

Tangential Thread Rolling

Thread Rolls & Setting Gauges

Thread rolls

One set of rolls is needed for each thread size. One set has two different rolls. They are marked with the number 1 and 2. The rolls have a defined position on the rolling attachment. The rolling attachments are marked on the front end, with the number 1 on the upper side and number 2 on the lower side. The roll number 1 has to be mounted where the number 1 is marked on the attachment. It is imperative that the roll is mounted with the marked number looking towards the outside of the attachment. The same has to be done with roll number 2. Both marked numbers have to look to the outer side of the attachment.

Spindle direction may be right or left handed the component must rotate in the same direction of the arrow on the roll that contacts the component first.

The marking in the roll consists of the thread size, attachment size, code number, roll width, roll style and EDP number.

Setting Gauges

There is a setting gauge for each thread size. The setting gauge has two tasks:

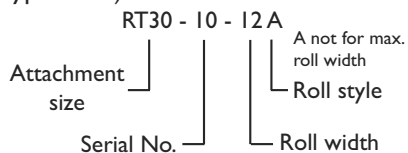
1. The distance of the axles are set-up after mounting the rolls on the attachment. In general the width of the recessed part of the gauge is equivalent to the core diameter of the thread. This dimension has to be setup tight between the rolls.

Please check when using the setting gauge that the marking of attachment size and serial code number are identical to the marking of attachment size and serial code number on the rolls.

2. The size of the stroke is set. The attachment holder is mounted on the slide (turret). The gauge is mounted on the pin of the attachment holder. The slide has to be advanced towards the component direction, until the tip of the gauge touches the blank diameter. This position is the end of the work stroke.

Roll-Key-Code:

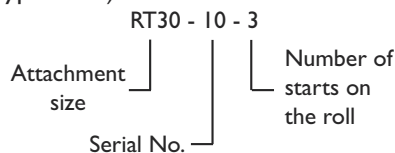
(Example for M 22 x 2.5 on attachment Type RT30)



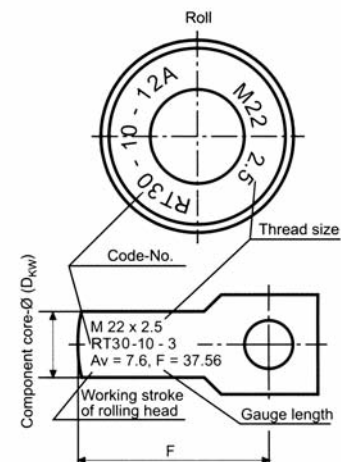
Max. width rolls
 T 12 = 15.5 mm/0.61"
 T 18 = 21.5 mm/0.846"
 T 27 = 31 mm/1.22"
 T 42 = 40.5 mm/1.594"

Setting Gauges-Key-Code:

(Example for M 22 x 2.5 on attachment Type RT30)



Please check when using the setting gauge, that the marking of attachment size and serial code number are identical to the marking of attachment size and serial code no. on the rolls.



Standard roll width design

Head	Roll Widths (mm)/inch													
RT10	4	6	8	10	12	14	15.5							
	0.157	0.236	0.315	0.394	0.472	0.551	0.61							
RT20	-	6	8	10	12	14	16	18	21.5					
	-	0.236	0.315	0.394	0.472	0.551	0.63	0.709	21.5					
RT30	-	-	8	10	12	14	16	18	20	22	24	26	28	31
	-	-	0.315	0.394	0.472	0.551	0.63	0.709	0.787	0.866	0.945	1.024	1.102	1.22

It is recommended to order the roll widths in the dimensions shown. Special requirements upon request.