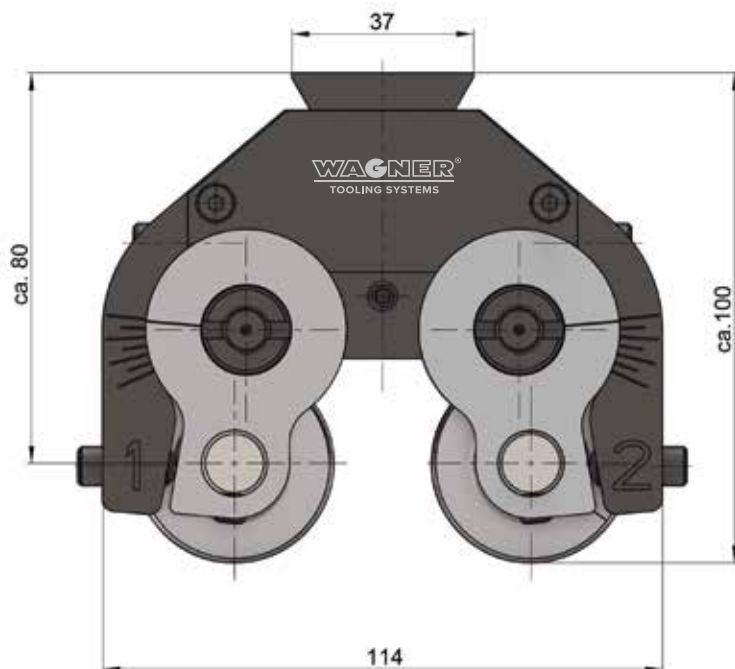




Tangential rolling system B13



*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

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

Micrometer setting gauge:

