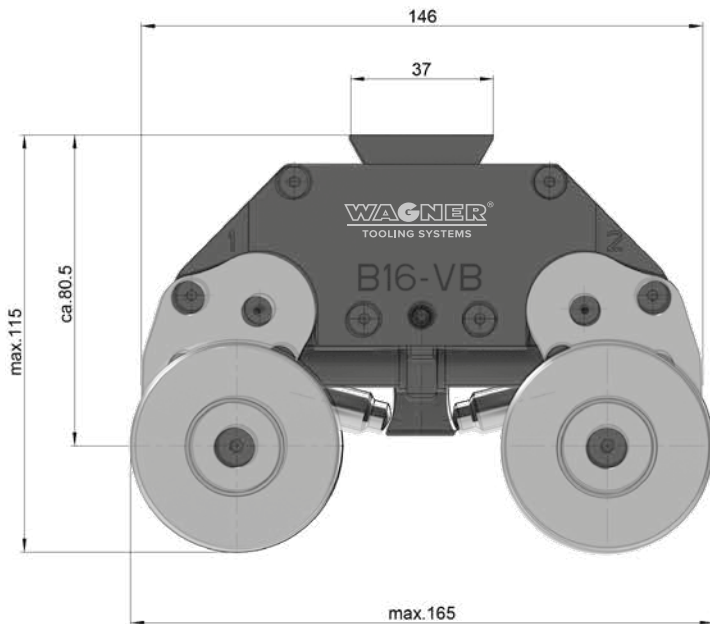




## Tangential rolling system B16-VB



### 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

### 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 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

Micrometer setting gauge:

