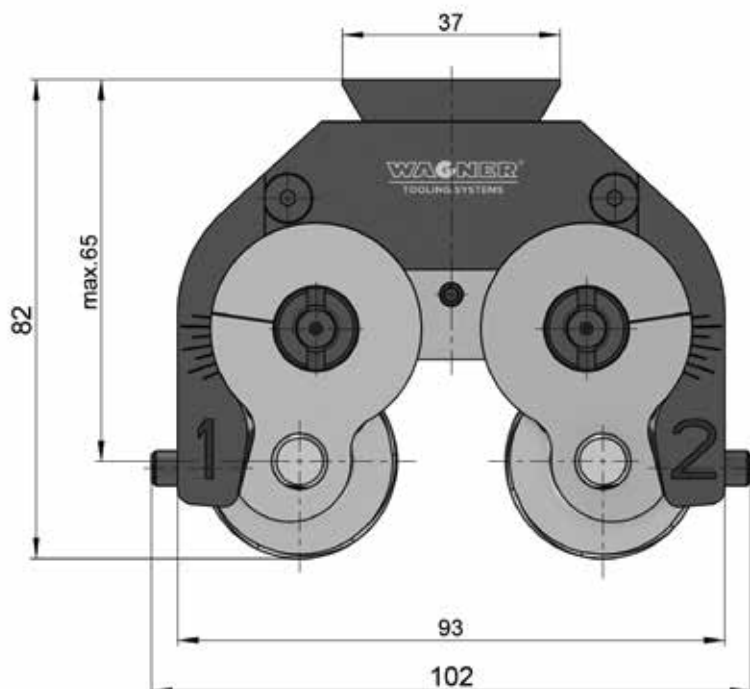




Tangential rolling system B10



* 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

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 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:

