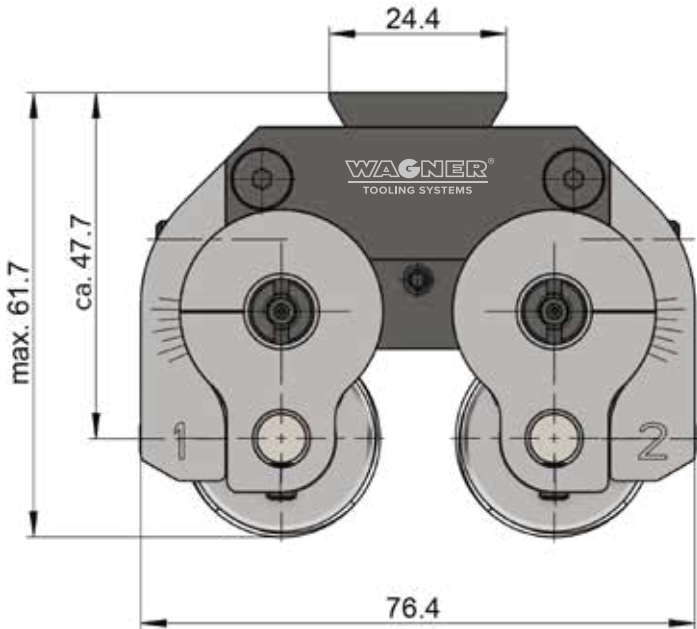




Tangential rolling system B8



* With rolls DR1: 14.1 mm

Tangential rolling system B8

Weight of tool with rolls	0.9 kg
Weight of adapter	approx. 1.5 kg
Max. feed force	1600 N

	mm	inch
Standard thread Ø	1.6–12	0.06–0.5
Fine thread Ø	1.6–13	0.06–0.5
Max. thread length (minus 2 × thread pitch)	14	0.55
Clearance from roll to tool edge	7.5	0.28

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 M10 × 1

Thread length	6.5 mm
Material	1.0715
Rolling speed	75 m/min
Spindle speed	2500 r.p.m.
Feed	0.25 mm
Machining time	0.4 sec.
Lubrication	Oil

Micrometer setting gauge:

