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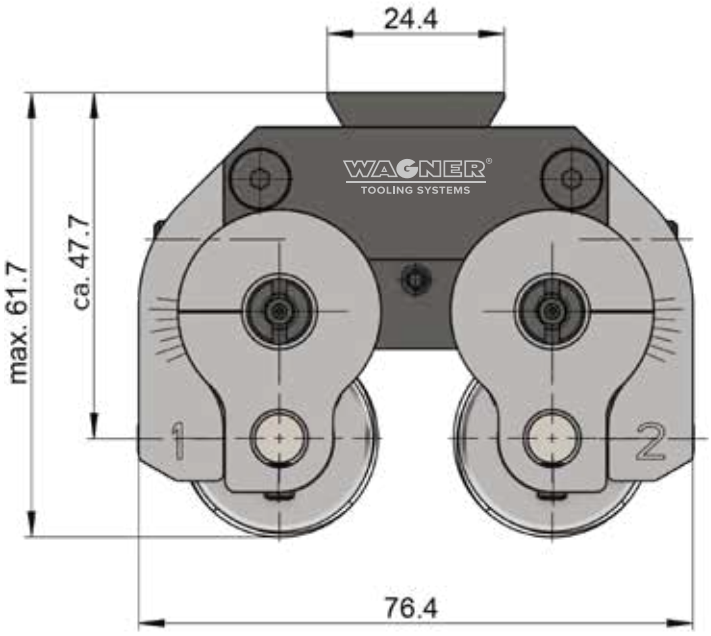
Tangential rolling system B8

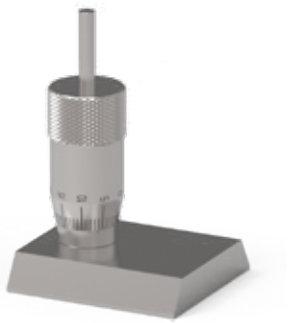


* With rolls DR1: 14.1 mm

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

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:



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

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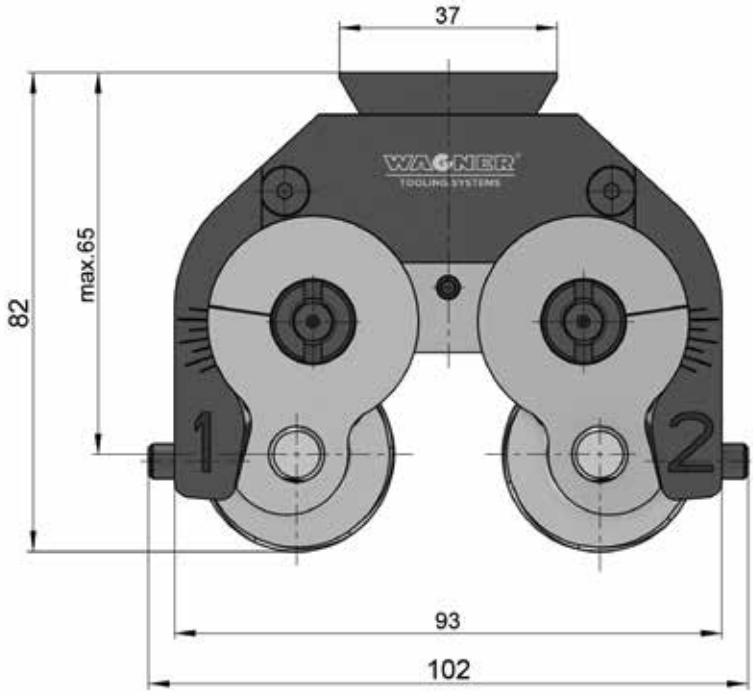
Tangential rolling system B10

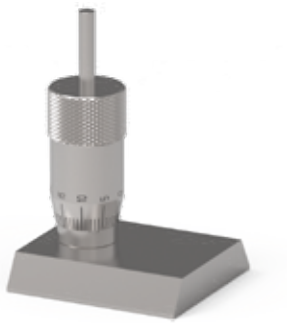


* With rolls DR1: 19,2 mm

Tangential rolling system B10		
Weight of tool with rolls	1.9 kg	
Weight of adapter	approx. 1.7 kg	
Max. feed force	2500 N	
	mm	**inch**
Standard thread Ø	2–16	0.08–0.625
Fine thread Ø	2–16	0.08–0.625
Max. thread length (minus 2 × thread pitch)	19	0.75
Clearance from roll to tool edge	10.1	0.39

Example Thread G1/4"	
Thread length	5 mm
Material	1.4571
Rolling speed	50 m/min
Spindle speed	1300 r.p.m.
Feed	0.20 mm
Machining time	1.2 sec.
Lubrication	Emulsion

Micrometer setting gauge:



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

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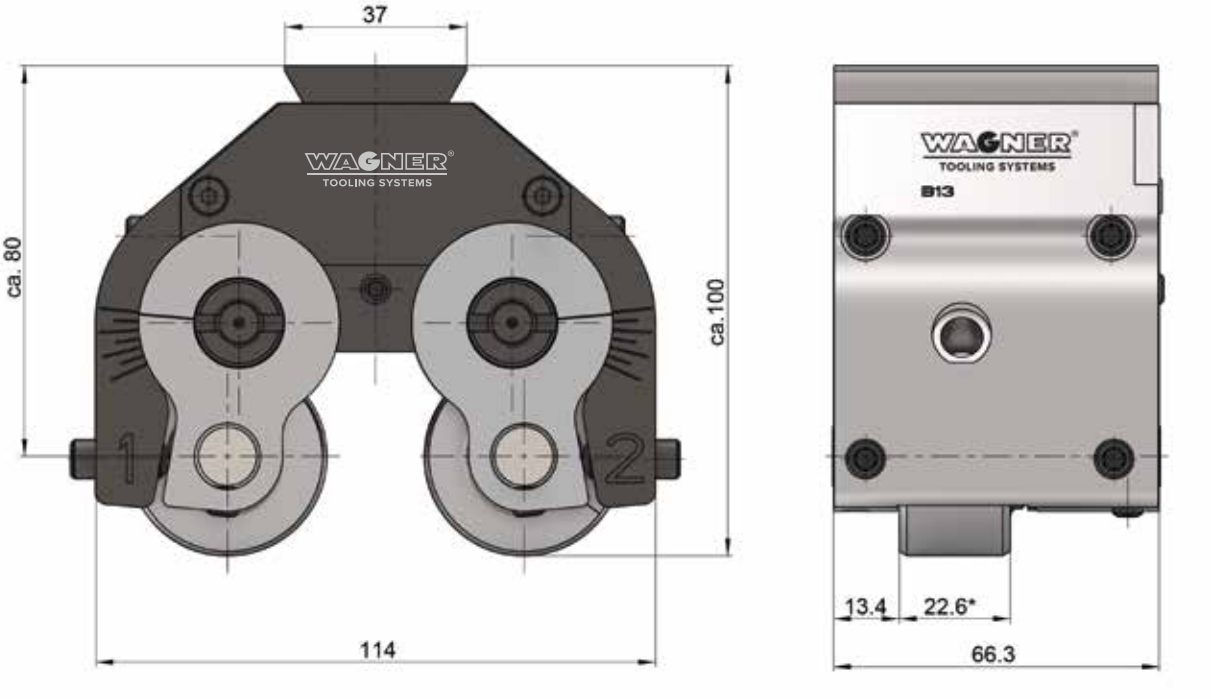
Tangential rolling system B13

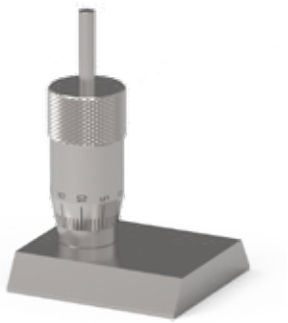


*with rolls DR1: 25.7 mm

Tangential rolling system B13		
Weight of tool with rolls	3.8 kg	
Weight of adapter	approx. 2.0 kg	
Max. feed force	4900 N	
	mm	**inch**
Standard thread Ø	3–22	0.12–0.866
Fine thread Ø	3–30	0.12–1.181
Max. thread length (minus 2 × thread pitch)	25.7	1.01
Distance roll to tool edge	13.4	0.53

Example Thread M17 × 0.75-LH	
Thread length	12 mm
Material	1.7228
Rolling speed	40 m/min
Spindle speed	800 r.p.m.
Feed	0.22 mm
Lubrication	Oil
Machining time	1.6 s

Micrometer setting gauge:



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

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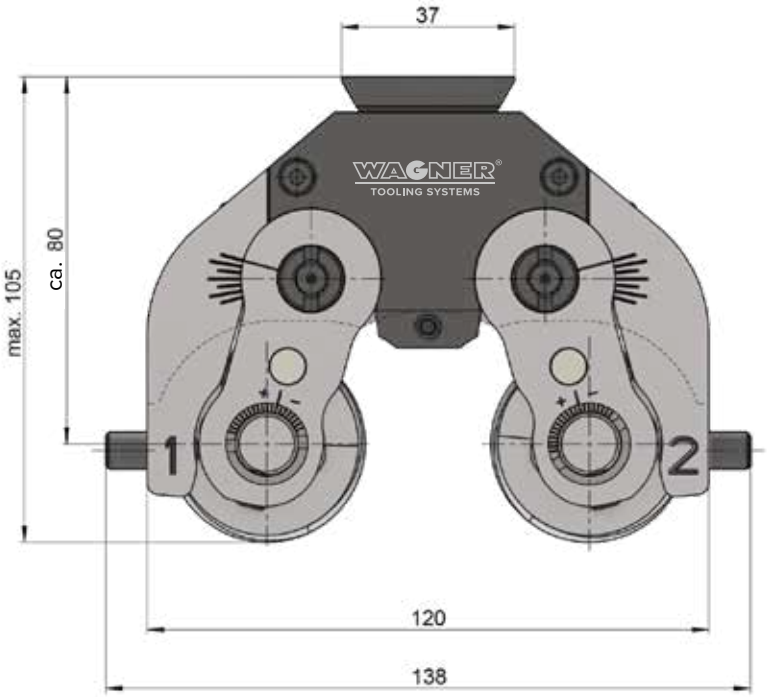
Tangential rolling systems B14 and B14-F

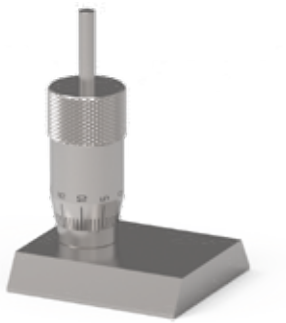


* With rolls DR1: 25.6 mm

Tangential rolling systems B14 and B14-F		
Weight of tool with rolls	3.5 kg	
Weight of adapter	approx. 2 kg	
Max. feed force	5000 N	
	mm	**inch**
Standard thread Ø	4–22	0.157–0.875
Fine thread Ø	4–35	0.157–1.375
Max. thread length (minus 2 × thread pitch)	25.5	1
Clearance from roll to tool edge	13.5	0.531

Example Thread M17 × 0.75-LH	
Thread length	12 mm
Material	1.7228
Rolling speed	40 m/min
Spindle speed	800 r.p.m.
Feed	0.20 mm
Machining time	1.6 sec.
Lubrication	Oil

Micrometer setting gauge:



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

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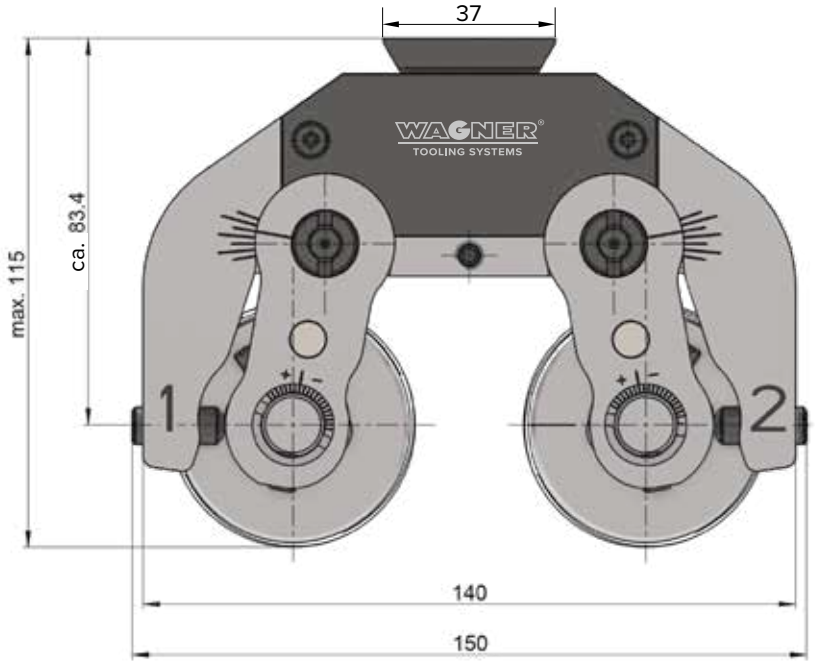
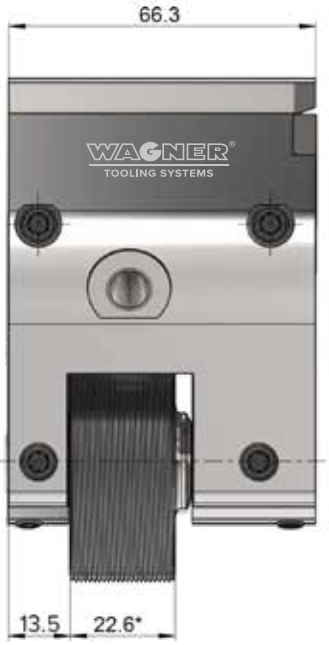
Tangential rolling systems B16 and B16-F



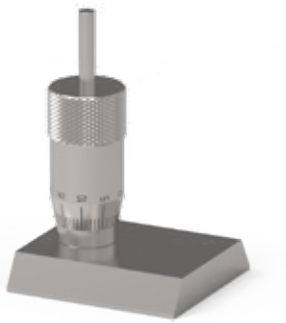


* With rolls DR1: 25.6 mm

Tangential rolling systems B16 and B16-F		
Weight of tool with rolls	3.7 kg	
Weight of adapter	approx. 2 kg	
Max. feed force	5700 N	
	mm	**inch**
Standard thread Ø	6–22	0.25–0.875
Fine thread Ø	6–45	0.25–1.75
Max. thread length (minus 2 × thread pitch)	25.5	1
Clearance from roll to tool edge	13.5	0.531

Example Thread UNJF 5/16"-24	
Thread length	19.5 mm
Material	3.7164
Rolling speed	40 m/min
Spindle speed	1750 r.p.m.
Feed	0.20 mm
Machining time	1.0 sec.
Lubrication	Emulsion

Micrometer setting gauge:



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

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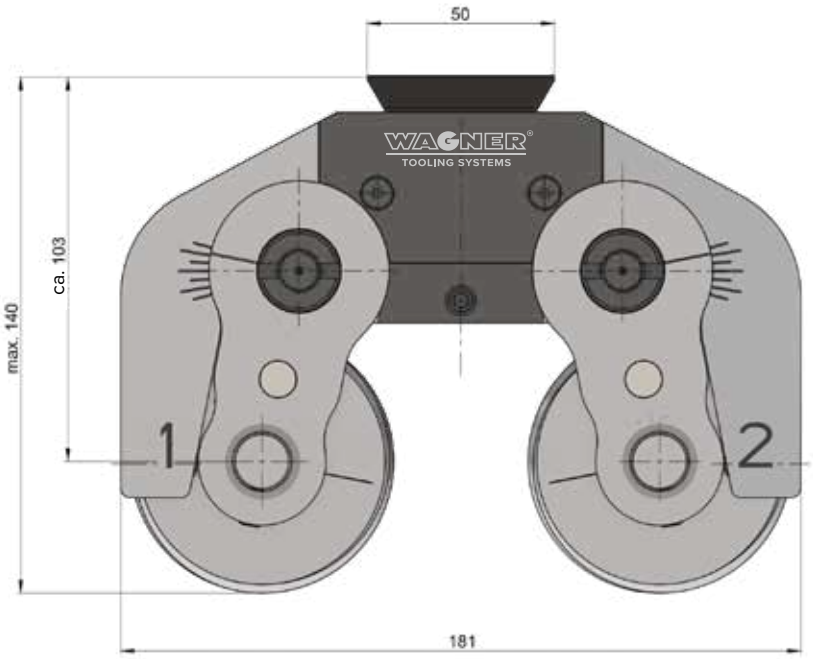
Tangential rolling systems B19 and B19-F

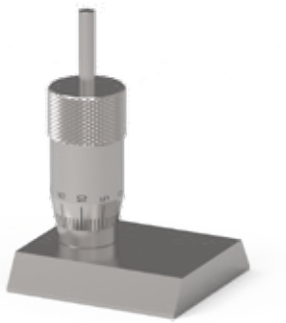


* With rolls DR1: 34,6 mm

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

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:



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

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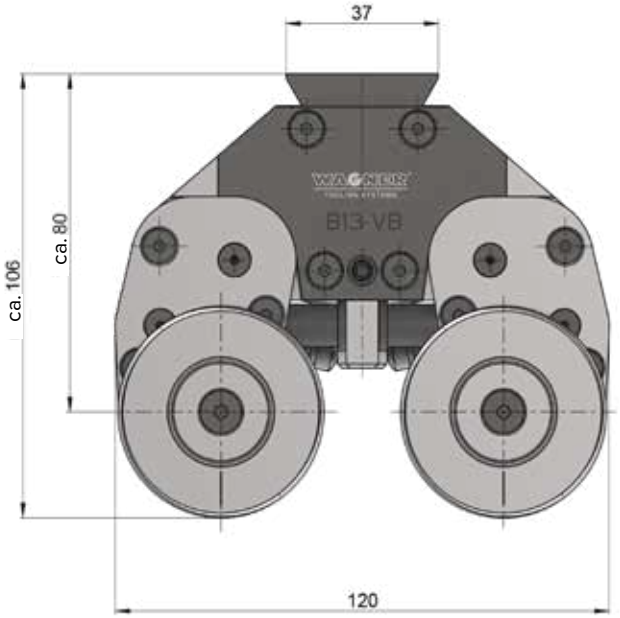
Tangential rolling system B13-VB

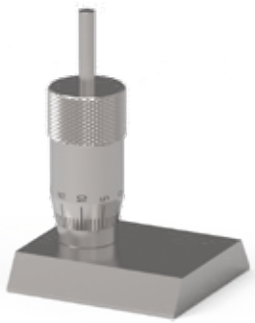


Tangential rolling system B13-VB		
Weight of tool with rolls	4.5 kg	
Weight of adapter	approx. 2.0 kg	
Max. feed force	4000 N	
	mm	**inch**
Standard thread Ø	3–10	0.12–0.375
Fine thread Ø	3–24	0.12–0.9375
Max. thread length (minus 2 × thread pitch)	17	0.67

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

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

Micrometer setting gauge:



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

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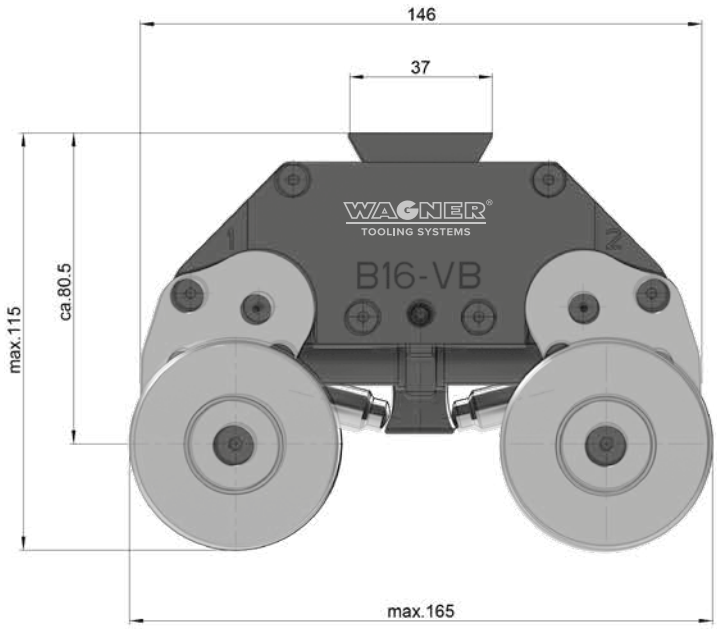
Tangential rolling system B16-VB

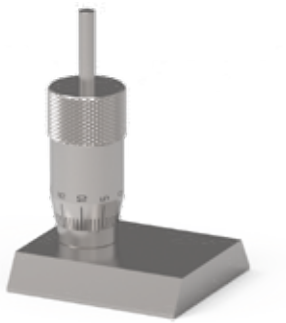


Tangential rolling system B16-VB		
Weight of tool with rolls	5.4 kg	
Weight of adapter	approx. 2.0 kg	
Max. feed force	4000 N	
	mm	**inch**
Standard thread Ø	8–16	0.315–0.625
Fine thread Ø	8–42	0.5–1.625
Max. thread length (minus 2 × thread pitch)	20	0.787

Example Thread UNEF 3/4"-20	
Thread length	6 mm
Material	1.4404
Rolling speed	40 m/min
Spindle speed	700 r.p.m.
Feed	0.21 mm
Machining time	2.8 sec.
Lubrication	Oil

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

Micrometer setting gauge:



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

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