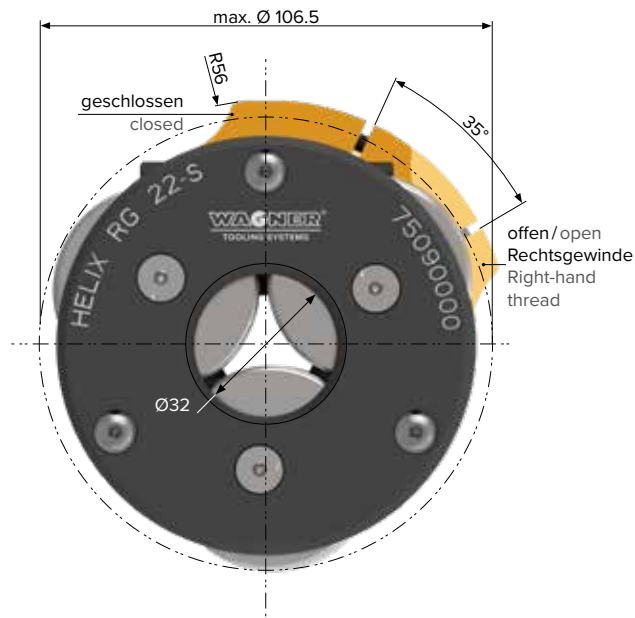
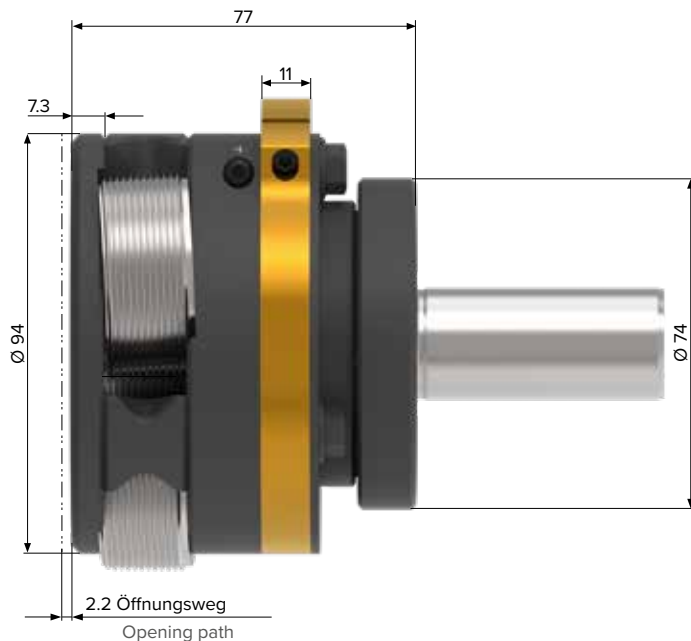




HELIX Axial-Rollsystem RG22-S/FG22-S

HELIX Axial rolling system RG22-S/FG22-S

Bauart stillstehend
Type stationary



Metrisches ISO-Gewinde DIN 13 Regel- und Feingewinde Metric ISO thread DIN 13 standard and fine thread	Amerikanische UN/UNC/UNF/UNEF/ UNS-Gewinde ASME B1.1 American UN/UNC/UNF/ UNEF/UNS thread ASME B1.1	Rohrgewinde DIN EN ISO 228 Pipe thread DIN EN ISO 228	Whitworth- Regelgewinde BS84 (BSW) Whitworth stan- dard thread BS84 (BSW)	Whitworth- Feingewinde BS84 (BSF) Whitworth fine thread BS84 (BSF)	Rohrgewinde DIN EN 10226 ISO 7, K1/16 Pipe thread DIN EN 10226 ISO 7, K1/16	Amerikanische kegelige Rohrgewinde ANSI/ASME B1.20.1, ANSI 1.20.3 American tapered pipe threads ANSI/ASME B1.20.1 ANSI 1.20.3
HELIX 22						
RG-22-S	M10–M22	UN/UNC/UNF 3/8"–7/8"	G 1/8" + G 1/4"	BSW3/8"–3/4"	BSF3/8"–7/8"	R 1/8" + G 1/4"
FG-22-S	M9×0.5–M22×2	UNEF 7/8"–7/8"	G 3/8" + G 1/2"			R 3/8" + R 1/2"

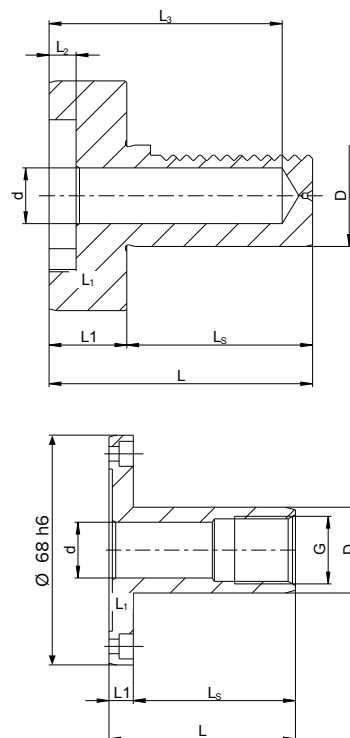
Axial-Rollsystem HELIX RG22-S/FG22-S/ Axial rolling system HELIX RG22-S/FG22-S

Gewicht Werkzeug mit Rollen/Weight of tool with rolls	2.6 kg
Gewicht Schaft/Weight of shank	0.3–1 kg
Schließenrichtung/Closing device	1.2 kg

Schaft-Ø D Shank-Ø D mm (Zoll/Inch)	d mm	L mm	L _s mm	L ₁ mm	L ₂ mm	L ₃ mm	G
19,05 (3/4")	12.5	49	42	7.2	–	–	M14-LH
20	12.5	49	42	7.2	–	–	M14-LH
22	12.5	49	42	7.2	–	–	M14-LH
25	16.5	77.2	70	7.2	–	–	M20 × 1.5
25,4 (1")	16.5	77.2	70	7.2	–	–	M20 × 1.5
30	22.5	67	60	7.2	–	52	M18 × 1.5
32	22.5	87	80	7.2	–	52	M24 × 1.5
VDI20	16.5	59.7	40	19.7	8	16	–
VDI30	16.5	78	55	23	8	69	–
VDI40	25	86	63	23	16	71	–

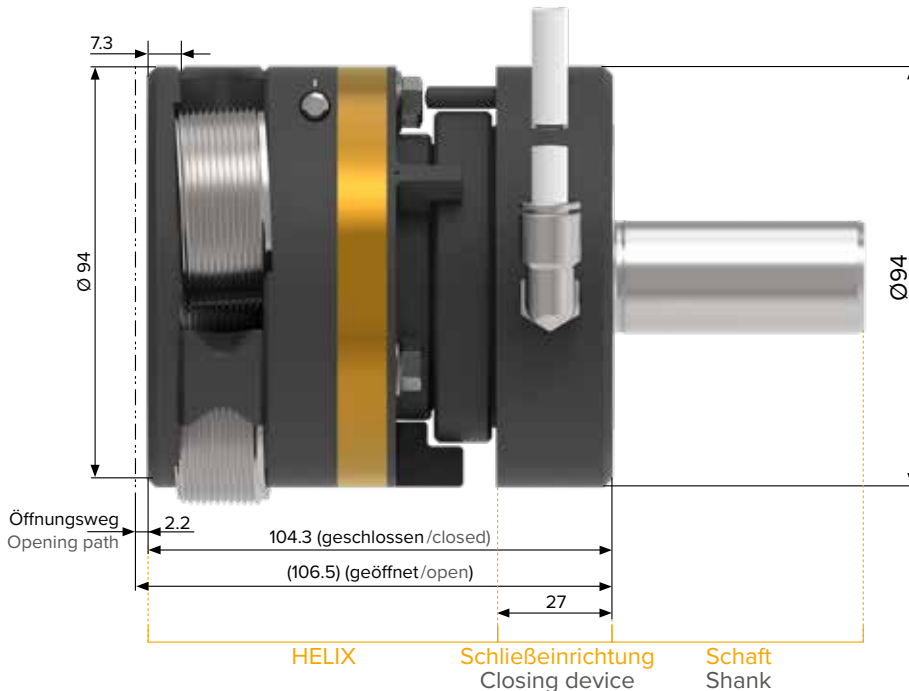
* Weitere Varianten auf Anfrage
* Other variants on request

Abbildung: Schaftmaße, siehe Tabelle
Figure: Shank dimensions, see table



HELIX RG22-S/FG22-S mit Schließeinrichtung HELIX RG22-S/FG22-S with closing device

Bauart stillstehend
Type stationary



Betriebsdruck
6–12 bar erforderlich
Operating pressure
6–12 bar required

Jedes stillstehend eingesetzte Axial-Rollsystem HELIX kann mit einer Schließeinrichtung (pneumatisch oder kühlmittebetrieb) nachgerüstet werden.

Every stationary HELIX axial rolling system can be upgraded with a closing device (pneumatic or coolant-operated).

BAUART STILLSTEHEND TYPE STATIONARY

**HELIX RG22-S/FG22-S
mit Schließeinrichtung**
**HELIX RG22-S/FG22-S
with closing device**

HELIX RG22-S
stillstehend für Regelgewinde bis M22
stationary for standard threads up to M22

HELIX FG22-S
stillstehend für Feingewinde bis M22 × 2
stationary for fine threads up to M22 × 2

BAUART ROTIEREND TYPE ROTARY

HELIX RG22-R
rotierend für Regelgewinde bis M22
rotary for standard threads up to M22

HELIX FG22-R
rotierend für Feingewinde bis M22 × 2
rotary for fine threads up to M22 × 2



Alle Systeme sind für Rechts- und für Linksgewinde erhältlich.
All systems are available for right-hand and left-hand threads.

Video Betriebsanleitung
Baureihe Helix 22
Video Operation Manual
Helix 22 series

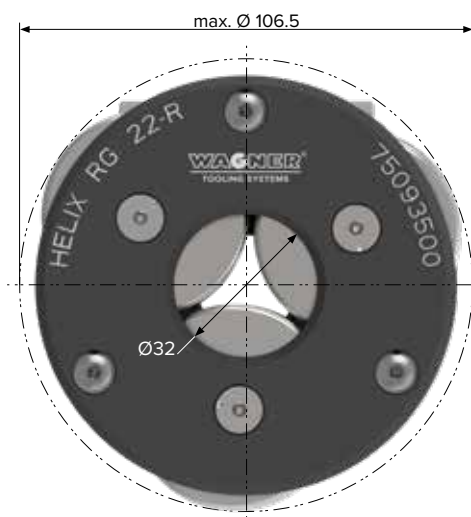
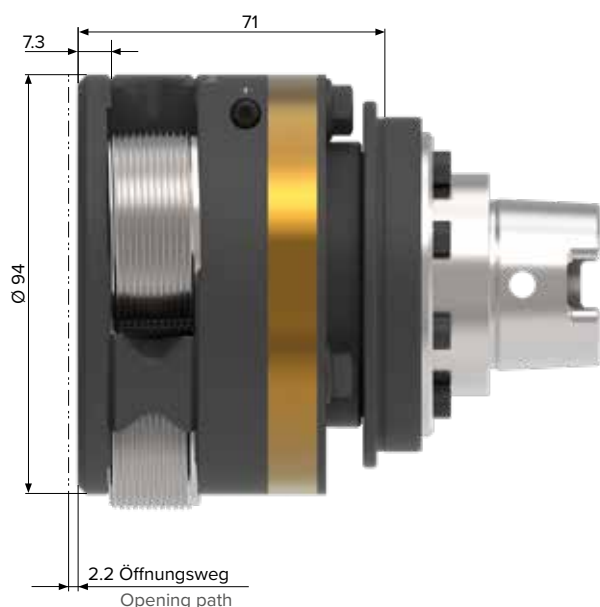


WAGNER
TOOLING SYSTEMS



HELIX Axial-Rollsystem RG22-R/FG22-R HELIX Axial rolling system RG22-R/FG22-R

Bauart rotierend
Type rotary



Metrisches ISO-Gewinde DIN 13 Regel- und Feingewinde Metric ISO thread DIN 13 standard and fine thread	Amerikanische UN/UNC/UNF/UNEF/ UNS-Gewinde ASME B1.1 American UN/UNC/UNF/ UNEF/UNS thread ASME B1.1	Rohrgewinde DIN EN ISO 228 Pipe thread DIN EN ISO 228	Whitworth- Regelgewinde BS84 (BSW) Whitworth stan- dard thread BS84 (BSW)	Whitworth- Feingewinde BS84 (BSF) Whitworth fine thread BS84 (BSF)	Rohrgewinde DIN EN 10226 ISO 7, K1/16 Pipe thread DIN EN 10226 ISO 7, K1/16	Amerikanische kegelige Rohrgewinde ANSI/ASME B1.20.1, ANSI 1.20.3 American tapered pipe threads ANSI/ASME B1.20.1 ANSI 1.20.3
HELIX 16						
RG-22-R	M10–M22	UN/UNC/UNF 3/8"–7/8"	G 1/8" + G 1/4"	BSW3/8"–3/4"	BSF3/8"–7/8"	R 1/8" + G 1/4"
FG-22-R	M9×0.5–M22×2	UNEF 7/8"–7/8"	G 3/8" + G 1/2"			R 3/8" + R 1/2"

Axial-Rollsystem HELIX RG22-S/FG22-S/ Axial rolling system HELIX RG22-S/FG22-S

Gewicht Werkzeug mit Rollen/Weight of tool with rolls

2.6 kg



➔ **Schäfte sind baugleich mit Schäften des Helix 22-S (stillstehend) siehe Seite 304. Sonderaufnahmen (Flansch, HSK, Capto) auf Anfrage.**

Shanks are identical in construction to Helix 22-S shanks (stationary) see page 304. Customised holders (flange, HSK, Capto) on request.

HELIX 22: Gewindeabmessungen

HELIX 22: Thread sizes

Metr. ISO- Gewinde DIN 13	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
M9 × 1	X	
M9 × 0.75		X
M9 × 0.5		X
M10 × 1.5	X	
M10 × 1.25	X	
M10 × 1	X	X
M10 × 0.75		X
M10 × 0.5		X
M11 × 1.5	X	
M11 × 1.25	X	
M11 × 1	X	X
M11 × 0.75		X
M11 × 0.5		X
M12 × 1.75	X	
M12 × 1.5	X	
M12 × 1.25	X	X
M12 × 1		X
M12 × 0.75		X
M12 × 0.5		X
M13 × 1.75	X	
M13 × 1.5	X	
M13 × 1		X
M13 × 0.75		X
M13 × 0.5		X

Metr. ISO- Gewinde DIN 13	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
M14 × 2	X	
M14 × 1.75	X	
M14 × 1.5	X	X
M14 × 1.25	X	X
M14 × 1		X
M14 × 0.75		X
M14 × 0.5		X
M15 × 1.5	X	X
M15 × 1		X
M15 × 0.75		X
M15 × 0.5		X
M16 × 2	X	
M16 × 1.5	X	X
M16 × 1.25		X
M16 × 1		X
M16 × 0.75		X
M16 × 0.5		X
M17 × 2	X	
M17 × 1.5	X	X
M17 × 1		X
M17 × 0.75		X
M17 × 0.5		X

Metr. ISO- Gewinde DIN 13	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
M18 × 2.5	X	
M18 × 2	X	
M18 × 1.5		X
M18 × 1		X
M18 × 0.75		X
M18 × 0.5		X
M19 × 2	X	X
M19 × 1.5		X
M19 × 1		X
M19 × 0.75		X
M20 × 2.5	X	
M20 × 2	X	X
M20 × 1.5		X
M20 × 1		X
M20 × 0.75		X
M21 × 2	X	X
M21 × 1.5		X
M21 × 1		X
M21 × 0.75		X
M22 × 2.5	X	
M22 × 2	X	X
M22 × 1.5		X
M22 × 1		X
M22 × 0.75		X



HELIX 22: Gewindeabmessungen

HELIX 22: Thread sizes

Unified-Gewinde Unified threads ANSI B1.1	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
3/8-20UN	X	
3/8-24UNF	X	
3/8-28UN	X	X
3/8-32UNEF		X
3/8-36UNS		X
7/16-14UNC	X	
7/16-16UN	X	
7/16-20UNF	X	
7/16-22UNS	X	X
7/16-26UNS	X	X
7/16-28UNEF		X
7/16-32UN		X
7/16-36UNS		X
1/2-13UNC	X	
1/2-16UN	X	
1/2-18UN	X	
1/2-20UNF	X	X
1/2-22UNS	X	X
1/2-26UNS		X
1/2-28UNEF		X
1/2-32UN		X

Unified-Gewinde Unified threads ANSI B1.1	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
9/16-12UN	X	
9/16-14UN	X	
9/16-16UN	X	
9/16-18UNF	X	X
9/16-20UN	X	X
9/16-22UN		X
9/16-24UNEF		X
9/16-26UNEF		X
9/16-28UN		X
9/16-32UN		X
5/8-11UNC	X	
5/8-12UN	X	
5/8-16UN	X	X
5/8-18UNF	X	X
5/8-20UN		X
5/8-24UNEF		X
5/8-28UN		X
5/8-32UN		X
11/16-12UN	X	
11/16-16UN	X	X
11/16-20UN		X
11/16-24UNEF		X
11/16-28UN		X
11/16-32UN		X

Unified-Gewinde Unified threads ANSI B1.1	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
3/4-10UNC	X	
3/4-12UN	X	
3/4-16UNF		X
3/4-20UNEF		X
3/4-24UN		X
3/4-28UN		X
3/4-32UN		X
13/16-12UN	X	X
13/16-16UN		X
13/16-20UNEF		X
13/16-28UN		X
13/16-32UN		X
7/8-12UN	X	X
7/8-14UNF		X
7/8-16UN		X
7/8-20UNEF		X
7/8-28UN		X
17/8-32UN		X

Amerik. Rohrgewinde NPT, kegelig American pipe threads NPT, taper DIN EN 10226 DIN 2999 DIN 3858	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
1/8	X	X
1/4	X	X
3/8		X
1/2		X

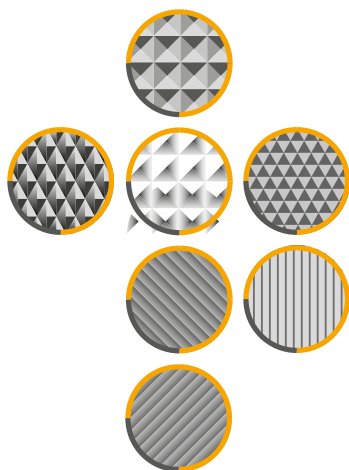
HELIX 22: Gewindeabmessungen

HELIX 22: Thread sizes

Whitworth- Gewinde Whitworth threads B. S. 84	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
3/8"-20BSF	X	
3/8"-26BSFS	X	X
3/8"-32BSFS		X
7/16"-14BSW	X	
7/16"-18BSF	X	
7/16"-20BSFS	X	
7/16"-26BSFS	X	X
1/2"-12BSW	X	
1/2"-16BSF	X	
1/2"-20BSFS	X	X
1/2"-24BSFS		X
1/2"-26BSFS		X
9/16"-12BSW	X	

Whitworth- Gewinde Whitworth threads B. S. 84	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
9/16"-16BSF	X	
9/16"-20BSFS	X	X
9/16"-26BSFS		X
5/8"-11BSW	X	
5/8"-13BSFS	X	
5/8"-14BSF	X	
5/8"-20BSFS		X
5/8"-22BSFS		X
5/8"-26BSFS		X
11/16"-11BSW	X	
11/16"-14BSF	X	X
11/16"-16BSFS	X	X
11/16"-20BSFS		X
11/16"-26BSFS		X

Whitworth- Gewinde Whitworth threads B. S. 84	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
3/4"-10BSW	X	
3/4"-12BSF	X	
3/4"-14BSFS	X	X
3/4"-16BSFS		X
3/4"-18BSFS		X
3/4"-20BSFS		X
3/4"-26BSFS		X
13/16"-12BSFS	X	X
13/16"-16BSFS		X
13/16"-20BSFS		X
13/16"-26BSFS		X
7/8"-11BSF	X	X
7/8"-18BSFS		X
7/8"-20BSFS		X



Mit entsprechenden Rändelrollen kann man mit **HELIX Rollsystemen** auch verschiedene Rändel herstellen.

Using the appropriate knurling rolls, **HELIX rolling systems** can also be used to produce various types of knurling.

Whitworth- Rohrgewinde Whitworth Pipe threads DIN EN ISO 228	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
G1/8	X	X
G1/4	X	X
G3/8		X
G1/2		X

Whitworth- Rohrgewinde, kegelig Whitworth Pipe threads taper DIN EN 10226 DIN 2999 DIN 3858	Rollsystem Rolling system	
	RG22-S RG22-R	FG22-S FG22-R
R1/8	X	X
R1/4	X	X
R3/8		X
R1/2		X