

COLD THREAD ROLLING



RM 60

**COLD THREAD
ROLLING MACHINE**

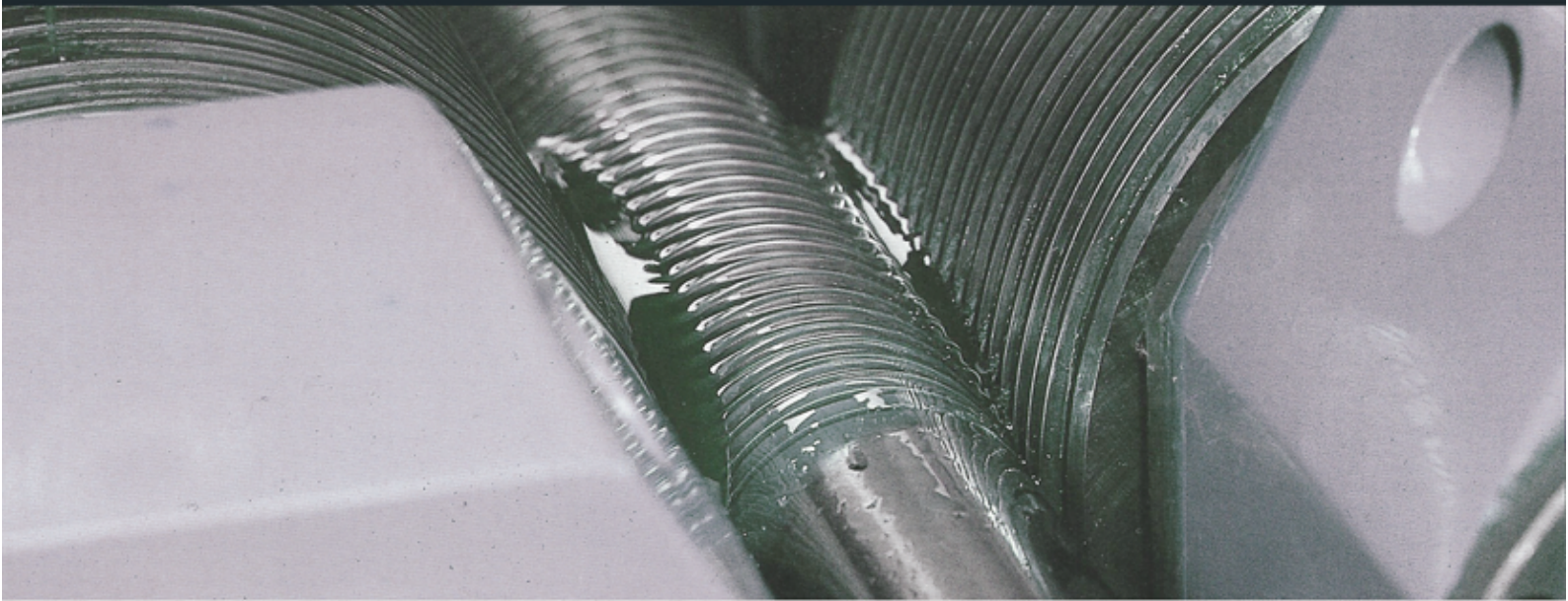


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What is Cold Rolling?

Cold rolling

may be defined as the coldforming of the circumferential surface of cylindrical workpieces. The desired profile is generated by rolling the workpiece under pressure between two opposing form rolls.

The workpiece material is displaced due to the rolling pressure and flows the outside diameter of the profile being rolled.

Advantages of Cold Rolling

Cold rolled profiles are very precise.

Rolled surfaces are burnished and work-hardened approximately 30 - 50% when compared to the workpiece core.

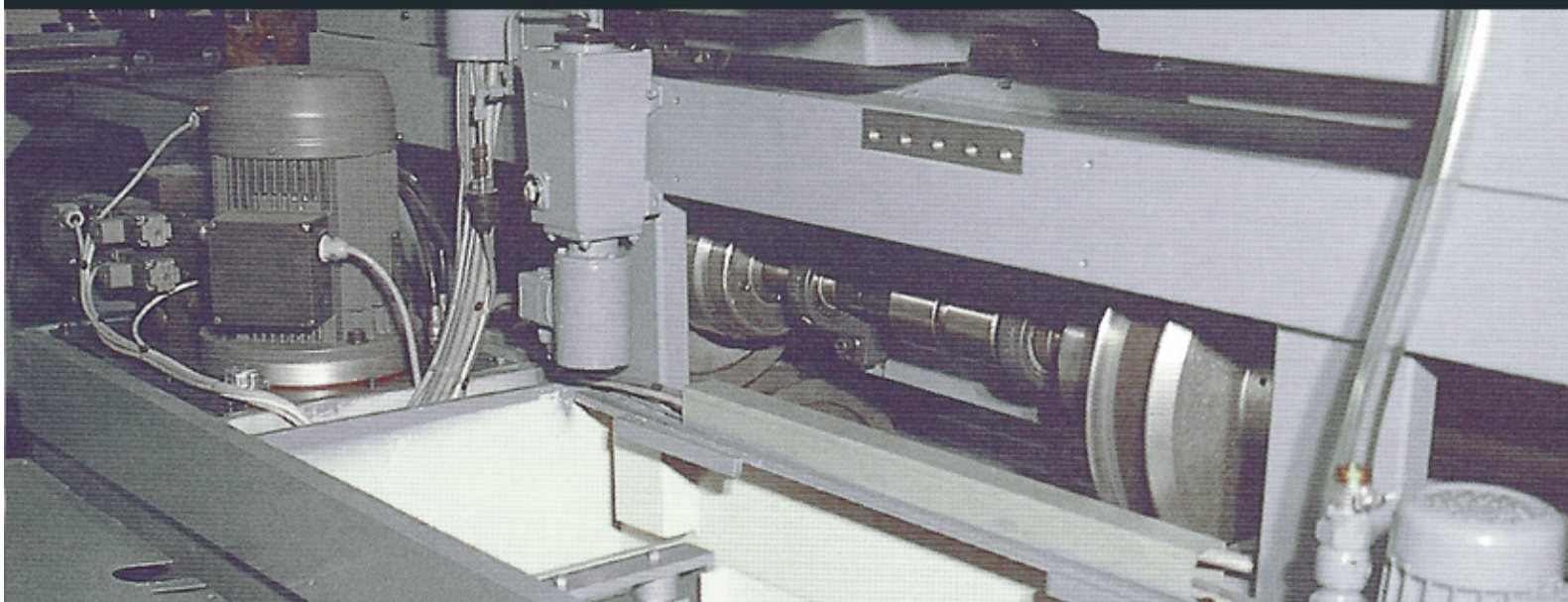
Fatigue strength improvement is on the order of 50 - 75%, tensile strength increased on the order of 10%. Other advantages of the cold rolling process include short set-up times, extremely short cycle times with a consequent reduction in per workpiece cost. Also, no waste such as chips is generated, amounting to as much as 20% savings in material costs.

Finally, the relatively short set-up times make cold rolling practical even for small and medium sized production runs.



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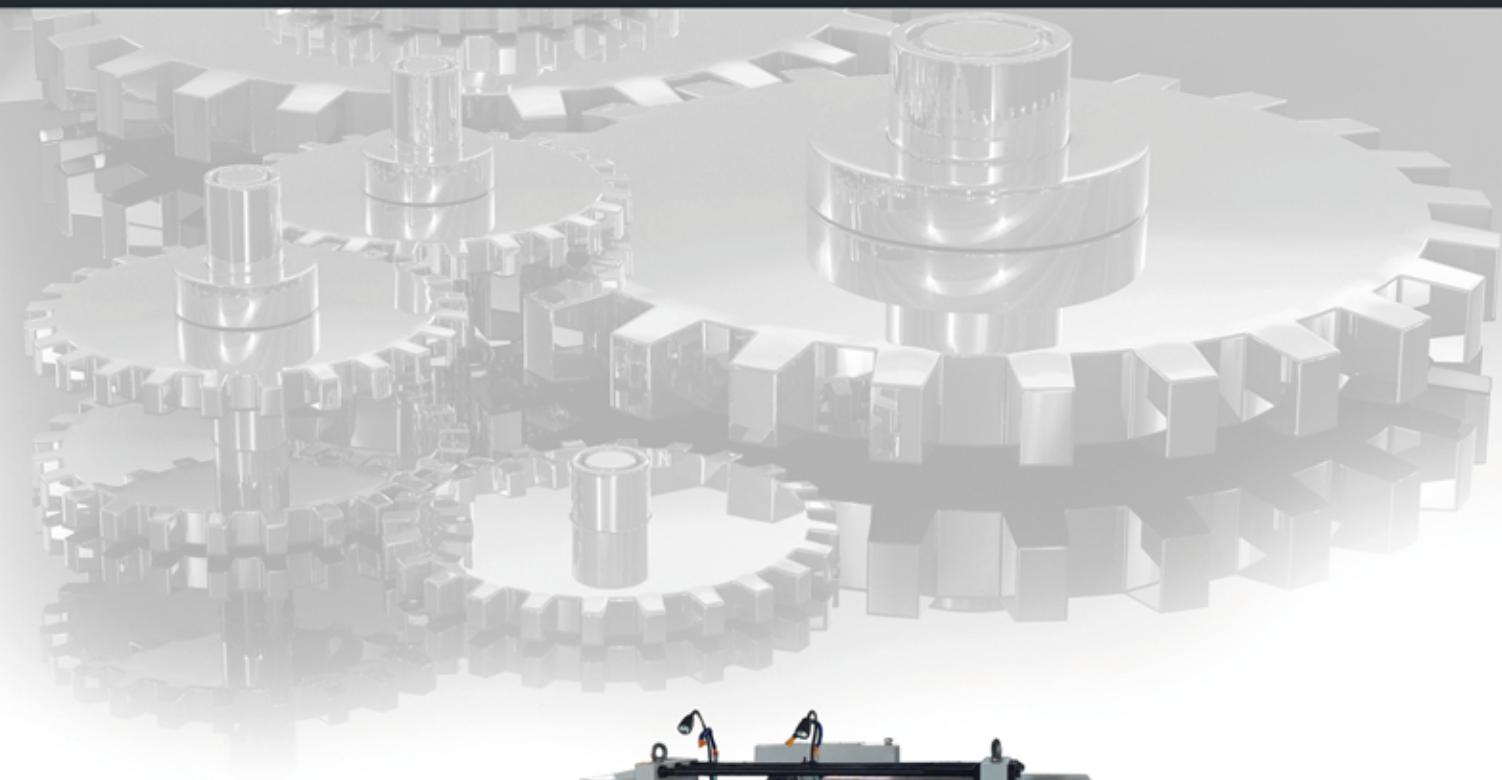


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Technical data and main dimensions:

■ Minimum / maximum diameter of the rolled workpiece	10/125 mm
■ Largest rolling step	10 mm
■ Largest division of the rolling at notch toothing	2,5 mm
■ Maximum length of the thread in the radial rolling process (infeed)	200 mm
■ in axial procedure (thrufeed) (guide with roller rest)	endless
■ Minimum / maximum distance between rolling spindles	160/275mm
■ Height of the rolling spindle over the machine placket	200 mm
■ Largest diameter of the rolling tool	220 mm
■ Roller spindle diameter	80 mm
■ Diameter in a special performance	69, 85 mm
■ Receiving length of the rolling spindle	180 mm
■ in special performance	225 mm
■ Force of rolling stepwise movable	40-600 kN
■ RPM of rolling spindle stepwise moveable	20-90 rpm
■ Motor of rolling spindle drive	30 kW
■ Motor for high-pressure gear pump	8,0 kW
■ Coolant pump motor	0,40 kW
■ Required space (lenght x width)	2.400 x 1.400
■ Net weight	ca. 6.500 kg
■ Gross weight	ca. 7.000 kg
■ Cover load per qm	ca. 3.900 kg
■ Full dimensions (lenght x width x height)	2.200 x 1,200 x 2.300 mm

RM 65 ROLLING MACHINE



RM 65

Thread Rolling machine

Technical details:

Maximum pressure	650 kN
Maximum rolling dia. \varnothing	120 mm (130 mm)
Maximum Roller (dies) dia. \varnothing	290 mm
Maximum Roller hole dia. \varnothing	100 mm
Maximum infeed rolling length	250 mm
Main motor	25 kW
Hydraulic motor	7,5 kW
Dimension	2.300x2.540x2.700 mm
Weight	6.200 kg



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