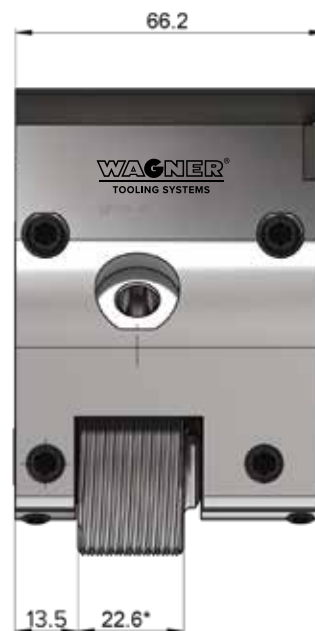
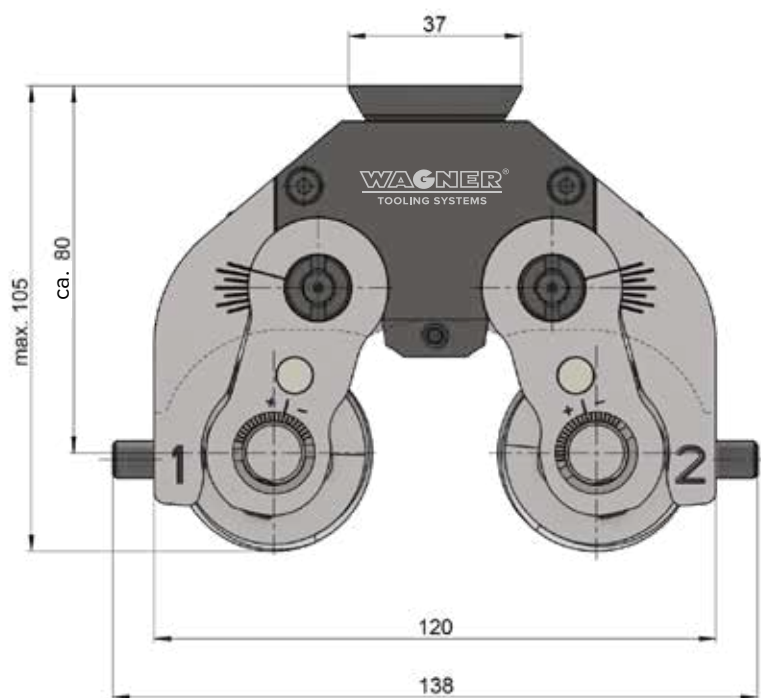




Tangential rolling systems B14 and B14-F



* 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

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 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:

