

**EVOline**

## 新型轴向滚压头

开启一个新时代的篇章

## The new axial rolling head

The beginning of a new generation

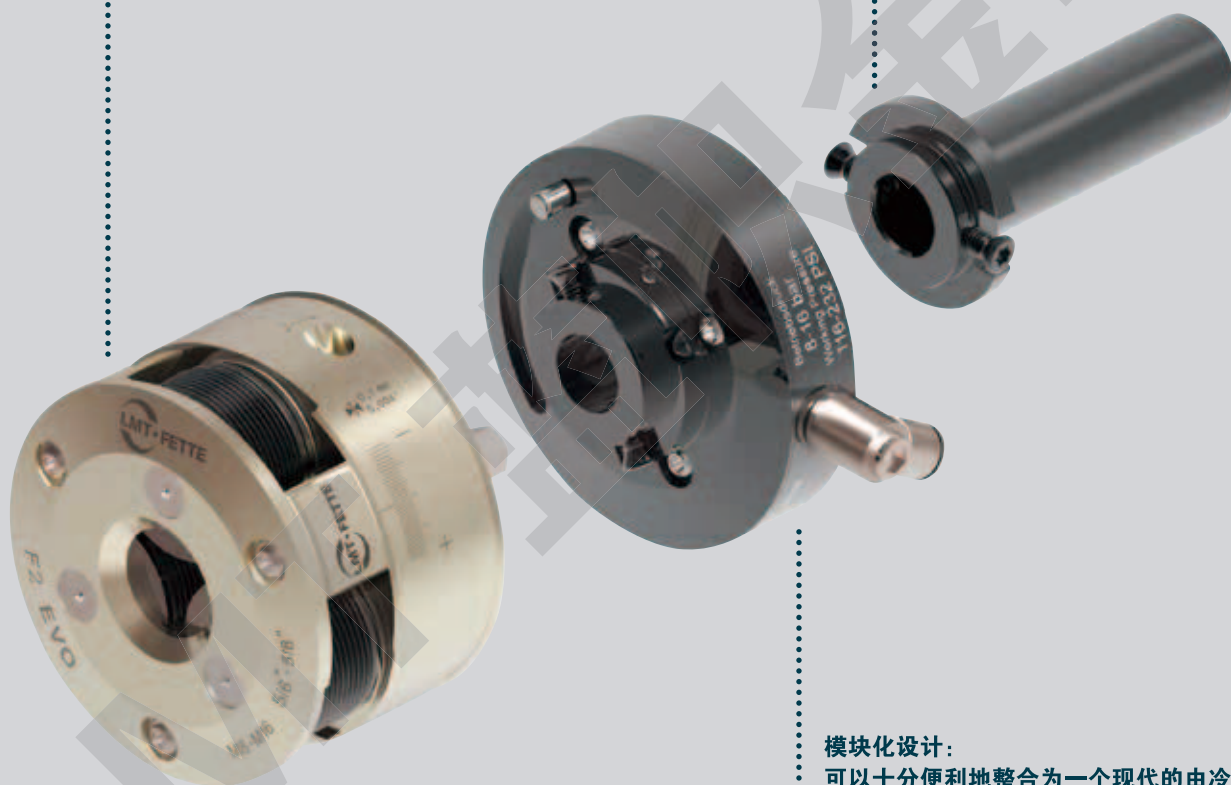


# EVOLine新一代的轴向滚压头 —— 成功的系统

## The new axial rolling head generation EVOLine – Success with system

Evoline轴向滚压头：  
提升加工安全性以及最佳的用户体验。  
Axial rolling head EVOLine:  
Increased process safety and  
highest user friendliness.

新型的接柄提供精确的同心度  
和安全的扭矩传递。  
可换式接柄的模块化设计提供  
高灵活性和高效率。  
New shank adaption for  
precise concentricity and  
safe torque transmission.  
High flexibility and  
efficiency due to modular  
change shanks.



带有精调功能的中心调节装置。  
调整更简便，重复精度更高。

Central adjustment of the  
rolling diameter with fine  
adjustment. Easy handling  
and precise repeatability of  
the settings.

模块化设计：  
可以十分便利地整合为一个现代的由冷  
却液驱动的闭合装置。  
Modular design:  
A modern, coolant operated  
closing device can be integrated  
very easily.

# 客户受益

## Customer benefits

简单且可精密调节的滚压结构  
Easy and precise fine  
adjustment of the  
rolling diameter

更短的加工时间  
更高的螺纹强度和质量  
Short machining times,  
high thread strength and  
high thread quality

铁屑防护后盖  
提升加工安全性  
Increased process  
safety due to chip  
guard

模块化设计提供安全简单的组装  
Safe and easy assembly  
due to modular design

NEW  
现代化闭合装置实现简单安装  
Modern closing device  
is easy to adapt



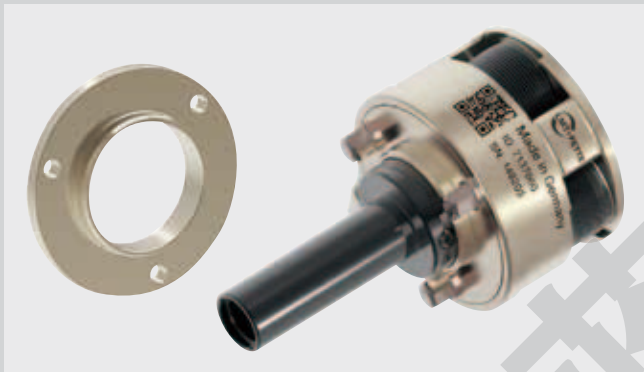


### 可精调的滚压结构

- 带有精调结构的中心调节装置 —— 已申请专利
- 精调由调节扳手实现
- 调节精确度（0.01mm的范围内）
- 高再现性 —— 可再现相同刻度下误差为 $\pm 0.01\text{mm}$ 的中径精度

### Fine adjustment of the rolling diameter

- Central adjustment of the diameter range including fine adjustment of the rolling diameter – patent applied
- Fine adjustment by adjusting spindle
- Precise adjustment possible (in range of 0.01 mm)
- High repeatability – reproducibility of pitch diameter at same scale position is  $\pm 0.01\text{ mm}$



### 铁屑防护

- 由于铁屑防护提升了加工安全性
- 防止铁屑和其他的微粒（来自前后工序）进入，即使在离合器打开时

### Chip guard

- Increased process safety due to new chip guard
- Protection from chips and other particles (from pre/post processes) even at opened clutch



### 模块化设计

- 组成：滚轮、滚轮座、滚压系统外壳体、中心精调装置、闭合环、闭合装置和新型接柄
- 闭合环可以360° 旋转并可根据设备具体情况来进行调整
- 冷却驱动闭合装置是可用选项，可非常方便地整合在接柄与离合器之间
- 可换式接柄提供更高的灵活性和效率

### Modular design

- Consisting of: thread rolls, roller cage, rolling system housing incl. central fine adjustment, closing clip resp. closing device and shank with new adaption
- Closing clip revolving full 360° and can be set perfectly to the adaption situation in the machine
- Coolant driven closing device is available optional and can be integrated easily between clutch and shank
- High flexibility and efficiency due to interchangeable shanks

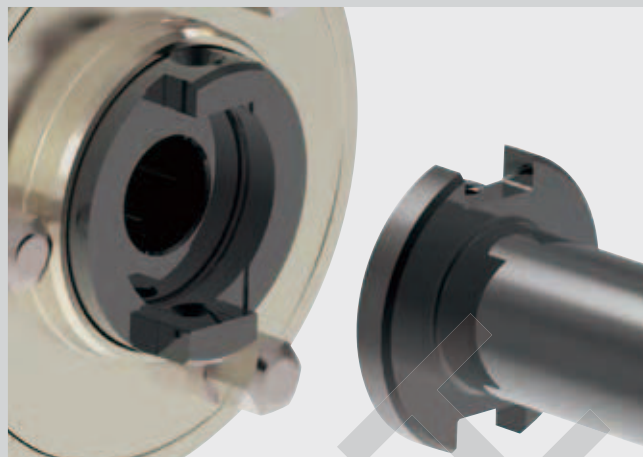


## 新型接柄

- 理想的模块化设计 —— 可加配闭合装置
- 精确的同心率
- 安全的扭矩传递
- 组装便利
- 标准品覆盖了大部分接柄尺寸范围，保证了高灵活性

## New shank adaption

- The ideal modular design – optional closing device can be integrated
- Precise concentricity
- Safe torque transmission
- Easy assembly
- High flexibility due to a wide range of standard shank sizes



## 组装便利

- 标记的安装起始位置提升安装安全性
- 在齿轮端面的标记避免了安装错误
- 在不同的角度都已明确安装位置



## Easy assembly

- High process safety due to defined mounting position
- Additional marking on gears for error-free assembly
- Defined mounting position of the clutch due to different angle

## 闭合手柄

- 无限的调整可能
- 360° 调整范围
- 可完美地匹配设备刀具的情况进行调节
- 可用多种不同类型的结构方式（闭合轮，闭合杆）

## Closing clip

- Infinitely adjustable
- Adjustable range 360°
- Perfect set-up to suit machine tool requirements
- Interface for different fastening elements (closing roller, closing pin) available



关于EVOLine的更多信息，例如：产品视频。  
请登录 [www.lmt-tools.com/EVOLine](http://www.lmt-tools.com/EVOLine) 或者扫描右侧二维码！



More information about our EVOLine, such as product video are available under [www.lmt-tools.com/EVOLine](http://www.lmt-tools.com/EVOLine) – or just scan the QR code!



蓝帜菲特滚压头在滚压螺纹或所要求的其他外形后会自动打开。在滚压下一个螺纹前必须恢复工作位置，意为必须保持闭合状态。

闭合手柄是完全重新设计的，作为标准品，其灵活性为用户提供更好的体验式布局设计，确保实现滚压头的闭合工作。

另一个显著的优化是可以通过新的EVOLine闭合装置(CCD)来实现闭合过程。安装在滚压头和接柄之间，通过冷却液的压力实现闭合，闭合过程不占用机床加工节拍。

机床可以通过简单的功能整合使闭合装置可以通过冷却液或者压缩空气进行驱动的目的。

简单、安全和快捷。

LMT Fette rolling heads generate the thread or required form and then open automatically after rolling. Before the next thread can be rolled the head has to be put back into working position, means the head must be closed.

The completely new designed closing clip, delivered as standard, already allows an flexible and user friendly layout of the process for closing the rolling head.

Another significant optimization of the closing process can be realized with the new closing device (CCD) for EVOLine. Adapted between rolling head and shank and connected with the coolant supply, closing of the rolling head can be transferred from process time to the non-productive time of the machine.

Closing by coolant (or even compressed air) can be integrated in the machine program by a simple function.

Easy, safe and fast.



- 由于EVOLine的模块化设计，闭合装置可以简便地配置在滚压头和接柄之间
- 所有之前的异形接柄仍然可选

- Because of the modular design of EVOLine the closing device can be easily integrated between head and shank
- All shank variants still can be used



- 闭合装置可以被任何冷却液和压缩空气驱动
- 工作所需压力范围为8 – 16bar

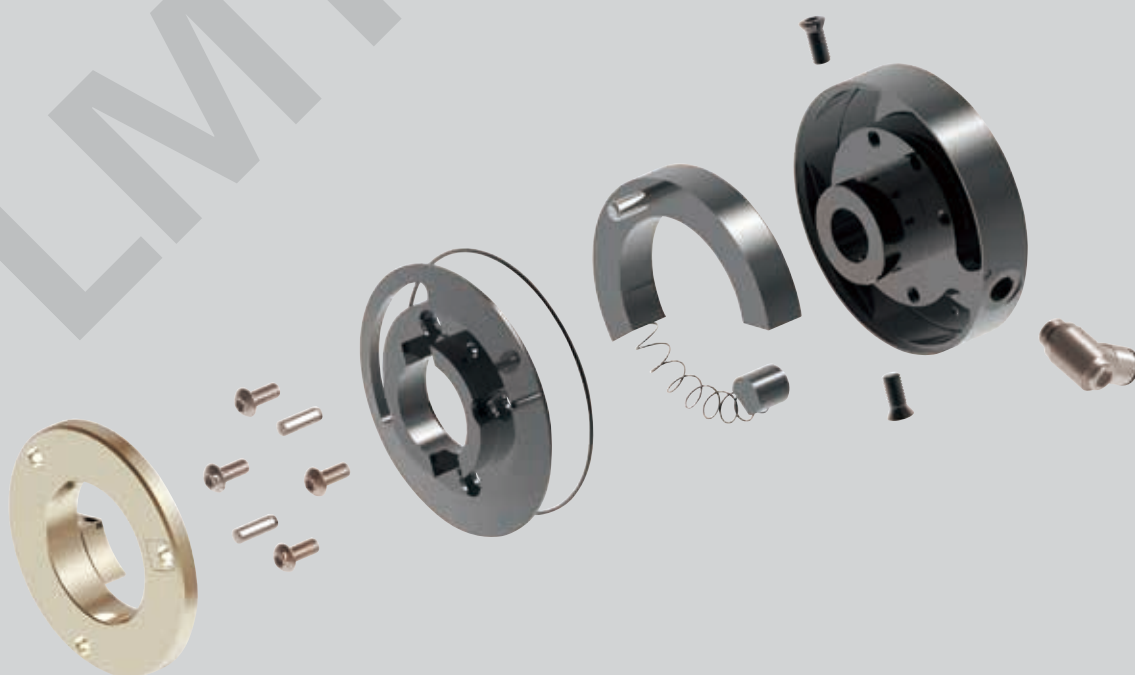
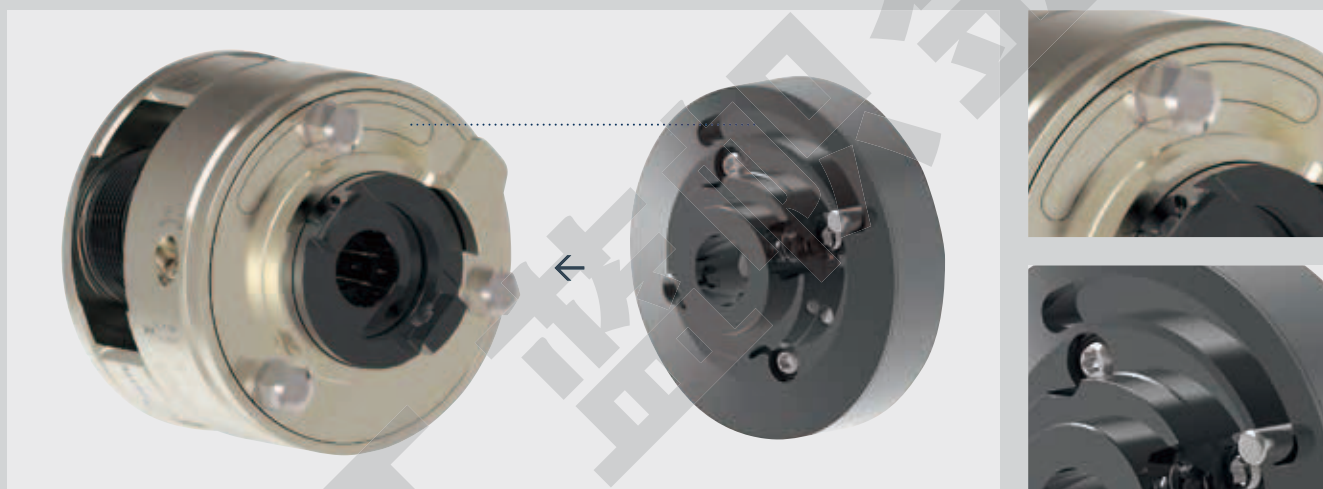
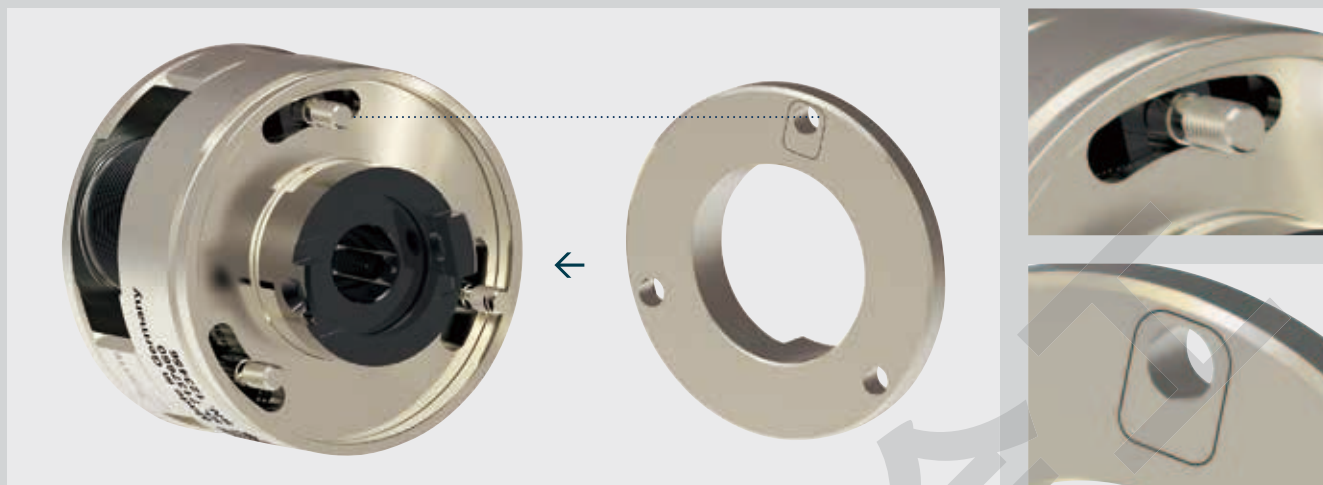
- The closing device can be operated with any coolant and also with compressed air
- The working pressure is at range from 8 – 16 bar



- 交付的标准包装是一个完整的包:闭合装置旁边有一个特殊的铁屑防护后盖板,连接件和一个高压接头
- Delivered in standard is a complete starter package: beside the closing device there is a special chip guard, different connecting elements and a pressure hose

■ 带有标记的安装位置以及防屑壳上一一对应的标记位置确保了更高的加工安全性和组装便利性

■ High process safety and easy assembly due to defined mounting position and one-to-one marking at chip guard



| 型号<br>Type | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
|------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
| F1 EVO     | 7146300          |  |  |  |  |  |  |  |  |  |  |  |  |
| F1L EVO    | 7169593          |  |  |  |  |  |  |  |  |  |  |  |  |
| K1 EVO     | 7169594          |  |  |  |  |  |  |  |  |  |  |  |  |
| K1L EVO    | 7169595          |  |  |  |  |  |  |  |  |  |  |  |  |

| 尺寸单位为毫米 |        | Dimension in inches |        |    |        |        |        |        |        |        |          |          |  |
|---------|--------|---------------------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|--|
| D       | D1max  | D2                  | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |  |
| 64      | 70     | 17                  | 66     | M5 | 11,4   | 61     | 6      | 3,5    | 38,3   | 2      | 60°      | 3° 30'   |  |
| 2.520"  | 2.756" | 0.669"              | 2.598" |    | 0.449" | 2.402" | 0.236" | 0.138" | 1.508" | 0.079" |          |          |  |

F1 EVO, K1 EVO右手螺纹用 for right-hand threads  
 F1L EVO, K1L EVO左手螺纹用 for left-hand threads  
 F1 EVO, F1L EVO仅在滚压头静止的工况中使用 to be used stationary only  
 K1 EVO, K1L EVO在滚压头静止或回转的工况中使用 used stationary or rotating

|  | m-Rk                   | m-Ro                           |
|--|------------------------|--------------------------------|
|  | 约0,9 kg<br>近似等于1.98 lb | 0,105–0,155 kg<br>0.23–0.34 lb |

a = 开启时前移量 Pull off for opening  
 b = 对于F型, 滚压头闭合 Head closes when type F  
 c = 对于F型, 滚压头开启 Head opens when type F  
 d = 滚压头闭合 Rolling head closed  
 e = 滚压头开启 Rolling head opened  
 f = 静止状态下操作时的手柄螺纹。Thread for hand grip with stationary operation.  
 $\alpha$  = 闭合角度 Closing angle  
 $\gamma$  = 滚轮的倾斜位置 Inclined position of rolls  
 m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls  
 m-Ro = 1套/3个滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

| 型号<br>Type   | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
|--------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
| R20-规格 1     | 7139594          |  |  |  |  |  |  |  |  |  |  |  |  |
| R25-规格 1     | 7139596          |  |  |  |  |  |  |  |  |  |  |  |  |
| R 3/4-规格 1   | 7139598          |  |  |  |  |  |  |  |  |  |  |  |  |
| R 1-规格 1     | 7139600          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1 1/4-规格 1  | 7139602          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-20-规格 1  | 7139604          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-25-规格 1  | 7139606          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-30-规格 1  | 7139608          |  |  |  |  |  |  |  |  |  |  |  |  |
| HSK-A63-规格 1 | 7139610          |  |  |  |  |  |  |  |  |  |  |  |  |

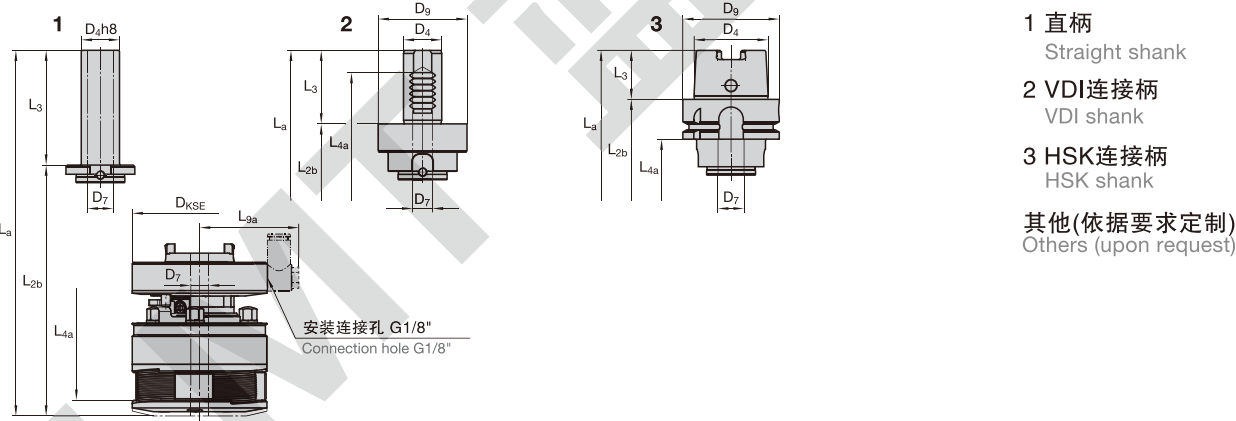
| 连接柄直径<br>Shank dia. | 尺寸单位为毫米        | Dimension in inches |             |             |                |                |               |                |             |  |  |  |  |
|---------------------|----------------|---------------------|-------------|-------------|----------------|----------------|---------------|----------------|-------------|--|--|--|--|
|                     | D4             | D7                  | D9          | DKSE        | L              | La             | L2            | L2b            | L3          |  |  |  |  |
| 20                  | 20   0.787"    | 11,4   0.449"       | —           | 73   2.874" | 121   4.764"   | 152   5.984"   | 61   2.402"   | 92   3.622"    | 60   2.362" |  |  |  |  |
| 25                  | 25   0.984"    | 11,4   0.449"       | —           | 73   2.874" | 121   4.764"   | 152   5.984"   | 61   2.402"   | 92   3.622"    | 60   2.362" |  |  |  |  |
| 3/4                 | 19,05   0.750" | 11,4   0.449"       | —           | 73   2.874" | 121   4.764"   | 152   5.984"   | 61   2.402"   | 92   3.622"    | 60   2.362" |  |  |  |  |
| 1                   | 25,4   1.000"  | 11,4   0.449"       | —           | 73   2.874" | 121   4.764"   | 152   5.984"   | 61   2.402"   | 92   3.622"    | 60   2.362" |  |  |  |  |
| 1 1/4               | 31,75   1.250" | 11,4   0.449"       | —           | 73   2.874" | 121   4.764"   | 152   5.984"   | 61   2.402"   | 92   3.622"    | 60   2.362" |  |  |  |  |
| VDI-20              | 20   0.787"    | 11,4   0.449"       | 50   1.969" | 73   2.874" | 125   4.921"   | 156   6.142"   | 85   3.347"   | 116   4.567"   | 40   1.575" |  |  |  |  |
| VDI-25              | 25   0.984"    | 11,4   0.449"       | 58   2.283" | 73   2.874" | 133   5.236"   | 164   6.457"   | 85   3.347"   | 116   4.567"   | 48   1.890" |  |  |  |  |
| VDI-30              | 30   1.181"    | 11,4   0.449"       | 68   2.677" | 73   2.874" | 140,5   5.532" | 171,5   6.752" | 85,5   3.366" | 116,5   4.587" | 55   2.165" |  |  |  |  |
| HSK-A63             | 48   1.890"    | 11,4   0.449"       | 63   2.480" | 73   2.874" | 132   5.197"   | 163   6.417"   | 100   3.937"  | 131   5.158"   | 32   1.260" |  |  |  |  |

相应紧固螺钉(2 x 7211620)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211620).



| 冷却液驱动的闭合装置<br>Coolant operating closing device |            |                                           | KSE   CCD<br>规格1       |
|------------------------------------------------|------------|-------------------------------------------|------------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                  | 订货号<br>Ident No.       |
| 1                                              | 1          | 壳体<br>Housing                             | 7154981                |
| 2                                              | 1          | 罩板<br>Cover plate                         | 7154982                |
| 3                                              | 1          | 曲型活塞<br>Curved piston                     | 7154983                |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                       | 7154978                |
| 5                                              | 1          | 防屑罩<br>Chip guard                         | 7154975                |
| 6                                              | 1          | 密封圈<br>Ring sealing                       | 7154976                |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                   | 7154977                |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2142677                |
| 9                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2143287                |
| 10                                             | 4          | 螺钉<br>Screw                               | 7123889                |
| 11                                             | 1          | L- 与I-G1/8" 管接头<br>L- and I-Fitting G1/8" | 7167804-L<br>7167806-I |
| 12                                             | 2          | 螺钉<br>Screw                               | 7211620                |

| 型号<br>Type      | 订货号<br>Ident No. |
|-----------------|------------------|
| 1号规格KSE EVOLine | 7154980          |



| L <sub>4</sub>  | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub> | m-Rs                 |
|-----------------|-----------------|----------------|----------------|-----------------|-----------------|----------------------|
| —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,13 kg 近似等于0.29 lb |
| —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,21 kg 近似等于0.46 lb |
| —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,12 kg 近似等于0.27 lb |
| —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,22 kg 近似等于0.49 lb |
| —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,35 kg 近似等于0.77 lb |
| 78,5   3.091 "  | 109,5   4.311 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,41 kg 近似等于0.90 lb |
| 113,5   4.469 " | 144,5   5.689 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,57 kg 近似等于1.26 lb |
| 120,5   4.744 " | 151,5   5.965 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,82 kg 近似等于1.81 lb |
| 66   2.598 "    | 97   3.819 "    | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,76 kg 近似等于1.68 lb |

m-Rs = 连接柄重量    Weight shank



| M                               |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| M 6 ... 8 x 1                   | 1504564         | 1504573         |
| M 8 ... 9 x 1,25                | 1504653         | 1504671         |
| M 10 ... 10 x 1,5               | 1504715         | 1504724         |

| MF                              |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| MF 6 ... 8 x 0,75               | 7180387         | 7180385         |
| MF 8 ... 10 x 1                 | 1504813         | 1504822         |
| MF 10 ... 11 x 1,25             | 1505000         | 1505019         |

| UNC                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| UNC 1/4 - 20                   | 1505545         | 1505554         |
| UNC 5/16 - 18                  | 1505563         | 1505572         |
| UNC 3/8 - 16                   | 1505581         | 1505590         |
| UNC 7/16 <sup>1)</sup> - 14    | 2166949         | 2166784         |

| UNF                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| UNF 1/4 - 28                   | 1505625         | 1505634         |
| UNF 5/16... 3/8 - 24           | 7180380         | 7180381         |
| UNF 7/16 <sup>1)</sup> - 20    | 2241471         | 2169909         |

| BSF                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| BSF 1/4 - 26                   | 1505304         | 1505313         |
| BSF 5/16 - 22                  | 1505322         | 1505331         |
| BSF 3/8 - 20                   | 1505359         | 1505368         |
| BSF 7/16 <sup>1)</sup> - 20    | 2241469         | 2241470         |

| 公称尺寸x节距<br>Nominal size x pitch<br>mm   inch 英寸  | RAA     | RGE     |
|--------------------------------------------------|---------|---------|
|                                                  | 订货号     |         |
| Ø 6 ... Ø 8 x 0,5   Ø 0.236 ... Ø 0.315 x 0.02   | 1505901 | 1506205 |
| Ø 8 ... Ø 10 x 0,5   Ø 0.315 ... Ø 0.394 x 0.02  | 2168750 | 1506214 |
| Ø 6 ... Ø 8 x 0,6   Ø 0.236 ... Ø 0.315 x 0.024  | 1505910 | 1506223 |
| Ø 8 ... Ø 10 x 0,6   Ø 0.315 ... Ø 0.394 x 0.024 | 1505929 | 1506232 |
| Ø 6 ... Ø 8 x 0,8   Ø 0.236 ... Ø 0.315 x 0.031  | 1505947 | 1506241 |
| Ø 8 ... Ø 10 x 0,8   Ø 0.315 ... Ø 0.394 x 0.031 | 1505956 | 1506250 |
| Ø 6 ... Ø 8 x 1,0   Ø 0.236 ... Ø 0.315 x 0.039  | 1505965 | 1506269 |
| Ø 8 ... Ø 10 x 1,0   Ø 0.315 ... Ø 0.394 x 0.039 | 1505983 | 1506278 |
| Ø 6 ... Ø 8 x 1,2   Ø 0.236 ... Ø 0.315 x 0.047  | 1505992 | 1506287 |
| Ø 8 ... Ø 10 x 1,2   Ø 0.315 ... Ø 0.394 x 0.047 | 1506009 | 1506296 |
| Ø 6 ... Ø 8 x 1,5   Ø 0.236 ... Ø 0.315 x 0.059  | 1506027 | 1506312 |
| Ø 8 ... Ø 10 x 1,5   Ø 0.315 ... Ø 0.394 x 0.059 | 1506036 | 1506321 |
| Ø 7 ... Ø 8 x 1,6   Ø 0.276 ... Ø 0.315 x 0.063  | 2242104 | 2242108 |
| Ø 8 ... Ø 10 x 1,6   Ø 0.315 ... Ø 0.394 x 0.063 | 2242105 | 2242109 |
| Ø 7 ... Ø 8 x 2,0   Ø 0.276 ... Ø 0.315 x 0.079  | 2242106 | 2242110 |
| Ø 8 ... Ø 10 x 2,0   Ø 0.315 ... Ø 0.394 x 0.079 | 2242107 | 2242111 |

| 公称尺寸<br>Nominal size<br>mm   inch 英寸 | 订货号<br>Ident No. |
|--------------------------------------|------------------|
| Ø 6 - Ø 8   Ø 0.236 - Ø 0.315        | 1506330          |
| Ø 7 - Ø 10   Ø 0.276 - Ø 0.394       | 1506349          |

| BSW                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| BSW 1/4 - 20                   | 1505215         | 1505224         |
| BSW 5/16 - 18                  | 1505233         | 1505242         |
| BSW 3/8 - 16                   | 1505279         | 1505288         |

| NPT                            |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
|                                | 订货号             |
| NPT 1/16 - 27                  | 1506964         |
| NPT 1/8 - 27                   | 1506973         |

| NPTF                           |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
|                                | 订货号             |
| NPTF 1/16 - 27                 | 2248946         |
| NPTF 1/8 - 27                  | 2245597         |

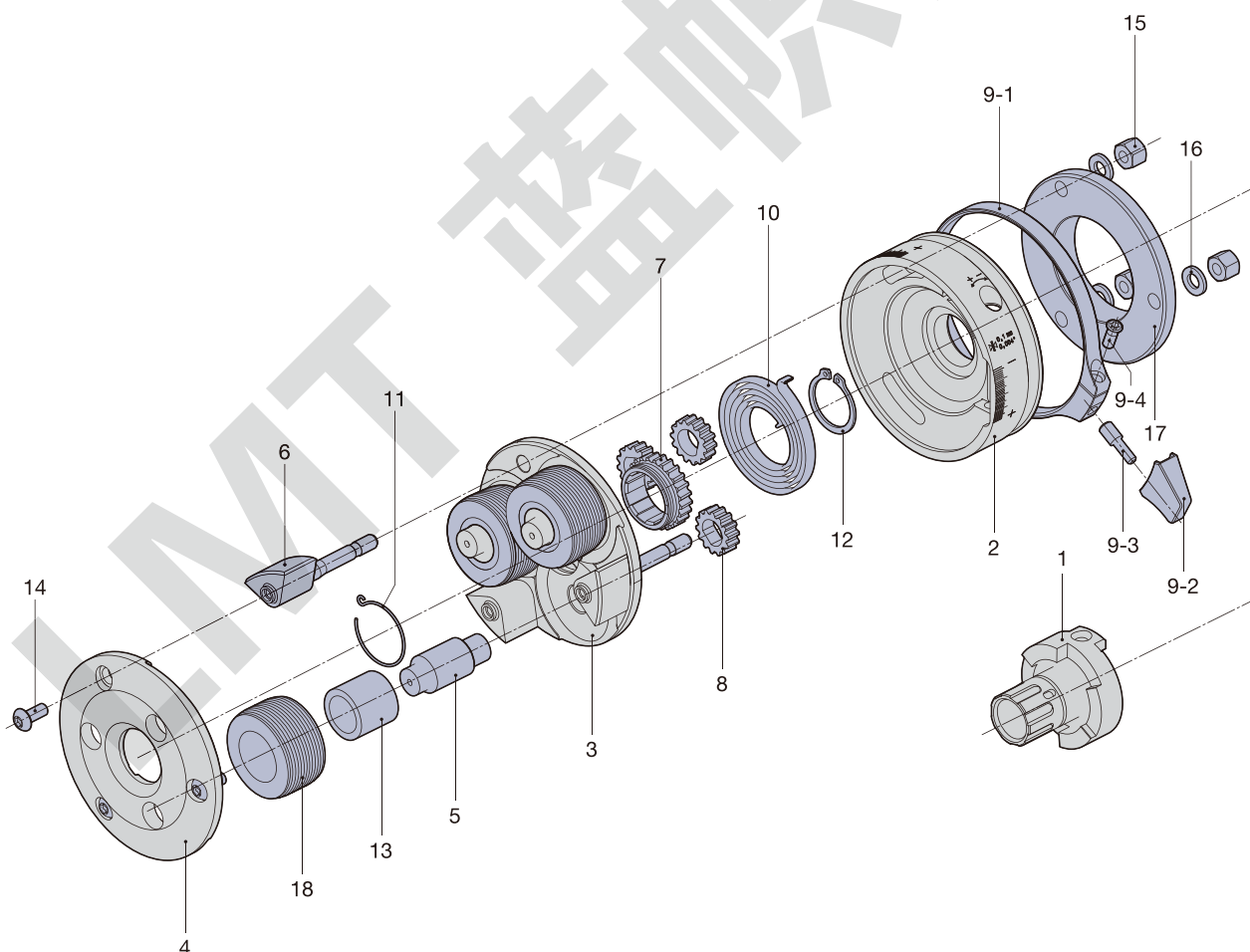
同一栏内螺纹尺寸可使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

<sup>1)</sup>适用于14 mm | 0.551"以内的短螺纹，含退刀槽。  
For short threads up to 14 mm | 0.551" including runout.

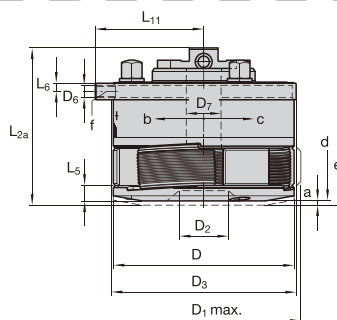


| 滚压头<br>Rolling head |            |                                 | F1 EVO           | 滚压头<br>Rolling head |            |                               | F1 EVO           |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7146301          | 9-3                 | 1          | 螺纹销<br>Threaded pin           | 7146299          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7146302          | 9-4                 | 1          | 螺钉<br>Screw                   | 1045105          |
| 3                   | 1          | 中心板<br>Center plate             | 7146303          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 7146310          |
| 4                   | 1          | 前板<br>Front plate               | 7146304          | 11                  | 1          | 卡簧<br>Circlip                 | 2164642          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2164637          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7130049          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7146306          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2164705          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7146307          | 14                  | 3          | 螺钉<br>Screw                   | 7123889          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7146309          | 15                  | 3          | 螺母<br>Cover nut               | 2148397          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7146296          | 16                  | 3          | 垫圈<br>Washer                  | 2143364          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7146297          | 17                  | 1          | 防屑罩<br>Chip guard             | 7146305          |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7146298          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |





| 型号<br>Type | 订货号<br>Ident No. |
|------------|------------------|
| F12 EVO    | 7156343          |
| F12L EVO   | 7169596          |
| K12 EVO    | 7169597          |
| K12L EVO   | 7169598          |



尺寸单位为毫米 Dimension in inches

| D      | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |
|--------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|
| 64     | 70     | 20     | 66     | M5 | 11,4   | 62,1   | 6      | 3,5    | 38,3   | 2      | 60°      | 1° 50'   |
| 2.520" | 2.756" | 0.787" | 2.598" |    | 0.449" | 2.445" | 0.236" | 0.138" | 1.508" | 0.079" |          |          |

F12 EVO, K12 EVO右手螺纹用 for right-hand threads

F12L EVO, K12L EVO 左手螺纹用 for left-hand threads

F12 EVO, F12L EVO仅在滚压头静止的工况中使用 to be used stationary only

K12 EVO, K12L EVO在滚压头静止或回转的工况中使用 used stationary or rotating

| m-Rk                        | m-Ro                                 |
|-----------------------------|--------------------------------------|
| 约0,82 kg<br>近似等于<br>1.81 lb | 0,07–0,13 kg<br>近似等于<br>0.15–0.29 lb |

a = 开启时出料 Pull off for opening

b = 对于F型, 滚压头闭合 Head closes when type F

c = 对于F型, 滚压头开启 Head opens when type F

d = 滚压头闭合 Rolling head closed

e = 滚压头开启 Rolling head opened

f = 静止状态下操作时的手柄螺纹. Thread for hand grip with stationary operation.

$\alpha$  = 闭合角度 Closing angle

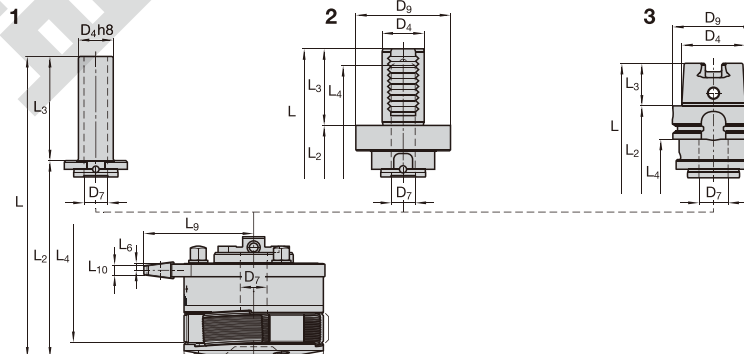
$\gamma$  = 滚轮的倾斜位置 Inclined position of rolls

m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls

m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

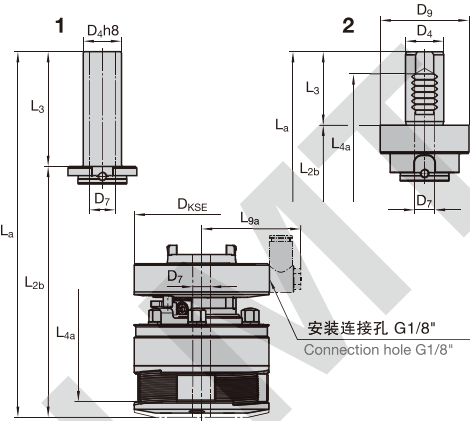
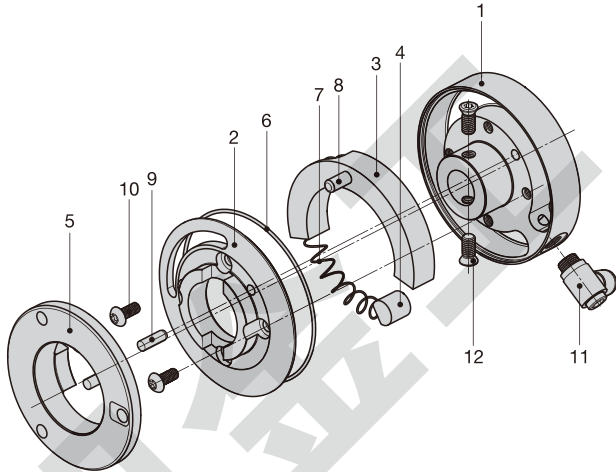
| 型号<br>Type   | 订货号<br>Ident No. |
|--------------|------------------|
| R20-规格 1     | 7139594          |
| R25-规格 1     | 7139596          |
| R 3/4-规格 1   | 7139598          |
| R 1-规格 1     | 7139600          |
| R 1 1/4-规格 1 | 7139602          |
| VDI-20-规格 1  | 7139604          |
| VDI-25-规格 1  | 7139606          |
| VDI-30-规格 1  | 7139608          |
| HSK-A63-规格 1 | 7139610          |



| 连接柄直径<br>Shank dia. | 尺寸单位为毫米 Dimension in inches |               |             |             |                |                |                |                |             |  |  |  |
|---------------------|-----------------------------|---------------|-------------|-------------|----------------|----------------|----------------|----------------|-------------|--|--|--|
|                     | D4                          | D7            | D9          | DKSE        | L              | La             | L2             | L2b            | L3          |  |  |  |
| 20                  | 20   0.787"                 | 11,4   0.449" | —           | 73   2.874" | 122,1   4.807" | 153,1   6.028" | 62,1   2.449"  | 93,1   3.665"  | 60   2.362" |  |  |  |
| 25                  | 25   0.984"                 | 11,4   0.449" | —           | 73   2.874" | 122,1   4.807" | 153,1   6.028" | 62,1   2.449"  | 93,1   3.665"  | 60   2.362" |  |  |  |
| 3/4                 | 19,05   0.750"              | 11,4   0.449" | —           | 73   2.874" | 122,1   4.807" | 153,1   6.028" | 62,1   2.449"  | 93,1   3.665"  | 60   2.362" |  |  |  |
| 1                   | 25,4   1.000"               | 11,4   0.449" | —           | 73   2.874" | 122,1   4.807" | 153,1   6.028" | 62,1   2.449"  | 93,1   3.665"  | 60   2.362" |  |  |  |
| 1 1/4               | 31,75   1.250"              | 11,4   0.449" | —           | 73   2.874" | 122,1   4.807" | 153,1   6.028" | 62,1   2.449"  | 93,1   3.665"  | 60   2.362" |  |  |  |
| VDI-20              | 20   0.787"                 | 11,4   0.449" | 50   1.969" | 73   2.874" | 126,1   4.965" | 157,1   6.185" | 86,1   3.390"  | 117,1   4.610" | 40   1.575" |  |  |  |
| VDI-25              | 25   0.984"                 | 11,4   0.449" | 58   2.283" | 73   2.874" | 134,1   5.280" | 165,1   6.500" | 86,1   3.390"  | 117,1   4.610" | 48   1.890" |  |  |  |
| VDI-30              | 30   1.181"                 | 11,4   0.449" | 68   2.677" | 73   2.874" | 141,6   5.575" | 172,6   6.795" | 86,6   3.410"  | 117,6   4.630" | 55   2.165" |  |  |  |
| HSK-A63             | 48   1.890"                 | 11,4   0.449" | 63   2.480" | 73   2.874" | 133,1   5.240" | 164,1   6.461" | 101,1   3.980" | 132,1   5.201" | 32   1.260" |  |  |  |

相应紧固螺钉(2 x 7211620)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211620).

| 冷却剂驱动的闭合装置<br>Coolant operating closing device |            |                                           | KSE   CCD<br>规格1       |
|------------------------------------------------|------------|-------------------------------------------|------------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                  | 订货号<br>Ident No.       |
| 1                                              | 1          | 壳体<br>Housing                             | 7154981                |
| 2                                              | 1          | 罩板<br>Cover plate                         | 7154982                |
| 3                                              | 1          | 曲型活塞<br>Curved piston                     | 7154983                |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                       | 7154978                |
| 5                                              | 1          | 防屑罩<br>Chip guard                         | 7154975                |
| 6                                              | 1          | 密封圈<br>Ring sealing                       | 7154976                |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                   | 7154977                |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2142677                |
| 9                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2143287                |
| 10                                             | 4          | 螺钉<br>Screw                               | 7123889                |
| 11                                             | 1          | L- 与I-G1/8" 管接头<br>L- and I-Fitting G1/8" | 7167804-L<br>7167806-I |
| 12                                             | 2          | 螺钉<br>Screw                               | 7211620                |



- 1 直柄  
Straight shank
- 2 VDI连接柄  
VDI shank
- 3 HSK连接柄  
HSK shank
- 其他(依据要求定制)  
Others (upon request)

|  | L <sub>4</sub>  | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub> | m-Rs                 |
|--|-----------------|-----------------|----------------|----------------|-----------------|-----------------|----------------------|
|  | —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,13 kg 近似等于0.29 lb |
|  | —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,21 kg 近似等于0.46 lb |
|  | —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,12 kg 近似等于0.27 lb |
|  | —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,22 kg 近似等于0.49 lb |
|  | —               | —               | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,35 kg 近似等于0.77 lb |
|  | 79,6   3.134 "  | 110,6   4.354 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,41 kg 近似等于0.90 lb |
|  | 114,6   4.512 " | 145,6   5.732 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,57 kg 近似等于1.26 lb |
|  | 121,6   4.787 " | 152,6   6.008 " | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,82 kg 近似等于1.81 lb |
|  | 67,1   2.642 "  | 98,1   3.862 "  | 3,5   0.138 "  | 52,8   2.079 " | 订制 Individual   | 5   0.197 "     | 约0,76 kg 近似等于1.68 lb |

m-Rs = 连接柄重量 Weight shank



| MF                                    |                 |                 |
|---------------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch<br>mm | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                   |                 |                 |
| MF 6 ... 7 x 0,5                      | 1507516         | 1507525         |
| MF 7 ... 8 x 0,5                      | 1507534         | 1507543         |
| MF 6 ... 7 x 0,75                     | 1507605         | 1507614         |
| MF 8 ... 9 x 0,75                     | 1507632         | 1507641         |
| MF 9 ... 10 x 0,75                    | 1507669         | 1507678         |
| MF 10 ... 11 x 0,75                   | 1507703         | 1507712         |
| MF 11 ... 12 x 0,75                   | 1507721         | 1507730         |
| MF 8 ... 9 x 1                        | 1507767         | 1507776         |
| MF 9 ... 10 x 1                       | 1507785         | 1507794         |
| MF 10 ... 11 x 1                      | 1507838         | 1507847         |
| MF 11 ... 12 x 1 <sup>1)</sup>        | 1507865         | 1507874         |
| MF 10 ... 11 x 1,25 <sup>1)</sup>     | 1507892         | 1507909         |
| MF 11 ... 12 x 1,25 <sup>1)</sup>     | 1507918         | 1507927         |
| MF 12 ... 12 x 1,5 <sup>1)</sup>      | 1507963         | 1507972         |

| UN UNF UNEF UNS                      |                 |                 |
|--------------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI       | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                  |                 |                 |
| UNS 1/4 ... 5/16 - 40                | 2241721         | 2169907         |
| UNF 5/16 ... 3/8 - 36                | 2242136         | 2242137         |
| UNF 7/16 - 36                        | 2242138         | 2242139         |
| UNEF 5/16 ... 3/8 - 32               | 1508105         | 1508114         |
| UN 3/8 ... 7/16 - 32                 | 2242122         | 2242123         |
| UNF 7/16 ... 1/2 <sup>1)</sup> - 32  | 2242140         | 2242141         |
| UNF 3/8 ... 7/16 - 28                | 2242142         | 2242143         |
| UNEF 7/16 ... 1/2 <sup>1)</sup> - 28 | 1508123         | 1508132         |
| UNF 7/16 ... 1/2 <sup>1)</sup> - 26  | 2242144         | 2242145         |
| UNS 3/8 ... 7/16 - 24                | 2167553         | 1508150         |
| UNS 7/16 ... 1/2 <sup>1)</sup> - 24  | 1508203         | 2242147         |
| UNF 7/16 ... 1/2 <sup>1)</sup> - 22  | 2242146         | 2242148         |
| UNF 7/16 ... 1/2 <sup>1)</sup> - 20  | 1508178         | 1508187         |

| G                              |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                            |                 |                 |
| G 1/8 - 28                     | 1508052         | 1508061         |
| G 1/4 - 19 <sup>1)</sup>       | 1508089         | 1508098         |

| BSFS                                 |                 |                 |
|--------------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI       | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                  |                 |                 |
| BSFS 1/4 ... 5/16 - 32               | 2242112         | 2242113         |
| BSFS 5/16 ... 3/8 - 26               | 2242114         | 2242115         |
| BSFS 5/16 ... 3/8 - 32               | 2242118         | 2242119         |
| BSFS 7/16 ... 1/2 <sup>1)</sup> - 26 | 2242126         | 2242127         |
| BSFS 7/16 ... 1/2 <sup>1)</sup> - 20 | 2242134         | 2242135         |

| NPT                            |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
| 订货号                            |                 |
| NPT 1/8 - 27                   | 2164716         |
| NPT 1/4 - 18                   | 2167396         |

| NPTF                           |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
| 订货号                            |                 |
| NPTF 1/8 - 27                  | 2166823         |
| NPTF 1/4 - 18                  | 2243188         |

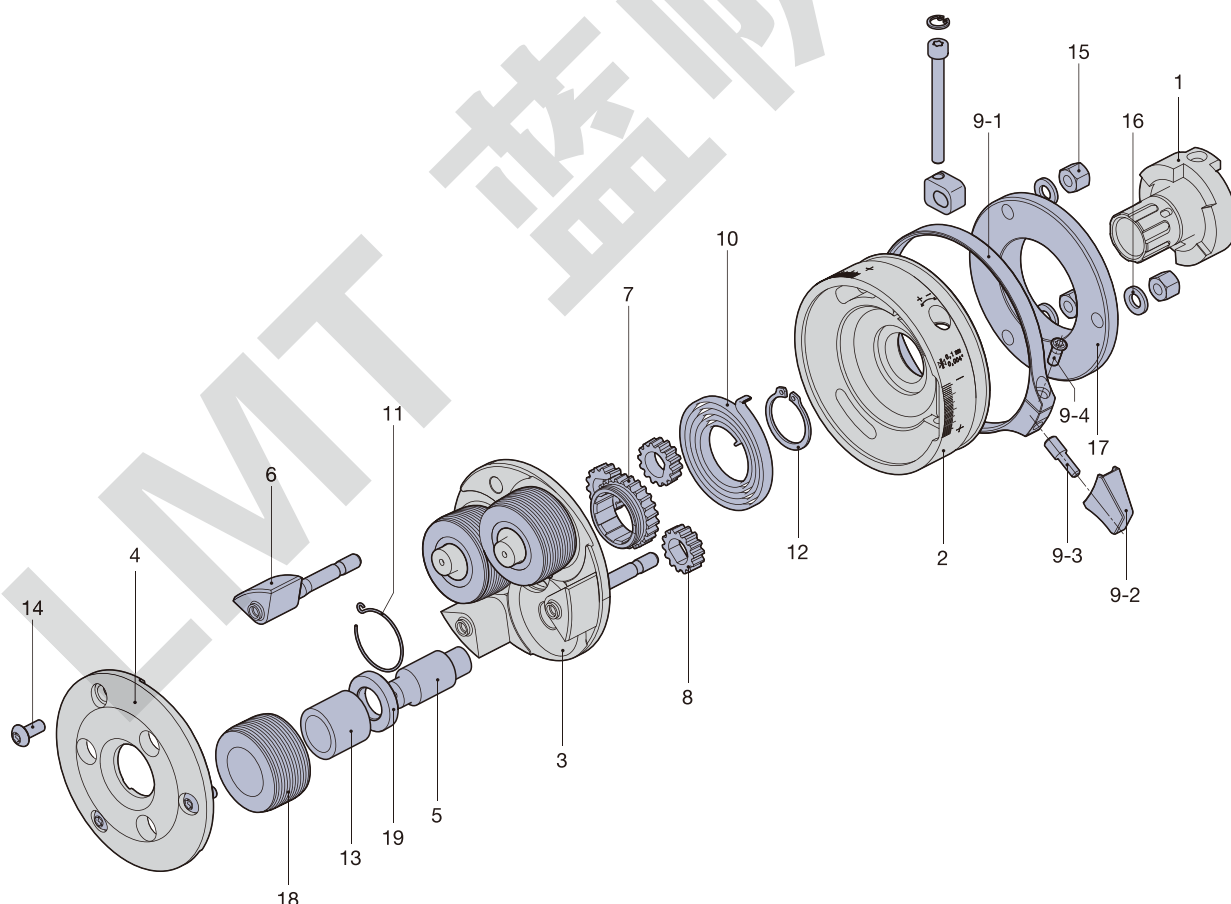
同一栏内螺纹尺寸可以使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

<sup>1)</sup> 适用于14 mm/0.551"以内的短螺纹，含退刀槽。

For short threads up to 14 mm/0.551" including runout.

| 滚压头<br>Rolling head |            |                                 | F12 EVO          | 滚压头<br>Rolling head |            |                               | F12 EVO          |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7146301          | 9-4                 | 1          | 螺钉<br>Screw                   | 1045105          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7146302          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 7146310          |
| 3                   | 1          | 中心板<br>Center plate             | 7156351          | 11                  | 1          | 卡簧<br>Circlip                 | 2164642          |
| 4                   | 1          | 前板<br>Front plate               | 7156350          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7130049          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2164737          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2173512          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7156352          | 14                  | 3          | 螺钉<br>Screw                   | 7123889          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7156356          | 15                  | 3          | 螺母<br>Cover nut               | 2143535          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7156354          | 16                  | 3          | 垫圈<br>Washer                  | 2143364          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7146296          | 17                  | 1          | 防屑罩<br>Chip guard             | 7146305          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7146297          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7146298          | 19                  | 3          | 垫圈<br>Washer                  | 2164741          |
| 9-3                 | 1          | 螺纹销<br>Threaded pin             | 7146299          |                     |            |                               |                  |





|            |                  |  |  |  |  |  |  |  |  |  |  |  |  |
|------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
|            |                  |  |  |  |  |  |  |  |  |  |  |  |  |
| 型号<br>Type | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
| F2 EVO     | 7137660          |  |  |  |  |  |  |  |  |  |  |  |  |
| F2L EVO    | 7159830          |  |  |  |  |  |  |  |  |  |  |  |  |
| K2 EVO     | 7159820          |  |  |  |  |  |  |  |  |  |  |  |  |
| K2L EVO    | 7169599          |  |  |  |  |  |  |  |  |  |  |  |  |

| 尺寸单位为毫米 Dimension in inches |        |        |        |    |        |        |        |        |        |        |     |    |  |
|-----------------------------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|-----|----|--|
| D                           | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | α   | γ  |  |
| 88                          | 93,5   | 24     | 90     | M6 | 17     | 77,5   | 7,5    | 4      | 52,8   | 3      | 60° | 3° |  |
| 3.465"                      | 3.681" | 0.945" | 3.543" |    | 0.669" | 3.051" | 0.295" | 0.158" | 2.079" | 0.118" |     |    |  |

F2 EVO, K2 EVO右手螺纹用 for right-hand threads  
 F2L EVO, K2L EVO左手螺纹用 for left-hand threads  
 F2 EVO, F2L EVO仅在滚压头静止的工况中使用 to be used stationary only  
 K2 EVO, K2L EVO在滚压头静止或回转的工况中使用 used stationary or rotating

|  | m-Rk                   | m-Ro                           |
|--|------------------------|--------------------------------|
|  | 约1,8 kg<br>近似等于3.96 lb | 0,245–0,425 kg<br>0.54–0.94 lb |

a = 开启时出料 Pull off for opening  
 b = 对于F型, 滚压头闭合 Head closes when type F  
 c = 对于F型, 滚压头开启 Head opens when type F  
 d = 滚压头闭合 Rolling head closed  
 e = 滚压头开启 Rolling head opened  
 f = 静止状态下操作时的手柄螺纹. Thread for hand grip with stationary operation.  
 α = 闭合角度 Closing angle  
 γ = 滚轮的倾斜位置 Inclined position of rolls  
 m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls  
 m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

|             |                  |  |  |  |  |  |  |  |  |  |  |  |  |
|-------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
| 型号<br>Type  | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
| R25-规格2     | 7137673          |  |  |  |  |  |  |  |  |  |  |  |  |
| R30-规格2     | 7139612          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1-规格2      | 7139614          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1 1/4-规格2  | 7139616          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1 1/2-规格2  | 7139618          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-25-规格2  | 7139620          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-30-规格2  | 7139622          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-40-规格2  | 7139624          |  |  |  |  |  |  |  |  |  |  |  |  |
| HSK-A63-规格2 | 7139626          |  |  |  |  |  |  |  |  |  |  |  |  |

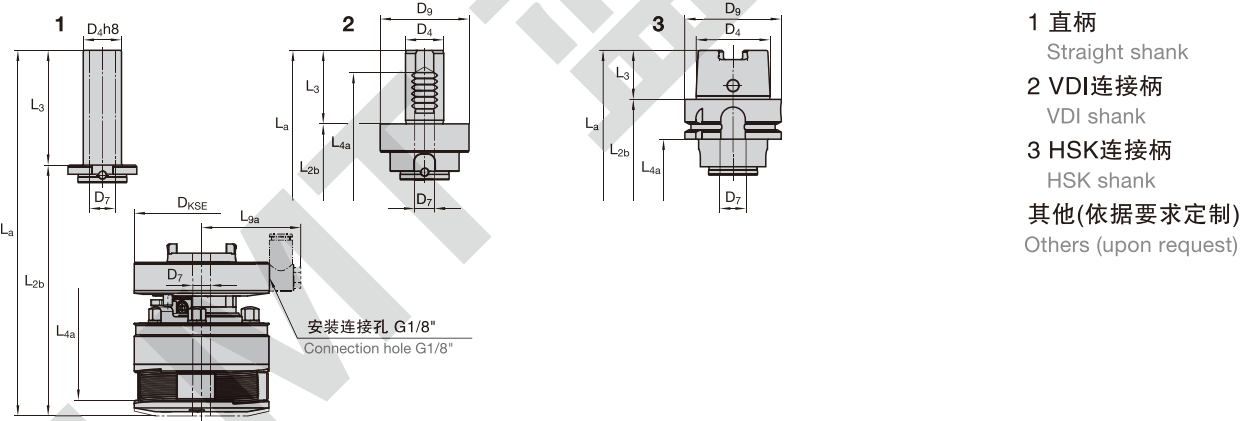
| 连接柄直径<br>Shank dia. | 尺寸单位为毫米 Dimension in inches |             |             |             |                |                |                |                |             |  |  |  |  |
|---------------------|-----------------------------|-------------|-------------|-------------|----------------|----------------|----------------|----------------|-------------|--|--|--|--|
|                     | D4                          | D7          | D9          | DKSE        | L              | La             | L2             | L2b            | L3          |  |  |  |  |
| 25                  | 25   0.984"                 | 17   0.669" | —           | 88   3.465" | 152,5   6.004" | 187,8   7.394" | 77,5   3.051"  | 112,8   4.441" | 75   2.953" |  |  |  |  |
| 30                  | 30   1.181"                 | 17   0.669" | —           | 88   3.465" | 167,5   6.594" | 202,8   7.984" | 77,5   3.051"  | 112,8   4.441" | 90   3.543" |  |  |  |  |
| 1                   | 25,4   1.000"               | 17   0.669" | —           | 88   3.465" | 152,5   6.004" | 187,8   7.394" | 77,5   3.051"  | 112,8   4.441" | 75   2.953" |  |  |  |  |
| 1 1/4               | 31,75   1.250"              | 17   0.669" | —           | 88   3.465" | 167,5   6.594" | 202,8   7.984" | 77,5   3.051"  | 112,8   4.441" | 90   3.543" |  |  |  |  |
| 1 1/2               | 38,1   1.500"               | 17   0.669" | —           | 88   3.465" | 167,5   6.594" | 202,8   7.984" | 77,5   3.051"  | 112,8   4.441" | 90   3.543" |  |  |  |  |
| VDI-25              | 25   0.984"                 | 17   0.669" | 58   2.283" | 88   3.465" | 150,5   5.925" | 185,8   7.315" | 102,5   4.035" | 137,8   5.425" | 48   1.890" |  |  |  |  |
| VDI-30              | 30   1.181"                 | 17   0.669" | 68   2.677" | 88   3.465" | 158   6.220"   | 193,3   7.610" | 103   4.055"   | 138,3   5.445" | 55   2.165" |  |  |  |  |
| VDI-40              | 40   1.575"                 | 17   0.669" | 83   3.268" | 88   3.465" | 166   6.535"   | 201,3   7.925" | 103   4.055"   | 138,3   5.445" | 63   2.480" |  |  |  |  |
| HSK-A63             | 48   1.890"                 | 17   0.669" | 63   2.480" | 88   3.465" | 147,5   5.807" | 182,8   7.197" | 115,5   4.547" | 150,8   5.937" | 32   1.260" |  |  |  |  |

相应紧固螺钉(2 x 7211621)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211621).

1号规格CCD EVOLine备件表  
Spare parts for CCD EVOLine Size 2



| 冷却液驱动的闭合装置<br>Coolant operating closing device |            |                                           | KSE   CCD<br>规格2       | 型号<br>Type         | 订货号<br>Ident No. |
|------------------------------------------------|------------|-------------------------------------------|------------------------|--------------------|------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                  | 订货号<br>Ident No.       | KSE EVOLine Size 2 | 7144712          |
| 1                                              | 1          | 壳体<br>Housing                             | 7144713                |                    |                  |
| 2                                              | 1          | 罩板<br>Cover plate                         | 7144714                |                    |                  |
| 3                                              | 1          | 曲型活塞<br>Curved piston                     | 7144715                |                    |                  |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                       | 7159855                |                    |                  |
| 5                                              | 1          | 防屑罩<br>Chip guard                         | 7151992                |                    |                  |
| 6                                              | 1          | 密封圈<br>Ring sealing                       | 7151997                |                    |                  |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                   | 7170169                |                    |                  |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2142691                |                    |                  |
| 9                                              | 2          | 圆柱销<br>Cylindrical pin                    | 2142675                |                    |                  |
| 10                                             | 4          | 螺钉<br>Screw                               | 7123891                |                    |                  |
| 11                                             | 1          | L- 与I-G1/8" 管接头<br>L- and I-Fitting G1/8" | 7167804-L<br>7167806-I |                    |                  |
| 12                                             | 2          | 螺钉<br>Screw                               | 7211621                |                    |                  |



| L <sub>4</sub> | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub> | m-Rs                 |
|----------------|-----------------|----------------|----------------|-----------------|-----------------|----------------------|
| —              | —               | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,22 kg 近似等于0.49 lb |
| —              | —               | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,41 kg 近似等于0.90 lb |
| —              | —               | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,23 kg 近似等于0.51 lb |
| —              | —               | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,47 kg 近似等于1.04 lb |
| —              | —               | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,71 kg 近似等于1.57 lb |
| 88,5   3.484"  | 123,8   4.874"  | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,63 kg 近似等于0.39 lb |
| 135,5   5.335" | 170,8   6.724"  | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,83 kg 近似等于1.83 lb |
| 138,5   5.453" | 173,8   6.843"  | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约1,40 kg 近似等于3.09 lb |
| 79   3.110"    | 114,3   4.500"  | 4   0.158"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,84 kg 近似等于1.85 lb |

m-Rs = 连接柄重量 Weight shank



| M                               |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| M 8 ... 10 x 1,25               | 1509569         | 1509578         |
| M 10 ... 12 x 1,5               | 1509747         | 1509756         |
| M 12 ... 14 x 1,75              | 1509970         | 1509989         |
| M 14 ... 16 x 2                 | 1510085         | 1510094         |

| MF                              |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| MF 8 ... 10 x 1                 | 1509532         | 1509541         |
| MF 10 ... 12 x 1,25             | 1509676         | 1509685         |
| MF 12 ... 14 x 1,5              | 1509925         | 1509934         |

| UNC                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| UNC 3/8 - 16                   | 1510548         | 1510566         |
| UNC 7/16 - 14                  | 1510575         | 1510584         |
| UNC 1/2 - 13                   | 1510593         | 1510600         |
| UNC 9/16 - 12                  | 1510628         | 1510637         |
| UNC 5/8 - 11                   | 1510646         | 1510655         |

| UNF                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| UNF 5/16... 3/8 - 24           | 1510717         | 1510726         |
| UNF 7/16... 1/2 - 20           | 1510744         | 1510753         |
| UNF 9/16... 5/8 - 18           | 1510762         | 1510771         |

| BSF                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| BSF 5/16 - 22                  | 1510334         | 2240407         |
| BSF 3/8 - 20                   | 1510352         | 1510361         |
| BSF 7/16 - 18                  | 1510370         | 1510389         |
| BSF 1/2... 9/16 - 16           | 7180390         | 7180399         |
| BSF 5/8... 11/16 - 14          | 7180391         | 1510423         |

| 公称尺寸x节距<br>Nominal size x pitch                   | RAA     | RGE     |
|---------------------------------------------------|---------|---------|
| mm   inch 英寸                                      | 订货号     |         |
| Ø 8 ... Ø 10 x 0,5   Ø 0.315 ... Ø 0.394 x 0.02   | 2169065 | 2242649 |
| Ø 10 ... Ø 12 x 0,5   Ø 0.394 ... Ø 0.472 x 0.02  | 2168390 | 2242650 |
| Ø 12 ... Ø 14 x 0,5   Ø 0.472 ... Ø 0.551 x 0.02  | 2169722 | 2242651 |
| Ø 14 ... Ø 16 x 0,5   Ø 0.551 ... Ø 0.63 x 0.02   | 2165306 | 2242652 |
| Ø 8 ... Ø 10 x 0,6   Ø 0.315 ... Ø 0.394 x 0.024  | 2168916 | 2242653 |
| Ø 10 ... Ø 12 x 0,6   Ø 0.394 ... Ø 0.472 x 0.024 | 2165181 | 2242654 |
| Ø 12 ... Ø 14 x 0,6   Ø 0.472 ... Ø 0.551 x 0.024 | 2240175 | 1511119 |
| Ø 14 ... Ø 16 x 0,6   Ø 0.551 ... Ø 0.63 x 0.024  | 1510904 | 2242655 |
| Ø 8 ... Ø 10 x 0,8   Ø 0.315 ... Ø 0.394 x 0.031  | 2242640 | 1511128 |
| Ø 10 ... Ø 12 x 0,8   Ø 0.394 ... Ø 0.472 x 0.031 | 1510913 | 1511137 |
| Ø 12 ... Ø 14 x 0,8   Ø 0.472 ... Ø 0.551 x 0.031 | 2168836 | 1511146 |
| Ø 14 ... Ø 16 x 0,8   Ø 0.551 ... Ø 0.63 x 0.031  | 1510922 | 1511155 |
| Ø 8 ... Ø 10 x 1,0   Ø 0.315 ... Ø 0.394 x 0.039  | 1510931 | 1511173 |
| Ø 10 ... Ø 12 x 1,0   Ø 0.394 ... Ø 0.472 x 0.039 | 1510940 | 1511182 |
| Ø 12 ... Ø 14 x 1,0   Ø 0.472 ... Ø 0.551 x 0.039 | 1510959 | 1511191 |
| Ø 14 ... Ø 16 x 1,0   Ø 0.551 ... Ø 0.63 x 0.039  | 1510968 | 1511208 |
| Ø 8 ... Ø 10 x 1,2   Ø 0.315 ... Ø 0.394 x 0.047  | 2168835 | 2242656 |
| Ø 10 ... Ø 12 x 1,2   Ø 0.394 ... Ø 0.472 x 0.047 | 1510986 | 2167590 |
| Ø 12 ... Ø 14 x 1,2   Ø 0.472 ... Ø 0.551 x 0.047 | 1510995 | 2168410 |
| Ø 14 ... Ø 16 x 1,2   Ø 0.551 ... Ø 0.63 x 0.047  | 1511002 | 1511217 |
| Ø 8 ... Ø 10 x 1,5   Ø 0.315 ... Ø 0.394 x 0.059  | 2168834 | 2169196 |
| Ø 10 ... Ø 12 x 1,5   Ø 0.394 ... Ø 0.472 x 0.059 | 1511011 | 2168833 |
| Ø 12 ... Ø 14 x 1,5   Ø 0.472 ... Ø 0.551 x 0.059 | 1511020 | 2166950 |
| Ø 14 ... Ø 16 x 1,5   Ø 0.551 ... Ø 0.63 x 0.059  | 2167772 | 2168962 |
| Ø 8 ... Ø 10 x 1,6   Ø 0.315 ... Ø 0.394 x 0.063  | 2242641 | 2242657 |
| Ø 10 ... Ø 12 x 1,6   Ø 0.394 ... Ø 0.472 x 0.063 | 2242642 | 2242658 |
| Ø 12 ... Ø 14 x 1,6   Ø 0.472 ... Ø 0.551 x 0.063 | 2242643 | 2242659 |
| Ø 14 ... Ø 16 x 1,6   Ø 0.551 ... Ø 0.63 x 0.063  | 2242644 | 2168821 |
| Ø 9 ... Ø 10 x 2,0   Ø 0.354 ... Ø 0.394 x 0.079  | 2242645 | 2242660 |
| Ø 10 ... Ø 12 x 2,0   Ø 0.394 ... Ø 0.472 x 0.079 | 2242646 | 2242661 |
| Ø 12 ... Ø 14 x 2,0   Ø 0.472 ... Ø 0.551 x 0.079 | 2242647 | 2242662 |
| Ø 14 ... Ø 16 x 2,0   Ø 0.551 ... Ø 0.63 x 0.079  | 2242648 | 2242663 |

| 公称尺寸<br>Nominal size            | 订货号<br>Ident No. |
|---------------------------------|------------------|
| mm   inch 英寸                    |                  |
| Ø 8 - Ø 10   Ø 0.315 - Ø 0.394  | 1511253          |
| Ø 10 - Ø 12   Ø 0.394 - Ø 0.472 | 1511262          |
| Ø 12 - Ø 14   Ø 0.472 - Ø 0.551 | 1511271          |
| Ø 14 - Ø 16   Ø 0.551 - Ø 0.63  | 1511280          |

| BSW                            |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| BSW 3/8 - 16                   | 1510236         | 1510245         |
| BSW 7/16 - 14                  | 1510263         | 1510272         |
| BSW 1/2... 9/16 - 12           | 1510281         | 1510290         |
| BSW 5/8 - 11                   | 1510316         | 1510325         |

| G                              |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| G 1/4 - 19                     | 1510450         | 2168838         |

| RD                             |                 |                 |
|--------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                | 订货号             |                 |
| Rd 16 x 1/8                    | 2169921         | 2166994         |

| NPT                            |                        |
|--------------------------------|------------------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k<br>订货号 |
| NPT 1/4 - 18                   | 2164717                |

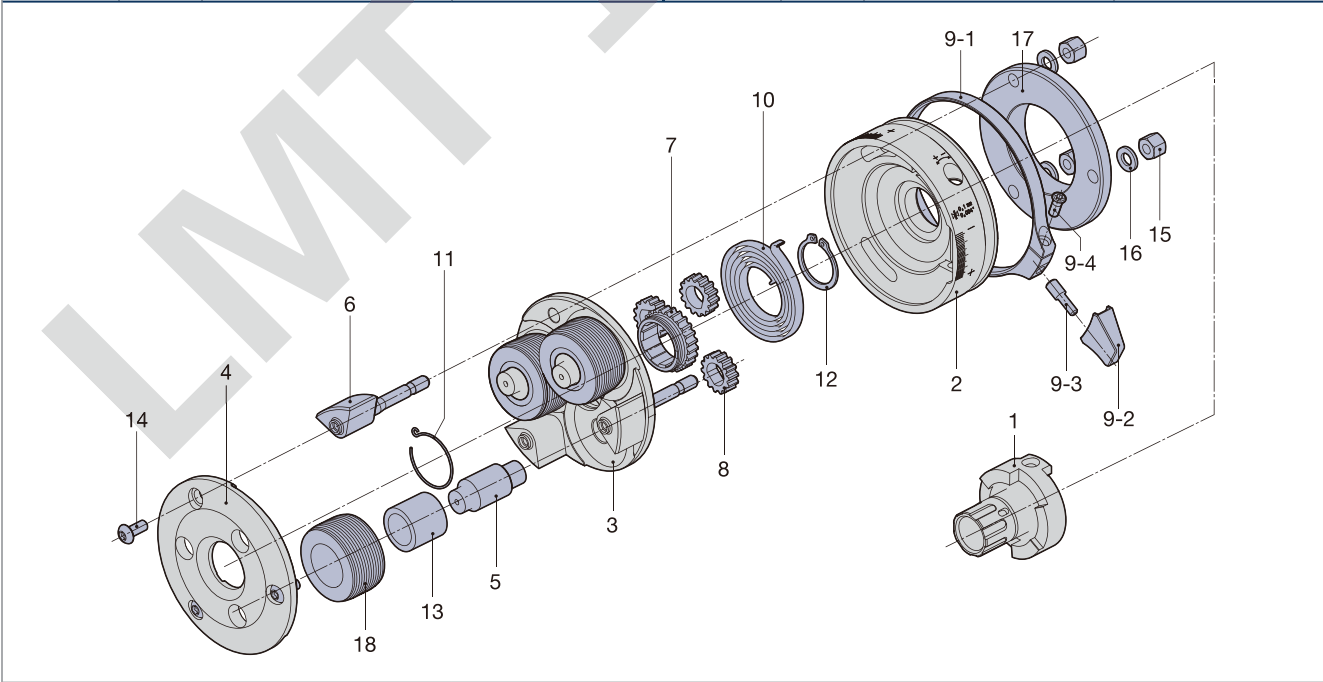
| NPTF                           |                        |
|--------------------------------|------------------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k<br>订货号 |
| NPTF 1/4 - 18                  | 2168616                |

同一栏内螺纹尺寸可使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

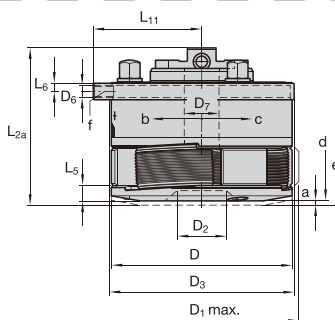
### F2 EVO型轴向滚压头备件表 Spare parts for axial type rolling head F2 EVO

| 滚压头<br>Rolling head |            |                                 | F2 EVO<br>订货号<br>Ident No. | 滚压头<br>Rolling head |            |                               | F2 EVO<br>订货号<br>Ident No. |
|---------------------|------------|---------------------------------|----------------------------|---------------------|------------|-------------------------------|----------------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        |                            | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      |                            |
| 1                   | 1          | 离合器<br>Clutch                   | 7137661                    | 9-3                 | 1          | 螺纹销<br>Threaded pin           | 7137658                    |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7137662                    | 9-4                 | 1          | 螺钉<br>Screw                   | 1044990                    |
| 3                   | 1          | 中心板<br>Center plate             | 7137663                    | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 2164774                    |
| 4                   | 1          | 前板<br>Front plate               | 7137664                    | 11                  | 1          | 卡簧<br>Circlip                 | 2164775                    |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2164770                    | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7113298                    |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7137666                    | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2164887                    |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7137667                    | 14                  | 3          | 螺钉<br>Screw                   | 7123891                    |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7137668                    | 15                  | 3          | 螺母<br>Cover nut               | 2143536                    |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7137669                    | 16                  | 3          | 垫圈<br>Washer                  | 2143365                    |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7137656                    | 17                  | 1          | 防屑罩<br>Chip guard             | 7137672                    |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7137657                    | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual           |





| 型号<br>Type | 订货号<br>Ident No. |
|------------|------------------|
| F23 EVO    | 7155144          |
| F23L EVO   | 7169600          |
| K23 EVO    | 7169601          |
| K23L EVO   | 7169602          |



尺寸单位为毫米 Dimension in inches

| D      | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |
|--------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|
| 88     | 93,5   | 28     | 90     | M6 | 17     | 78,6   | 7,5    | 4      | 52,8   | 3      | 60°      | 1° 25'   |
| 3.465" | 3.681" | 1.102" | 3.543" |    | 0.669" | 3.094" | 0.295" | 0.158" | 2.079" | 0.118" |          |          |

F23 EVO, K23 EVO 右手螺纹用 for right-hand threads

F23 EVO, K23 EVO 左手螺纹用 for left-hand threads

F23 EVO, K23 EVO 仅在滚压头静止的工况中使用 to be used stationary only

F23 EVO, K23 EVO 在滚压头静止或回转的工况中使用 used stationary or rotating

| m-Rk                        | m-Ro                                 |
|-----------------------------|--------------------------------------|
| 约1,86 kg<br>近似等于<br>4.10 lb | 0,17–0,32 kg<br>近似等于<br>0.37–0.71 lb |

a = 开启时出料 Pull off for opening

b = 对于F型, 滚压头闭合 Head closes when type F

c = 对于F型, 滚压头开启 Head opens when type F

d = 滚压头闭合 Rolling head closed

e = 滚压头开启 Rolling head opened

f = 静止状态下操作时的手柄螺纹. Thread for hand grip with stationary operation.

$\alpha$  = 闭合角度 Closing angle

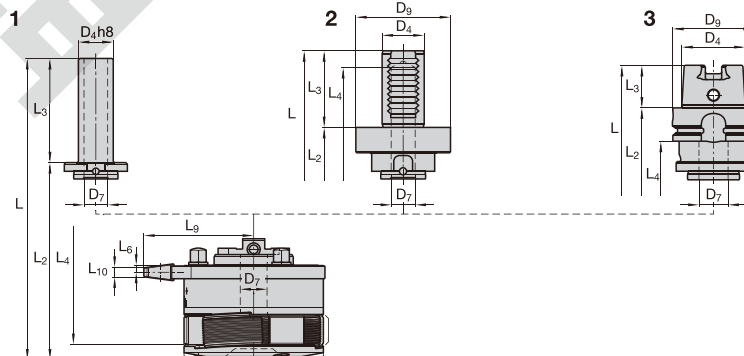
$\gamma$  = 滚轮的倾斜位置 Inclined position of rolls

m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls

m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

| 型号<br>Type  | 订货号<br>Ident No. |
|-------------|------------------|
| R25-规格2     | 7137673          |
| R30-规格2     | 7139612          |
| R1-规格2      | 7139614          |
| R1 1/4-规格2  | 7139616          |
| R1 1/2-规格2  | 7139618          |
| VDI-25-规格2  | 7139620          |
| VDI-30-规格2  | 7139622          |
| VDI-40-规格2  | 7139624          |
| HSK-A63-规格2 | 7139626          |



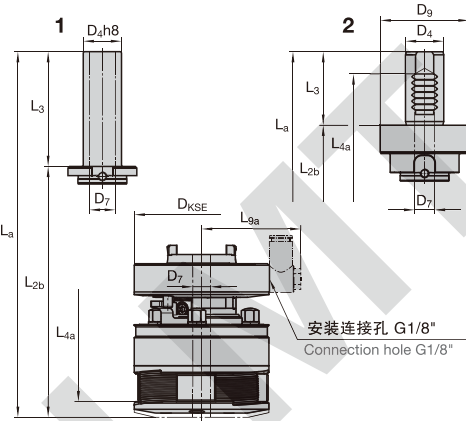
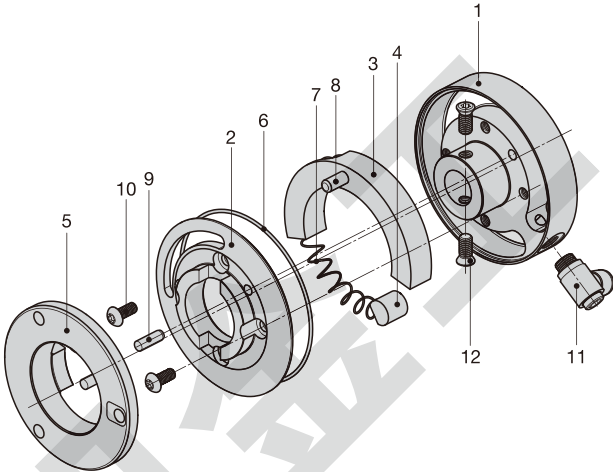
| 连接柄直径<br>Shank dia. | 尺寸单位为毫米<br>Dimension in inches | D4          | D7          | D9          | D <sub>KSE</sub> | L              | L <sub>a</sub> | L <sub>2</sub> | L <sub>2b</sub> | L <sub>3</sub> |
|---------------------|--------------------------------|-------------|-------------|-------------|------------------|----------------|----------------|----------------|-----------------|----------------|
| 25                  | 25   1.0984"                   | 17   0.669" | —           | 88   3.465" | 153,6   6.047"   | 189   7.441"   | 78,6   3.094"  | 114   4.488"   | 75   2.953"     |                |
| 30                  | 30   1.181"                    | 17   0.669" | —           | 88   3.465" | 168,6   6.638"   | 204   8.032"   | 78,6   3.094"  | 114   4.488"   | 90   3.543"     |                |
| 1                   | 25,4   1.000"                  | 17   0.669" | —           | 88   3.465" | 153,6   6.047"   | 189   7.441"   | 78,6   3.094"  | 114   4.488"   | 75   2.953"     |                |
| 1 1/4               | 31,75   1.250"                 | 17   0.669" | —           | 88   3.465" | 168,6   6.638"   | 204   8.032"   | 78,6   3.094"  | 114   4.488"   | 90   3.543"     |                |
| 1 1/2               | 38,1   1.500"                  | 17   0.669" | —           | 88   3.465" | 168,6   6.638"   | 204   8.032"   | 78,6   3.094"  | 114   4.488"   | 90   3.543"     |                |
| VDI-25              | 25   1.0984"                   | 17   0.669" | 58   2.283" | 88   3.465" | 151,6   5.969"   | 187   7.362"   | 104,1   4.098" | 139   5.472"   | 48   1.890"     |                |
| VDI-30              | 30   1.181"                    | 17   0.669" | 68   2.677" | 88   3.465" | 159,1   6.264"   | 194,5   7.658" | 104,1   4.098" | 139,5   5.492" | 55   2.165"     |                |
| VDI-40              | 40   1.575"                    | 17   0.669" | 83   3.268" | 88   3.465" | 167,1   6.579"   | 202,5   7.972" | 104,1   4.098" | 139,5   5.492" | 63   2.480"     |                |
| HSK-A63             | 48   1.890"                    | 17   0.669" | 63   2.480" | 88   3.465" | 148,6   5.850"   | 184   7.244"   | 116,6   4.591" | 152   5.984"   | 32   1.260"     |                |

相应紧固螺钉(2 x 7211621)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211621).



| 冷却剂驱动的闭合装置<br>Coolant operating closing device |            |                                           | KSE   CCD<br>规格2       |
|------------------------------------------------|------------|-------------------------------------------|------------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                  | 订货号<br>Ident No.       |
| 1                                              | 1          | 壳体<br>Housing                             | 7144713                |
| 2                                              | 1          | 罩板<br>Cover plate                         | 7144714                |
| 3                                              | 1          | 曲型活塞<br>Curved piston                     | 7144715                |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                       | 7159855                |
| 5                                              | 1          | 防屑罩<br>Chip guard                         | 7151992                |
| 6                                              | 1          | 密封圈<br>Ring sealing                       | 7151997                |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                   | 7170169                |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2142691                |
| 9                                              | 2          | 圆柱销<br>Cylindrical pin                    | 2142675                |
| 10                                             | 4          | 螺钉<br>Screw                               | 7123891                |
| 11                                             | 1          | L- 与I-G1/8" 管接头<br>L- and I-Fitting G1/8" | 7167804-L<br>7167806-I |
| 12                                             | 2          | 螺钉<br>Screw                               | 7211621                |

| 型号<br>Type         | 订货号<br>Ident No. |
|--------------------|------------------|
| KSE EVOLine Size 2 | 7144712          |



- 1 直柄  
Straight shank
- 2 VDI连接柄  
VDI shank
- 3 HSK连接柄  
HSK shank
- 其他(依据要求定制)  
Others (upon request)

|  | L <sub>4</sub> | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub> | m-Rs                 |
|--|----------------|-----------------|----------------|----------------|-----------------|-----------------|----------------------|
|  | —              | —               | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,22 kg 近似等于0.49 lb |
|  | —              | —               | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,41 kg 近似等于0.90 lb |
|  | —              | —               | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,23 kg 近似等于0.51 lb |
|  | —              | —               | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,47 kg 近似等于1.04 lb |
|  | —              | —               | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,71 kg 近似等于1.57 lb |
|  | 89,6   3.528"  | 125   4.921"    | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,63 kg 近似等于0.39 lb |
|  | 136,6   5.378" | 172   6.772"    | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,83 kg 近似等于1.83 lb |
|  | 139,6   5.496" | 175   6.890"    | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约1,40 kg 近似等于3.09 lb |
|  | 80,1   3.154"  | 115,5   4.547"  | 4   0.157"     | 69,1   2.721"  | 订制 Individual   | 6   0.236"      | 约0,84 kg 近似等于1.85 lb |

m-Rs = 连接柄重量 Weight shank



| MF                                            |  |                 |                 |
|-----------------------------------------------|--|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch               |  | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                                            |  | 订货号             |                 |
| MF 8 ... 10 x0,5                              |  | 1511725         | 2242958         |
| MF 8 ... 10 x0,75                             |  | 1511707         | 1511716         |
| MF 10 ... 12 x0,75                            |  | 1511743         | 1511752         |
| MF 10 ... 12 x1                               |  | 1511770         | 1511789         |
| MF 12 ... 14 x1                               |  | 1511798         | 1511814         |
| MF 14 ... 16 x1                               |  | 1511887         | 1511912         |
| MF 16 ... 18 <sup>1)</sup> x1                 |  | 1511985         | 1511994         |
| MF 18 <sup>1)</sup> ... 20 <sup>1)</sup> x1   |  | 1512074         | 1512083         |
| MF 14 ... 16 x1,25                            |  | 1511949         | 1511958         |
| MF 16 ... 18 <sup>1)</sup> x1,5               |  | 1512029         | 1512038         |
| MF 18 <sup>1)</sup> ... 20 <sup>1)</sup> x1,5 |  | 1512127         | 1512136         |
| MF 20 <sup>1)</sup> ... 22 <sup>1)</sup> x1,5 |  | 1512172         | 1512181         |

| <div>UN</div> <div>UNF</div> <div>UNEF</div>        |                 |                 |     |
|-----------------------------------------------------|-----------------|-----------------|-----|
| 公称尺寸xTPI<br>Nominal size x TPI                      | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k | 订货号 |
|                                                     |                 |                 |     |
| UNEF 5/16 ... 3/8 - 32                              | 1512403         | 1512412         |     |
| UNEF 3/8 ... 7/16 - 32                              | 2242901         | 2242902         |     |
| UNEF 7/16 ... 1/2 - 28                              | 1512378         | 2242903         |     |
| UN 7/16 ... 1/2 - 32                                | 2240057         | 2168596         |     |
| UN 1/2 ... 9/16 - 20                                | 1512421         | 1512430         |     |
| UN 1/2 ... 9/16 - 28                                | 2242730         | 2242905         |     |
| UN 1/2 ... 9/16 - 32                                | 2242906         | 2242907         |     |
| UNF 9/16 ... 5/8 - 18                               | 1512494         | 1512500         |     |
| UN 9/16 ... 5/8 - 20                                | 2168849         | 2168772         |     |
| UNEF 9/16 ... 5/8 - 24                              | 2169198         | 2242908         |     |
| UN 9/16 ... 5/8 - 28                                | 2242288         | 2242909         |     |
| UN 9/16 ... 5/8 - 32                                | 2242087         | 1512369         |     |
| UN 5/8 ... 11/16 <sup>1)</sup> - 16                 | 2242911         | 2242912         |     |
| UN 5/8 ... 11/16 <sup>1)</sup> - 20                 | 2242913         | 2242914         |     |
| UNEF 5/8 ... 11/16 <sup>1)</sup> - 24               | 2242915         | 2242916         |     |
| UN 5/8 ... 11/16 <sup>1)</sup> - 28                 | 2242917         | 2242918         |     |
| UNF 11/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> - 16  | 1512449         | 1512458         |     |
| UNEF 11/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> - 20 | 1512387         | 1512396         |     |
| UN 3/4 <sup>1)</sup> ... 13/16 <sup>1)</sup> - 16   | 2245452         | 2242920         |     |
| UNEF 3/4 <sup>1)</sup> ... 13/16 <sup>1)</sup> - 20 | 2242921         | 2242922         |     |
| UNEF 13/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> - 20 | 2242923         | 2242924         |     |

| BSFS                                                |                 |                 |     |
|-----------------------------------------------------|-----------------|-----------------|-----|
| 公称尺寸xTPI<br>Nominal size x TPI                      | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k | 订货号 |
|                                                     |                 |                 |     |
| BSFS 5/16 ... 3/8 - 32                              | 2242881         | 2242882         |     |
| BSFS 7/16 ... 1/2 - 26                              | 2168872         | 2242883         |     |
| BSFS 1/2 ... 9/16 - 20                              | 2240199         | 2242884         |     |
| BSFS 1/2 ... 9/16 - 26                              | 2242885         | 2242886         |     |
| BSFS 9/16 ... 5/8 - 20                              | 2240198         | 2242887         |     |
| BSFS 9/16 ... 5/8 - 26                              | 2242888         | 2242889         |     |
| BSFS 5/8 ... 11/16 <sup>1)</sup> - 20               | 2242890         | 2242891         |     |
| BSFS 5/8 ... 11/16 <sup>1)</sup> - 26               | 2242892         | 2242893         |     |
| BSFS 3/4 <sup>1)</sup> ... 13/16 <sup>1)</sup> - 26 | 2242894         | 2242895         |     |
| BSFS 3/4 <sup>1)</sup> ... 13/16 <sup>1)</sup> - 16 | 2245304         | 2245305         |     |
| BSFS 3/4 <sup>1)</sup> ... 13/16 <sup>1)</sup> - 20 | 2242897         | 2242898         |     |
| BSFS 13/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> - 20 | 2242899         | 2242900         |     |

| <div>G</div>                   |                 |                 |     |
|--------------------------------|-----------------|-----------------|-----|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k | 订货号 |
|                                |                 |                 |     |
| G 1/8 - 28                     | 1512305         | 1512314         |     |
| G 1/4 - 19                     | 1512323         | 1512332         |     |
| G 3/8 <sup>1)</sup> - 19       | 1512341         | 1512350         |     |
| G 1/2 <sup>1)</sup> - 14       | 1512519         | 2168208         |     |

| NPT                            |                 |         |
|--------------------------------|-----------------|---------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 订货号     |
|                                |                 |         |
| NPT 1/8 - 27                   |                 | 2165335 |
| NPT 1/4 - 18                   |                 | 2164611 |
| NPT 3/8 - 18                   |                 | 2166779 |

| NPTF                           |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
|                                | 订货号             |
| NPTF 1/8 - 27                  | 2164629         |
| NPTF 1/4 - 18                  | 2166947         |
| NPTF 3/8 - 18                  | 2168651         |

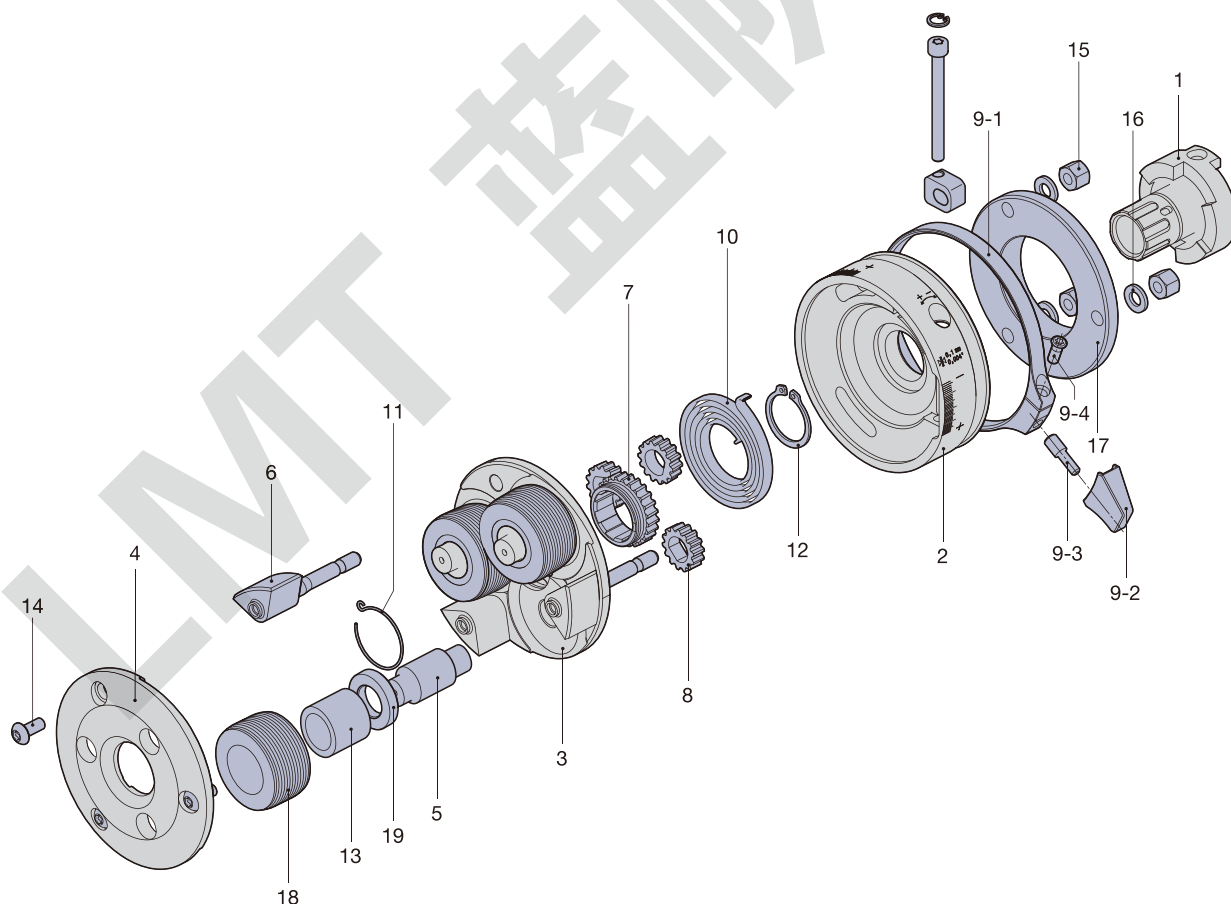
<sup>1)</sup> 适用于19 mm/0.748"以内的短螺纹，含螺尾。

For short threads up to 19 mm/0.748" including runout.

同一栏内螺纹尺寸可以使用一组滚轮进行滚压加工。

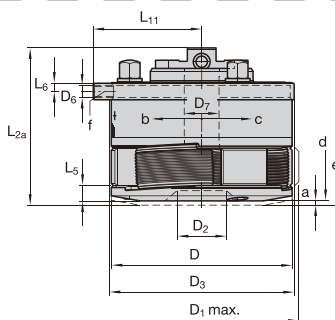
Thread dimensions combined in one block can be rolled with **one** set of rolls.

| 滚压头<br>Rolling head |            |                                 | F23 EVO          | 滚压头<br>Rolling head |            |                               | F23 EVO          |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7137661          | 9-4                 | 1          | 螺钉<br>Screw                   | 1044990          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7137662          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 2164774          |
| 3                   | 1          | 中心板<br>Center plate             | 7155528          | 11                  | 1          | 卡簧<br>Circlip                 | 2164775          |
| 4                   | 1          | 前板<br>Front plate               | 7155531          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7113298          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2164931          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2164705          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7155532          | 14                  | 3          | 螺钉<br>Screw                   | 7123891          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7155534          | 15                  | 3          | 螺母<br>Cover nut               | 2143536          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7155533          | 16                  | 3          | 垫圈<br>Washer                  | 2143365          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7137669          | 17                  | 1          | 防屑罩<br>Chip guard             | 7137672          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7137656          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7137657          | 19                  | 3          | 垫圈<br>Washer                  | 2164935          |
| 9-3                 | 1          | 螺纹销<br>Threaded pin             | 7137658          |                     |            |                               |                  |





| 型号<br>Type   | 订货号<br>Ident No. |
|--------------|------------------|
| F233400 EVO  | 7156345          |
| F233400L EVO | 7169603          |
| K233400 EVO  | 7169604          |
| K233400L EVO | 7169605          |



尺寸单位为毫米 Dimension in inches

| D      | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |
|--------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|
| 96     | 115    | 39     | 98     | M6 | 28     | 96     | 8      | 4      | 56,8   | 3      | 30°      | 1° 15'   |
| 3.780" | 4.528" | 1.535" | 3.858" |    | 1.102" | 3.780" | 0.315" | 0.158" | 2.236" | 0.118" |          |          |

F3 EVO, K3 EVO右手螺纹用 for right-hand threads

F3L EVO, K3L EVO左手螺纹用 for left-hand threads

F3 EVO, F3L EVO仅在滚压头静止的工况中使用 to be used stationary only

K3 EVO, K3L EVO在滚压头静止或回转的工况中使用 used stationary or rotating

| m-Rk                         | m-Ro                                 |
|------------------------------|--------------------------------------|
| ca. 3,4 kg<br>近似等于<br>7.5 lb | 0,185–0,4 kg<br>近似等于<br>0.41–0.88 lb |

a = 开启时出料 Pull off for opening

b = 对于F型, 滚压头闭合 Head closes when type F

c = 对于F型, 滚压头开启 Head opens when type F

d = 滚压头闭合 Rolling head closed

e = 滚压头开启 Rolling head opened

f = 静止状态下操作时的手柄螺纹. Thread for hand grip with stationary operation.

$\alpha$  = 闭合角度 Closing angle

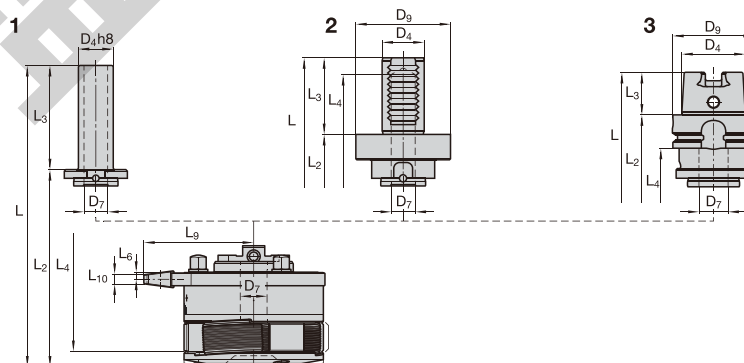
$\gamma$  = 滚轮的倾斜位置 Inclined position of rolls

m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls

m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

| 型号<br>Type  | 订货号<br>Ident No. |
|-------------|------------------|
| R25-规格3     | 7139628          |
| R30-规格3     | 7139630          |
| R1-规格3      | 7139632          |
| R1 1/4-规格3  | 7139634          |
| R1 1/2-规格3  | 7139636          |
| VDI-25-规格3  | 7139638          |
| VDI-30-规格3  | 7139640          |
| VDI-40-规格3  | 7139642          |
| HSK-A63-规格3 | 7139644          |



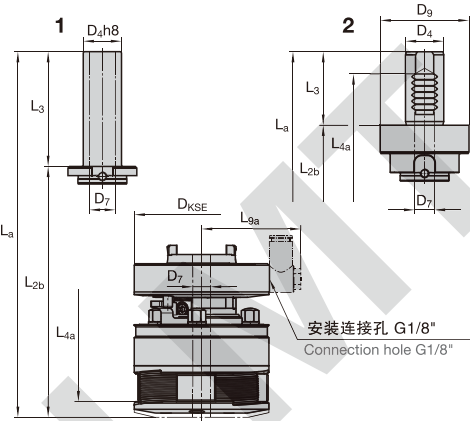
| 连接柄直径<br>Shank dia. | 尺寸单位为毫米        |               | Dimension in inches |                  |                |                |                |                 |                |  |  |  |
|---------------------|----------------|---------------|---------------------|------------------|----------------|----------------|----------------|-----------------|----------------|--|--|--|
|                     | D4             | D7            | D9                  | D <sub>KSE</sub> | L              | L <sub>a</sub> | L <sub>2</sub> | L <sub>2b</sub> | L <sub>3</sub> |  |  |  |
| 25                  | 25   0.984"    | 17   0.669"   | —                   | 113   4.449"     | 171   6.732"   | 210,4   8.284" | 96   3.779"    | 135,4   5.331"  | 75   2.953"    |  |  |  |
| 30                  | 30   1.181"    | 22,5   0.886" | —                   | 113   4.449"     | 186   7.322"   | 225,4   8.874" | 96   3.779"    | 135,4   5.331"  | 90   3.543"    |  |  |  |
| 1                   | 25,4   1.000"  | 17   0.669"   | —                   | 113   4.449"     | 171   6.732"   | 210,4   8.284" | 96   3.779"    | 135,4   5.331"  | 75   2.953"    |  |  |  |
| 1 1/4               | 31,75   1.250" | 22,5   0.886" | —                   | 113   4.449"     | 186   7.322"   | 225,4   8.874" | 96   3.779"    | 135,4   5.331"  | 90   3.543"    |  |  |  |
| 1 1/2               | 38,1   1.500"  | 22,5   0.886" | —                   | 113   4.449"     | 186   7.322"   | 225,4   8.874" | 96   3.779"    | 135,4   5.331"  | 90   3.543"    |  |  |  |
| VDI-25              | 25   0.984"    | 22,5   0.886" | 58   2.283"         | 113   4.449"     | 167   6.574"   | 206,4   8.126" | 119   4.685"   | 158,4   6.236"  | 48   1.890"    |  |  |  |
| VDI-30              | 30   1.181"    | 22,5   0.886" | 68   2.677"         | 113   4.449"     | 176,5   6.949" | 215,9   8.500" | 121,5   4.783" | 160,9   6.335"  | 55   2.165"    |  |  |  |
| VDI-40              | 40   1.575"    | 22,5   0.886" | 83   3.268"         | 113   4.449"     | 184,5   7.264" | 223,9   8.815" | 121,5   4.783" | 160,9   6.335"  | 63   2.480"    |  |  |  |
| HSK-A63             | 48   1.890"    | 22,5   0.886" | 63   2.480"         | 113   4.449"     | 170,5   6.713" | 209,9   8.264" | 138,5   5.453" | 177,9   7.004"  | 32   1.260"    |  |  |  |

相应紧固螺钉(2 x 7211622)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211622).

3号规格CCD EVOLine备件表 (F233400)  
Spare parts for CCD EVOLine Size 3 (F233400)



| 冷却剂驱动的闭合装置<br>Coolant operating closing device |            |                                           | KSE   CCD<br>3号规格<br>(F233400)<br>订货号<br>Ident No. | 型号<br>Type                                         | 订货号<br>Ident No. |
|------------------------------------------------|------------|-------------------------------------------|----------------------------------------------------|----------------------------------------------------|------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                  | 订货号<br>Ident No.                                   | 3号规格KSE EVOLine<br>KSE EVOLine Size 3<br>(F233400) | 7137680          |
| 1                                              | 1          | 壳体<br>Housing                             | 7137676                                            |                                                    |                  |
| 2                                              | 1          | 罩板<br>Cover plate                         | 7137677                                            |                                                    |                  |
| 3                                              | 1          | 曲型活塞<br>Curved piston                     | 7137678                                            |                                                    |                  |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                       | 7137679                                            |                                                    |                  |
| 5                                              | 1          | 防屑罩<br>Chip guard                         | 7156379                                            |                                                    |                  |
| 6                                              | 1          | 密封圈<br>Ring sealing                       | 7137674                                            |                                                    |                  |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                   | 7155154                                            |                                                    |                  |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                    | 2142691                                            |                                                    |                  |
| 9                                              | 2          | 圆柱销<br>Cylindrical pin                    | 2142688                                            |                                                    |                  |
| 10                                             | 4          | 螺钉<br>Screw                               | 7123891                                            |                                                    |                  |
| 11                                             | 1          | L- 与I-G1/8" 管接头<br>L- and I-Fitting G1/8" | 7167804-L<br>7167806-I                             |                                                    |                  |
| 12                                             | 2          | 螺钉<br>Screw                               | 7211622                                            |                                                    |                  |



- 1 直柄  
Straight shank
- 2 VDI连接柄  
VDI shank
- 3 HSK连接柄  
HSK shank
- 其他(依据要求定制)  
Others (upon request)

|  | L <sub>4</sub> | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub> | m-Rs                 |
|--|----------------|-----------------|----------------|----------------|-----------------|-----------------|----------------------|
|  | —              | —               | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,34 kg 近似等于0.75 lb |
|  | —              | —               | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,37 kg 近似等于0.82 lb |
|  | —              | —               | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,34 kg 近似等于0.75 lb |
|  | —              | —               | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,37 kg 近似等于0.82 lb |
|  | —              | —               | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,40 kg 近似等于0.88 lb |
|  | 104,4   4.110" | 143,9   5.665"  | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,70 kg 近似等于1.54 lb |
|  | 107,4   4.228" | 146,9   5.784"  | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约0,94 kg 近似等于2.07 lb |
|  | 156,4   6.158" | 195,9   7.713"  | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约1,42 kg 近似等于3.13 lb |
|  | 101,4   3.992" | 140,9   5.547"  | 4   0.158"     | 73,8   2.906"  | 订制 Individual   | 6   0.236"      | 约1,00 kg 近似等于2.21 lb |

m-Rs = 连接柄重量 Weight shank





| MF                                             |                 |                 |
|------------------------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch<br>mm          | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                            |                 |                 |
| MF 16 <sup>1)</sup> ... 18 <sup>1)</sup> x 1,5 | 1513037         | 1513064         |
| MF 18 <sup>1)</sup> ... 20 <sup>1)</sup> x 1,5 | 1513073         | 1513091         |
| MF 20 <sup>1)</sup> ... 22 <sup>1)</sup> x 1,5 | 1513108         | 1513126         |
| MF 22 <sup>1)</sup> ... 24 <sup>1)</sup> x 1,5 | 1513144         | 1513153         |
| MF 24 <sup>1)</sup> ... 26 <sup>1)</sup> x 1,5 | 1513171         | 1513180         |
| MF 26 <sup>1)</sup> ... 28 <sup>2)</sup> x 1,5 | 1513233         | 1513242         |
| MF 28 <sup>2)</sup> ... 30 <sup>2)</sup> x 1,5 | 2246617         | 2243039         |
| MF 30 <sup>2)</sup> ... 32 <sup>2)</sup> x 1,5 | 1513297         | 1513304         |
| MF 32 <sup>2)</sup> ... 34 <sup>2)</sup> x 1,5 | 1513340         | 1513359         |
| MF 34 <sup>2)</sup> ... 36 <sup>2)</sup> x 1,5 | 2243042         | 1513386         |
| MF 22 <sup>1)</sup> ... 24 <sup>1)</sup> x 2   | 1513162         | 2243044         |
| MF 24 <sup>1)</sup> ... 26 <sup>1)</sup> x 2   | 1513199         | 2169638         |
| MF 26 <sup>1)</sup> ... 28 <sup>2)</sup> x 2   | 1513251         | 2243045         |
| MF 28 <sup>2)</sup> ... 30 <sup>2)</sup> x 2   | 1513288         | 2243046         |
| MF 30 <sup>2)</sup> ... 32 <sup>2)</sup> x 2   | 1513313         | 1513331         |
| MF 32 <sup>2)</sup> ... 34 <sup>2)</sup> x 2   | 1513368         | 2243047         |
| MF 34 <sup>2)</sup> ... 36 <sup>2)</sup> x 2   | 1513402         | 2243048         |

| BSFS                                                  |                 |                 |
|-------------------------------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI                       | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                                   |                 |                 |
| BSFS 5/8 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -26   | 2243111         | 2243112         |
| BSFS 5/8 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -20   | 2243113         | 2243114         |
| BSFS 1 1/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> -26   | 2243115         | 2243116         |
| BSFS 1 1/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> -20   | 2243117         | 2243118         |
| BSFS 1 1/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> -16   | 2243119         | 2243120         |
| BSFS 3/4 <sup>1)</sup> ... 1 3/16 <sup>1)</sup> -26   | 2243121         | 2243122         |
| BSFS 3/4 <sup>1)</sup> ... 1 3/16 <sup>1)</sup> -20   | 2243123         | 2168612         |
| BSFS 3/4 <sup>1)</sup> ... 1 3/16 <sup>1)</sup> -16   | 2243124         | 2169760         |
| BSFS 1 3/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> -20   | 2243125         | 2243126         |
| BSFS 7/8 <sup>1)</sup> ... 1 5/16 <sup>1)</sup> -20   | 2243127         | 2243128         |
| BSFS 1 5/16 <sup>1)</sup> ... 1 <sup>1)</sup> -20     | 2243129         | 2168574         |
| BSFS 1 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -20     | 2243130         | 2243131         |
| BSFS 1 1/16 <sup>1)</sup> ... 1 1/8 <sup>2)</sup> -20 | 2243132         | 2232133         |
| BSFS 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -20 | 2243134         | 2243135         |
| BSFS 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -12 | 2243136         | 2243137         |
| BSFS 1 3/16 <sup>2)</sup> ... 1 1/4 <sup>2)</sup> -12 | 2243138         | 2243139         |
| BSFS 1 1/4 <sup>2)</sup> ... 1 5/16 <sup>2)</sup> -12 | 2243140         | 2243141         |
| BSFS 1 5/16 <sup>2)</sup> ... 1 3/8 <sup>2)</sup> -12 | 2243142         | 2243143         |
| BSFS 1 3/8 <sup>2)</sup> ... 1 7/16 <sup>2)</sup> -12 | 2243144         | 2243145         |

| UN UNF UNEF                                           |                 |                 |
|-------------------------------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI                       | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                                                   |                 |                 |
| UNF 5/8 <sup>1)</sup> -18                             | 2167797         | 2241562         |
| UNEF 5/8 <sup>1)</sup> -24                            | 2243148         | 2243063         |
| UN 5/8 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -20     | 2243064         | 2243065         |
| UNEF 1 1/16 <sup>1)</sup> -24                         | 2243066         | 2243067         |
| UN 1 1/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> -20     | 2166139         | 2243068         |
| UNF 1 1/16 <sup>1)</sup> ... 3/4 <sup>1)</sup> -16    | 2167188         | 2242668         |
| UN 3/4 <sup>1)</sup> -24                              | 2240085         | 2243069         |
| UNEF 3/4 <sup>1)</sup> ... 1 3/16 <sup>1)</sup> -20   | 2243070         | 2243071         |
| UN 3/4 <sup>1)</sup> ... 1 3/16 <sup>1)</sup> -16     | 2167189         | 1513554         |
| UNEF 1 3/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> -20   | 2169153         | 2243072         |
| UN 1 3/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> -16     | 2243073         | 2243074         |
| UNF 1 3/16 <sup>1)</sup> ... 7/8 <sup>1)</sup> -14    | 1513563         | 1513572         |
| UNEF 7/8 <sup>1)</sup> ... 1 5/16 <sup>1)</sup> -20   | 2168774         | 2243075         |
| UN 7/8 <sup>1)</sup> ... 1 5/16 <sup>1)</sup> -16     | 2169149         | 2242227         |
| UNF 7/8 <sup>1)</sup> ... 1 5/16 <sup>1)</sup> -14    | 2243076         | 2243077         |
| UN 7/8 <sup>1)</sup> ... 1 5/16 <sup>1)</sup> -12     | 2166038         | 2243078         |
| UNEF 1 5/16 <sup>1)</sup> ... 1 <sup>1)</sup> -20     | 2242407         | 2243079         |
| UN 1 5/16 <sup>1)</sup> ... 1 <sup>1)</sup> -16       | 2243080         | 2243081         |
| UNF 1 5/16 <sup>1)</sup> ... 1 <sup>1)</sup> -12      | 2243082         | 2167075         |
| UNEF 1 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -20     | 2169150         | 2243083         |
| UNEF 1 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -18     | 2243084         | 2243085         |
| UN 1 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -16       | 2168340         | 2168867         |
| UNF 1 <sup>1)</sup> ... 1 1/16 <sup>1)</sup> -12      | 2168130         | 2243086         |
| UN 1 1/16 <sup>1)</sup> ... 1 1/8 <sup>2)</sup> -20   | 2169148         | 2243087         |
| UNEF 1 1/16 <sup>1)</sup> ... 1 1/8 <sup>2)</sup> -18 | 2240059         | 2243088         |
| UNEF 1 1/16 <sup>1)</sup> ... 1 1/8 <sup>2)</sup> -16 | 2168691         | 2243089         |
| UNF 1 1/16 <sup>1)</sup> ... 1 1/8 <sup>2)</sup> -12  | 2242012         | 2243090         |
| UN 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -20   | 2243091         | 2243092         |
| UNEF 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -18 | 2243093         | 2243094         |
| UN 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -16   | 2243095         | 2243096         |
| UN 1 1/8 <sup>2)</sup> ... 1 3/16 <sup>2)</sup> -12   | 2241120         | 2243097         |
| UN 1 3/16 <sup>2)</sup> ... 1 1/4 <sup>2)</sup> -16   | 2168027         | 2243098         |
| UN 1 3/16 <sup>2)</sup> ... 1 1/4 <sup>2)</sup> -12   | 2243099         | 2243100         |
| UN 1 1/4 <sup>2)</sup> ... 1 5/16 <sup>2)</sup> -16   | 2243101         | 2243102         |
| UN 1 1/4 <sup>2)</sup> ... 1 5/16 <sup>2)</sup> -12   | 2165845         | 2243103         |
| UN 1 5/16 <sup>2)</sup> ... 1 3/8 <sup>2)</sup> -16   | 2243104         | 2243105         |
| UN 1 5/16 <sup>2)</sup> ... 1 3/8 <sup>2)</sup> -12   | 2243106         | 2243107         |
| UN 1 3/8 <sup>2)</sup> ... 1 7/16 <sup>2)</sup> -16   | 2242215         | 2243108         |
| UN 1 3/8 <sup>2)</sup> ... 1 7/16 <sup>2)</sup> -12   | 2243109         | 2243110         |

| G                               |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| 订货号                             |                 |                 |
| G 3/8 <sup>2)</sup> -19         | 1513411         | 1513439         |
| G 1/2 <sup>1)</sup> -14         | 1513448         | 2168886         |
| G 5/8 <sup>1)</sup> -14         | 1513466         | 2243146         |
| G 3/4 <sup>1)</sup> -14         | 1513484         | 2243147         |
| G 7/8 <sup>1)</sup> -14         | 1513509         | 1513518         |
| G 1 <sup>2)</sup> -11           | 1513527         | 2241298         |

| NPT                             |                 |
|---------------------------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
| 订货号                             |                 |
| NPT 3/8 - 18                    | 2164626         |

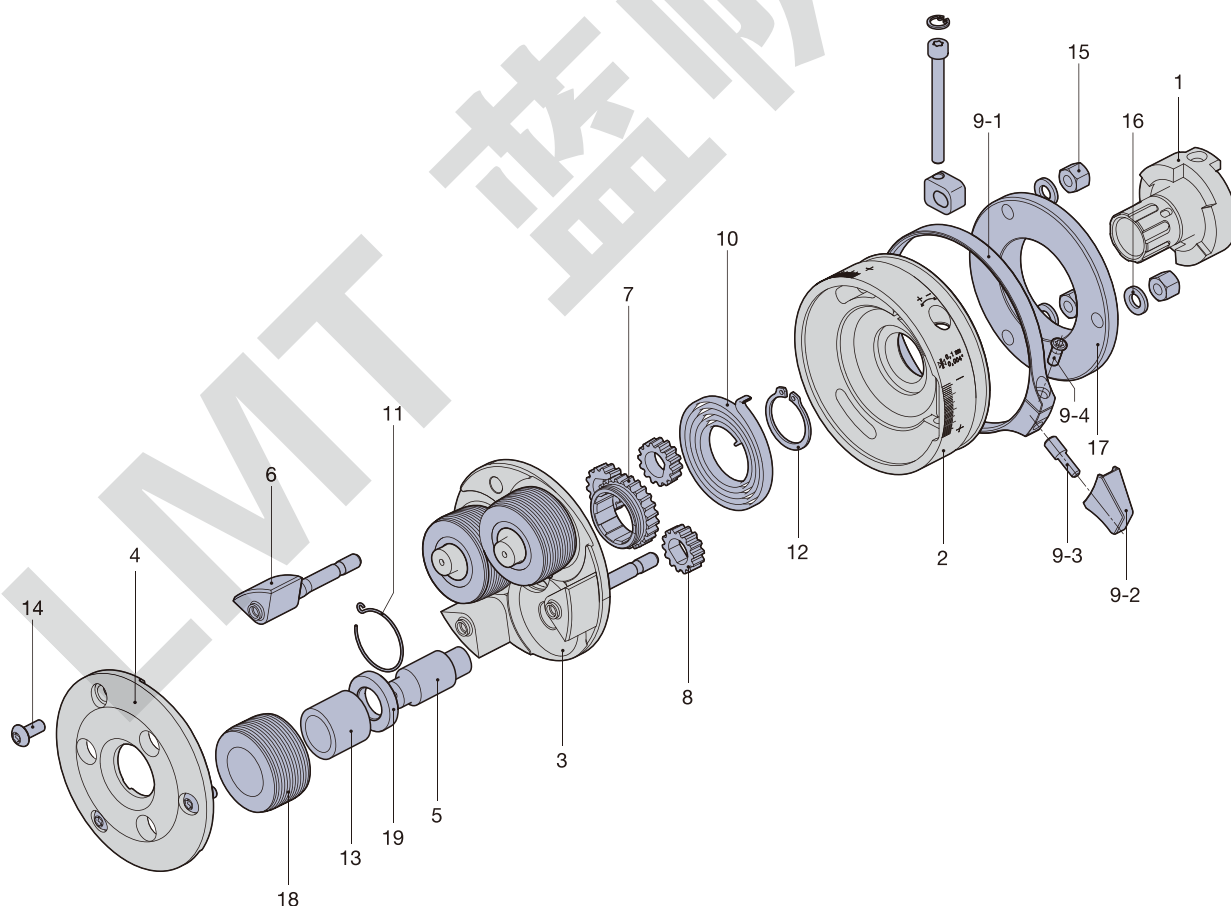
| NPTF                            |                 |
|---------------------------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
| 订货号                             |                 |
| NPTF 3/8 - 18                   | 2165232         |

同一栏内螺纹尺寸可以使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

- 1) 适用于73 mm/2.638"以内的短螺纹，含退刀槽。  
For short threads up to 73 mm/2.638" including runout.
- 2) 适用于24 mm/1.063"以内的短螺纹，含退刀槽。  
For short threads up to 24 mm/1.063" including runout.

| 滚压头<br>Rolling head |            |                                 | F233400 EVO      | 滚压头<br>Rolling head |            |                               | F233400 EVO      |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7156369          | 9-4                 | 1          | 螺钉<br>Screw                   | 1044990          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7156370          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 2164974          |
| 3                   | 1          | 中心板<br>Center plate             | 7156363          | 11                  | 1          | 卡簧<br>Circlip                 | 2164975          |
| 4                   | 1          | 前板<br>Front plate               | 7156364          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7161312          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2164969          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2168237          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7156365          | 14                  | 3          | 螺钉<br>Screw                   | 7123891          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7156367          | 15                  | 3          | 螺母<br>Cover nut               | 2143583          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7156368          | 16                  | 3          | 垫圈<br>Washer                  | 2143366          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7156374          | 17                  | 1          | 防屑罩<br>Chip guard             | 7156376          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7156375          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7137657          | 19                  | 3          | 垫圈<br>Washer                  | 2164978          |
| 9-3                 | 1          | 螺纹销<br>Threaded pin             | 7137658          |                     |            |                               |                  |



| 型号<br>Type | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
|------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
| F3 EVO     | 7146720          |  |  |  |  |  |  |  |  |  |  |  |  |
| F3L EVO    | 7169606          |  |  |  |  |  |  |  |  |  |  |  |  |
| K3 EVO     | 7169607          |  |  |  |  |  |  |  |  |  |  |  |  |
| K3L EVO    | 7169608          |  |  |  |  |  |  |  |  |  |  |  |  |

| 尺寸单位为毫米 Dimension in inches |        |        |        |    |        |        |        |        |        |        |          |          |  |
|-----------------------------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|--|
| D                           | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |  |
| 117                         | 131    | 38     | 119    | M8 | 22,5   | 95,4   | 8      | 5      | 66,8   | 4      | 60°      | 2° 40'   |  |
| 4.606"                      | 5.157" | 1.496" | 4.685" |    | 0.886" | 3.756" | 0.315" | 0.197" | 2.630" | 0.157" |          |          |  |

F233400 EVO, K233400右手螺纹用 for right-hand threads  
 F233400L EVO, K233400L EVO左手螺纹用 for left-hand threads  
 F233400 EVO, F233400L EVO仅在滚压头静止的工况中使用 to be used stationary only  
 K233400 EVO, K233400L EVO在滚压头静止或回转的工况中使用 used stationary or rotating

|  | m-Rk                      | m-Ro                        |
|--|---------------------------|-----------------------------|
|  | ca. 4 kg<br>appr. 8.82 lb | 0,75–1,2 kg<br>1.65–2.65 lb |

a = 开启时出料 Pull off for opening  
 b = 对于F型, 滚压头闭合 Head closes when type F  
 c = 对于F型, 滚压头开启 Head opens when type F  
 d = 滚压头闭合 Rolling head closed  
 e = 滚压头开启 Rolling head opened  
 f = 静止状态下操作时手柄螺纹. Thread for hand grip with stationary operation.  
 $\alpha$  = 闭合角度 Closing angle  
 $\gamma$  = 滚轮的倾斜位置 Inclined position of rolls  
 m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls  
 m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOLine Change shanks EVOLine

| 型号<br>Type  | 订货号<br>Ident No. |  |  |  |  |  |  |  |  |  |  |  |  |
|-------------|------------------|--|--|--|--|--|--|--|--|--|--|--|--|
| R25-规格3     | 7139628          |  |  |  |  |  |  |  |  |  |  |  |  |
| R30-规格3     | 7139630          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1-规格3      | 7139632          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1 1/4-规格3  | 7139634          |  |  |  |  |  |  |  |  |  |  |  |  |
| R1 1/2-规格3  | 7139636          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-25-规格3  | 7139638          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-30-规格3  | 7139640          |  |  |  |  |  |  |  |  |  |  |  |  |
| VDI-40-规格3  | 7139642          |  |  |  |  |  |  |  |  |  |  |  |  |
| HSK-A63-规格3 | 7139644          |  |  |  |  |  |  |  |  |  |  |  |  |

| 连接柄直径<br>Shank dia. | 尺寸单位为毫米 Dimension in inches |               |             |                  |                |                |                |                 |                |  |  |  |  |
|---------------------|-----------------------------|---------------|-------------|------------------|----------------|----------------|----------------|-----------------|----------------|--|--|--|--|
|                     | D4                          | D7            | D9          | D <sub>KSE</sub> | L              | L <sub>a</sub> | L <sub>2</sub> | L <sub>2b</sub> | L <sub>3</sub> |  |  |  |  |
| 25                  | 25   0.984"                 | 17   0.669"   | —           | 113   4.449"     | 170,4   6.709" | 210   8.268"   | 95,4   3.756"  | 135   5.315"    | 75   2.953"    |  |  |  |  |
| 30                  | 30   1.181"                 | 22,5   0.886" | —           | 113   4.449"     | 185,4   7.299" | 225   8.858"   | 95,4   3.756"  | 135   5.315"    | 90   3.543"    |  |  |  |  |
| 1                   | 25,4   1.000"               | 17   0.669"   | —           | 113   4.449"     | 170,4   6.709" | 210   8.268"   | 95,4   3.756"  | 135   5.315"    | 75   2.953"    |  |  |  |  |
| 1 1/4               | 31,75   1.250"              | 22,5   0.886" | —           | 113   4.449"     | 185,4   7.299" | 225   8.858"   | 95,4   3.756"  | 135   5.315"    | 90   3.543"    |  |  |  |  |
| 1 1/2               | 38,1   1.500"               | 22,5   0.886" | —           | 113   4.449"     | 185,4   7.299" | 225   8.858"   | 95,4   3.756"  | 135   5.315"    | 90   3.543"    |  |  |  |  |
| VDI-25              | 25   0.984"                 | 22,5   0.886" | 58   2.283" | 113   4.449"     | 166,4   6.551" | 206   8.110"   | 118,4   4.664" | 158   6.220"    | 48   1.890"    |  |  |  |  |
| VDI-30              | 30   1.181"                 | 22,5   0.886" | 68   2.677" | 113   4.449"     | 175,9   6.925" | 215,5   8.484" | 120,9   4.760" | 160,5   6.319"  | 55   2.165"    |  |  |  |  |
| VDI-40              | 40   1.575"                 | 22,5   0.886" | 83   3.268" | 113   4.449"     | 183,9   7.240" | 223,5   8.799" | 120,9   4.760" | 160,5   6.319"  | 63   2.480"    |  |  |  |  |
| HSK-A63             | 48   1.890"                 | 22,5   0.886" | 63   2.480" | 113   4.449"     | 169,9   6.689" | 209,5   8.248" | 137,9   5.429" | 177,5   6.988"  | 32   1.260"    |  |  |  |  |

相应紧固螺钉(2 x 7211622)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211622).

This exploded view diagram illustrates the assembly of a wheel. The components are numbered as follows:

- 1: Wheel rim
- 2: Wheel hub
- 3: Wheel arch
- 4: Wheel arch
- 5: Wheel flange
- 6: Wheel hub
- 7: Wheel arch
- 8: Wheel arch
- 9: Wheel hub
- 10: Wheel hub
- 11: Wheel hub
- 12: Wheel hub



|              |              |
|--------------|--------------|
| m-Rs = 连接柄重量 | Weight shank |
|--------------|--------------|



| M                               |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| M 12 ... 14 x 1,75              | 1514312         | 1514321         |
| M 14 ... 16 x 2                 | 1514438         | 1514447         |
| M 18 ... 20 x 2,5               | 1514642         | 1514660         |
| M 20 ... 22 x 2,5               | 1514768         | 1514777         |

| MF                              |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
| mm                              | 订货号             |                 |
| MF 12 ... 14 x 1,5              | 1514269         | 1514278         |
| MF 14 ... 16 x 1,5              | 1514385         | 1514401         |
| MF 18 ... 20 x 2                | 1514606         | 1514615         |
| MF 20 ... 22 x 2                | 2168931         | 1514740         |

| UNC                             |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                 | 订货号             |                 |
| UNC 7/16 - 14                   | 1515400         | 1515419         |
| UNC 1/2 - 13                    | 1515437         | 1515446         |
| UNC 9/16 - 12                   | 1515455         | 1515464         |
| UNC 5/8 - 11                    | 1515482         | 1515491         |
| UNC 3/4 - 10                    | 1515507         | 1515516         |
| UNC 7/8 - 9                     | 1515534         | 1515543         |

| UNF                             |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                 | 订货号             |                 |
| UNF 7/16 ... 1/2 - 20           | 1515570         | 1515589         |
| UNF 9/16 ... 5/8 - 18           | 1515605         | 1515614         |
| UNF 3/4 - 16                    | 1515650         | 1515669         |
| UNF 7/8 - 14                    | 1515678         | 2169974         |

| G                               |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                 | 订货号             |                 |
| G 1/4 ... 3/8 - 19              | 7180392         | 7180400         |
| G 1/2 - 14                      | 1515080         | 1515106         |

| 公称尺寸x节距<br>Nominal size x pitch                   | RAA     | RGE     |
|---------------------------------------------------|---------|---------|
| mm   inch                                         | 订货号     |         |
| Ø 12 ... Ø 14 x 0,5   Ø 0.472 ... Ø 0.551 x 0.02  | 2243564 | 2243585 |
| Ø 14 ... Ø 16 x 0,5   Ø 0.551 ... Ø 0.63 x 0.02   | 2169627 | 2243586 |
| Ø 16 ... Ø 18 x 0,5   Ø 0.63 ... Ø 0.709 x 0.02   | 2243565 | 2243587 |
| Ø 18 ... Ø 20 x 0,5   Ø 0.709 ... Ø 0.787 x 0.02  | 2243566 | 2243588 |
| Ø 20 ... Ø 22 x 0,5   Ø 0.787 ... Ø 0.866 x 0.02  | 2243567 | 2243589 |
| Ø 12 ... Ø 14 x 0,6   Ø 0.472 ... Ø 0.551 x 0.024 | 2243568 | 2243590 |
| Ø 14 ... Ø 16 x 0,6   Ø 0.551 ... Ø 0.63 x 0.024  | 1515909 | 2243591 |
| Ø 16 ... Ø 18 x 0,6   Ø 0.63 ... Ø 0.709 x 0.024  | 2243569 | 2243592 |
| Ø 18 ... Ø 20 x 0,6   Ø 0.709 ... Ø 0.787 x 0.024 | 2243570 | 2243593 |
| Ø 20 ... Ø 22 x 0,6   Ø 0.787 ... Ø 0.866 x 0.024 | 2243571 | 2243594 |
| Ø 12 ... Ø 14 x 0,8   Ø 0.472 ... Ø 0.551 x 0.031 | 1515918 | 2168024 |
| Ø 14 ... Ø 16 x 0,8   Ø 0.551 ... Ø 0.63 x 0.031  | 2243572 | 2165370 |
| Ø 16 ... Ø 18 x 0,8   Ø 0.63 ... Ø 0.709 x 0.031  | 2168428 | 2243595 |
| Ø 18 ... Ø 20 x 0,8   Ø 0.709 ... Ø 0.787 x 0.031 | 1515936 | 2168023 |
| Ø 20 ... Ø 22 x 0,8   Ø 0.787 ... Ø 0.866 x 0.031 | 2243573 | 2243596 |
| Ø 12 ... Ø 14 x 1,0   Ø 0.472 ... Ø 0.551 x 0.039 | 1515972 | 1516114 |
| Ø 14 ... Ø 16 x 1,0   Ø 0.551 ... Ø 0.63 x 0.039  | 2165323 | 2243597 |
| Ø 16 ... Ø 18 x 1,0   Ø 0.63 ... Ø 0.709 x 0.039  | 1515990 | 1516123 |
| Ø 18 ... Ø 20 x 1,0   Ø 0.709 ... Ø 0.787 x 0.039 | 1516007 | 1516132 |
| Ø 20 ... Ø 22 x 1,0   Ø 0.787 ... Ø 0.866 x 0.039 | 1516016 | 2243598 |
| Ø 12 ... Ø 14 x 1,2   Ø 0.472 ... Ø 0.551 x 0.047 | 2241199 | 1516141 |
| Ø 14 ... Ø 16 x 1,2   Ø 0.551 ... Ø 0.63 x 0.047  | 1516025 | 1516150 |
| Ø 16 ... Ø 18 x 1,2   Ø 0.63 ... Ø 0.709 x 0.047  | 1516034 | 2243599 |
| Ø 18 ... Ø 20 x 1,2   Ø 0.709 ... Ø 0.787 x 0.047 | 1516043 | 1516169 |
| Ø 20 ... Ø 22 x 1,2   Ø 0.787 ... Ø 0.866 x 0.047 | 1516052 | 2168022 |
| Ø 12 ... Ø 14 x 1,5   Ø 0.472 ... Ø 0.551 x 0.059 | 1516070 | 1516187 |
| Ø 14 ... Ø 16 x 1,5   Ø 0.551 ... Ø 0.63 x 0.059  | 1516089 | 1516196 |
| Ø 16 ... Ø 18 x 1,5   Ø 0.63 ... Ø 0.709 x 0.059  | 2168315 | 1516203 |
| Ø 18 ... Ø 20 x 1,5   Ø 0.709 ... Ø 0.787 x 0.059 | 1516098 | 1516212 |
| Ø 20 ... Ø 22 x 1,5   Ø 0.787 ... Ø 0.866 x 0.059 | 2242855 | 1516221 |
| Ø 12 ... Ø 14 x 1,6   Ø 0.472 ... Ø 0.551 x 0.063 | 2243575 | 2243600 |
| Ø 14 ... Ø 16 x 1,6   Ø 0.551 ... Ø 0.63 x 0.063  | 2243576 | 2243601 |
| Ø 16 ... Ø 18 x 1,6   Ø 0.63 ... Ø 0.709 x 0.063  | 2243577 | 2243602 |
| Ø 18 ... Ø 20 x 1,6   Ø 0.709 ... Ø 0.787 x 0.063 | 2243578 | 2243603 |
| Ø 20 ... Ø 22 x 1,6   Ø 0.787 ... Ø 0.866 x 0.063 | 2243579 | 2243604 |
| Ø 12 ... Ø 14 x 2,0   Ø 0.472 ... Ø 0.551 x 0.079 | 2243580 | 2243605 |
| Ø 14 ... Ø 16 x 2,0   Ø 0.551 ... Ø 0.63 x 0.079  | 2243581 | 2242539 |
| Ø 16 ... Ø 18 x 2,0   Ø 0.63 ... Ø 0.709 x 0.079  | 2243582 | 2243606 |
| Ø 18 ... Ø 20 x 2,0   Ø 0.709 ... Ø 0.787 x 0.079 | 2243583 | 2243607 |
| Ø 20 ... Ø 22 x 2,0   Ø 0.787 ... Ø 0.866 x 0.079 | 2243584 | 2243608 |

| BSF                                  |                 |                 |
|--------------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI      | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                      | 订货号             |                 |
| BSF 7/16 - 18                        | 1514900         | 1514928         |
| BSF 1/2 ... 9/16 - 16                | 1514946         | 1514955         |
| BSF 5/8 ... 11/16 - 14               | 1514964         | 1514973         |
| BSF 3/4 - 12                         | 1514982         | 1514991         |
| BSF 7/8 ... 15/16 <sup>1)</sup> - 11 | 2243559         | 1515008         |

| NPT                             |                 |  |
|---------------------------------|-----------------|--|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |  |
|                                 | 订货号             |  |
| NPT 1/4 - 18                    | 2241666         |  |

| BSW                             |                 |                 |
|---------------------------------|-----------------|-----------------|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                 | 订货号             |                 |
| BSW 7/16 - 14                   | 1515124         | 1515142         |
| BSW 1/2 ... 9/16 - 12           | 1515151         | 1515160         |
| BSW 5/8 ... 11/16 - 11          | 1515188         | 1515197         |
| BSW 3/4 - 10                    | 1515222         | 1515231         |
| BSW 7/8 ... 15/16 - 9           | 1515259         | 1515268         |

| NPTF                            |                 |  |
|---------------------------------|-----------------|--|
| 公称尺寸x TPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |  |
|                                 | 订货号             |  |
| NPTF 1/4 - 18                   | 2166887         |  |

1) 适用于24 mm/0.945"以内的短螺纹，含退刀槽。  
For short threads up to 24 mm/0.945" including runout.



| 公称尺寸x节距<br>Nominal size<br>mm   inch 英寸 | 订货号<br>Ident No. |
|-----------------------------------------|------------------|
| Ø 12 – Ø 14   Ø 0.472 – Ø 0.551         | 2241694          |
| Ø 14 – Ø 16   Ø 0.551 – Ø 0.63          | 1516249          |
| Ø 16 – Ø 18   Ø 0.63 – Ø 0.709          | 2165473          |
| Ø 18 – Ø 20   Ø 0.709 – Ø 0.787         | 1516258          |
| Ø 20 – Ø 22   Ø 0.787 – Ø 0.866         | 2169908          |

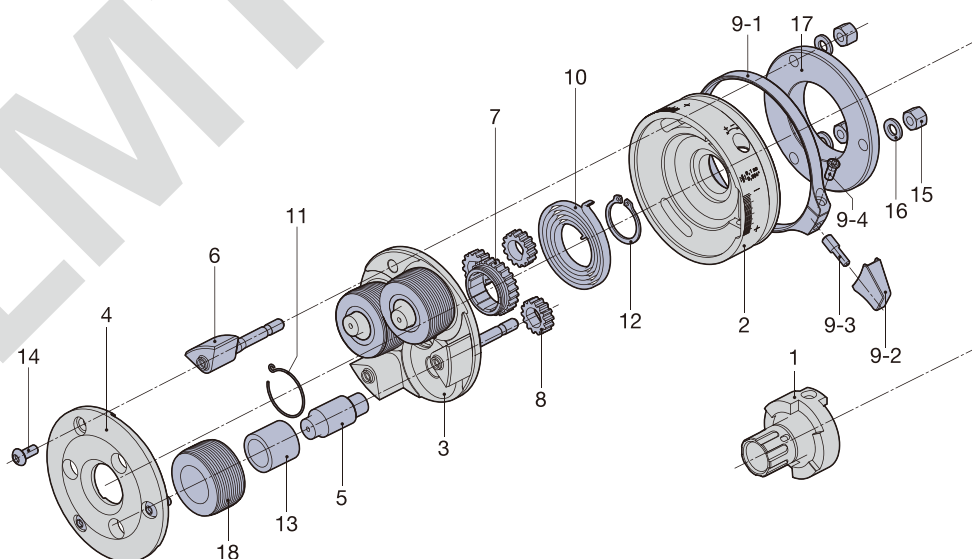
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|--------------------------------|-----------------|-----------------|
| Rd 18 – 20 x 1/8               | 2168222         | 2240161         |

同一栏内螺纹尺寸可以使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

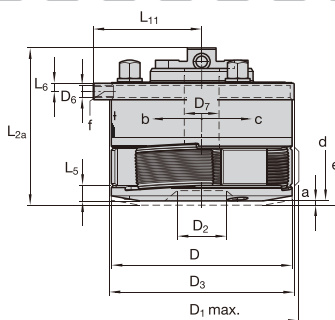
### F34 EVO, K34 EVO型轴向滚压头 Spare parts for axial type rolling head F3 EVO

| 滚压头<br>Rolling head |            |                                 | F3 EVO           | 滚压头<br>Rolling head |            |                               | F3 EVO           |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7146721          | 9-3                 | 1          | 螺纹销<br>Threaded pin           | 7146733          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7146722          | 9-4                 | 1          | 螺钉<br>Screw                   | 2237766          |
| 3                   | 1          | 中心板<br>Center plate             | 7146723          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 2165032          |
| 4                   | 1          | 前板<br>Front plate               | 7146724          | 11                  | 1          | 卡簧<br>Circlip                 | 2165033          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2165028          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7132606          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7146726          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2165072          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7146727          | 14                  | 3          | 螺钉<br>Screw                   | 7132607          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7146728          | 15                  | 3          | 螺母<br>Cover nut               | 2143583          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7146730          | 16                  | 3          | 垫圈<br>Washer                  | 2143366          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7146731          | 17                  | 1          | 防屑罩<br>Chip guard             | 7146725          |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7146732          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |





| 型号<br>Type | 订货号<br>Ident No. |
|------------|------------------|
| F34 EVO    | 7156344          |
| F34L EVO   | 7169609          |
| K34 EVO    | 7169610          |
| K34L EVO   | 7169611          |



尺寸单位为毫米 Dimension in inches

| D      | D1max  | D2     | D3     | D6 | D7     | L2a    | L5     | L6     | L11    | a      | $\alpha$ | $\gamma$ |
|--------|--------|--------|--------|----|--------|--------|--------|--------|--------|--------|----------|----------|
| 117    | 128    | 44     | 119    | M8 | 22,5   | 97     | 8      | 5      | 66,8   | 4      | 60°      | 1° 15'   |
| 4.606" | 5.039" | 1.732" | 4.685" |    | 0.886" | 3.819" | 0.315" | 0.197" | 2.630" | 0.157" |          |          |

F34 EVO, K34 EVO右手螺纹用 for right-hand threads

F34L EVO, K34L EVO左手螺纹用 for left-hand threads

F34 EVO, F34L EVO仅在滚压头静止工况中使用 to be used stationary only

K34 EVO, K34L EVO在滚压头静止或回转工况中使用 used stationary or rotating

| m-Rk                        | m-Ro                                     |
|-----------------------------|------------------------------------------|
| 约3,85 kg<br>近似等于<br>8.49 lb | 0,32 – 0,85 kg<br>近似等于<br>0.71 – 1.87 lb |

a = 开启时出料 Pull off for opening

b = 对于F型, 滚压头闭合 Head closes when type F

c = 对于F型, 滚压头开启 Head opens when type F

d = 滚压头闭合 Rolling head closed

e = 滚压头开启 Rolling head opened

f = 静止状态下操作时手柄螺纹. Thread for hand grip with stationary operation.

$\alpha$  = 闭合角度 Closing angle

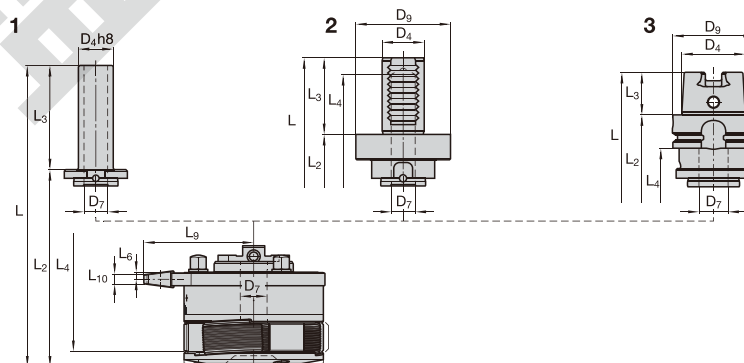
$\gamma$  = 滚轮的倾斜位置 Inclined position of rolls

m-Rk = 不含连接柄、滚轮的滚压头重量 Rolling head weight without shank and rolls

m-Ro = 1组3件滚轮的重量 Weight of 1 set of 3 rolls

## 更换连接柄EVOline Change shanks EVOline

| 型号<br>Type  | 订货号<br>Ident No. |
|-------------|------------------|
| R25-规格3     | 7139628          |
| R30-规格3     | 7139630          |
| R1-规格3      | 7139632          |
| R1 1/4-规格3  | 7139634          |
| R1 1/2-规格3  | 7139636          |
| VDI-25-规格3  | 7139638          |
| VDI-30-规格3  | 7139640          |
| VDI-40-规格3  | 7139642          |
| HSK-A63-规格3 | 7139644          |



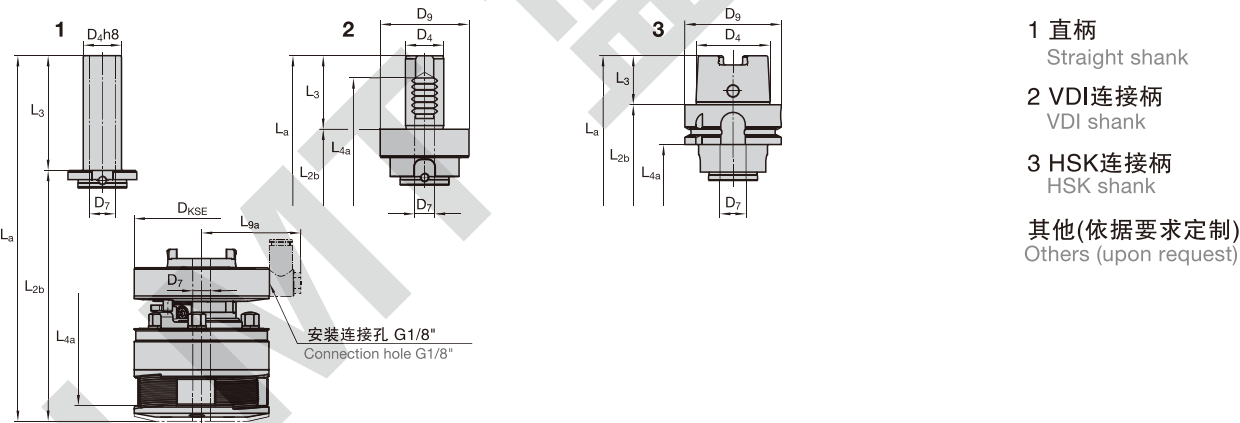
| 连接柄直径<br>Shank dia. | 尺寸单位为毫米 Dimension in inches |               |             |                  |                |                |                |                 |                |  |  |  |
|---------------------|-----------------------------|---------------|-------------|------------------|----------------|----------------|----------------|-----------------|----------------|--|--|--|
|                     | D4                          | D7            | D9          | D <sub>KSE</sub> | L              | L <sub>a</sub> | L <sub>2</sub> | L <sub>2b</sub> | L <sub>3</sub> |  |  |  |
| 25                  | 25   0.984"                 | 17   0.669"   | —           | 113   4.449"     | 172   6.772"   | 211,5   8.327" | 97   3.819"    | 136,5   5.374"  | 75   2.953"    |  |  |  |
| 30                  | 30   1.181"                 | 22,5   0.886" | —           | 113   4.449"     | 187   7.362"   | 226,5   8.917" | 97   3.819"    | 136,5   5.374"  | 90   3.543"    |  |  |  |
| 1                   | 25,4   1.000"               | 17   0.669"   | —           | 113   4.449"     | 172   6.772"   | 211,5   8.327" | 97   3.819"    | 136,5   5.374"  | 75   2.953"    |  |  |  |
| 1 1/4               | 31,75   1.250"              | 22,5   0.886" | —           | 113   4.449"     | 187   7.362"   | 226,5   8.917" | 97   3.819"    | 136,5   5.374"  | 90   3.543"    |  |  |  |
| 1 1/2               | 38,1   1.500"               | 22,5   0.886" | —           | 113   4.449"     | 187   7.362"   | 226,5   8.917" | 97   3.819"    | 136,5   5.378"  | 90   3.543"    |  |  |  |
| VDI-25              | 25   0.984"                 | 22,5   0.886" | 58   2.283" | 113   4.449"     | 168   6.614"   | 207,5   8.170" | 120   4.724"   | 159,5   6.280"  | 48   1.890"    |  |  |  |
| VDI-30              | 30   1.181"                 | 22,5   0.886" | 68   2.677" | 113   4.449"     | 177,5   6.988" | 217   8.543"   | 122,5   4.823" | 162   6.378"    | 55   2.165"    |  |  |  |
| VDI-40              | 40   1.575"                 | 22,5   0.886" | 83   3.268" | 113   4.449"     | 185,5   7.303" | 225   8.858"   | 122,5   4.823" | 162   6.378"    | 63   2.480"    |  |  |  |
| HSK-A63             | 48   1.890"                 | 22,5   0.886" | 63   2.480" | 113   4.449"     | 171,5   6.752" | 211   8.307"   | 139,5   5.492" | 179   7.047"    | 32   1.260"    |  |  |  |

相应紧固螺钉(2 x 7211622)和更换连接柄一起交付。 Change shanks will be delivered with the according fastening screws (2 x 7211622).

3号规格CCD EVOLine备件表 (F3/F34)  
Spare parts for CCD EVOLine Size 3 (F3/F34)



| 冷却剂驱动的闭合装置<br>Coolant operating closing device |            |                                                                                               | KSE   CCD<br>3号规格<br>(F3/F34)<br>订货号<br>Ident No.                                                                                               | 型号<br>Type                     | 订货号<br>Ident No. |
|------------------------------------------------|------------|-----------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|------------------|
| 备件编号<br>Part No.                               | 数量<br>Qty. | 备件描述<br>Part description                                                                      | 7137676<br>7137677<br>7137678<br>7137679<br>7146737<br>7137674<br>7155154<br>2142691<br>2142688<br>7123891<br>7167804-L<br>7167806-I<br>7211622 | KSE EVOLine Size 3<br>(F3/F34) | 7137675          |
| 1                                              | 1          | 壳体<br>Housing                                                                                 |                                                                                                                                                 |                                |                  |
| 2                                              | 1          | 罩板<br>Cover plate                                                                             |                                                                                                                                                 |                                |                  |
| 3                                              | 1          | 曲型活塞<br>Curved piston                                                                         |                                                                                                                                                 |                                |                  |
| 4                                              | 1          | 弹簧螺栓<br>Spring bolt                                                                           |                                                                                                                                                 |                                |                  |
| 5                                              | 1          | 防屑罩<br>Chip guard                                                                             |                                                                                                                                                 |                                |                  |
| 6                                              | 1          | 密封圈<br>Ring sealing                                                                           |                                                                                                                                                 |                                |                  |
| 7                                              | 1          | 压力弹簧<br>Pressure spring                                                                       |                                                                                                                                                 |                                |                  |
| 8                                              | 1          | 圆柱销<br>Cylindrical pin                                                                        |                                                                                                                                                 |                                |                  |
| 9                                              | 2          | 圆柱销<br>Cylindrical pin                                                                        |                                                                                                                                                 |                                |                  |
| 10                                             | 4          | 螺钉<br>Screw                                                                                   |                                                                                                                                                 |                                |                  |
| 11                                             | 1          | L- 与I-G <sup>1</sup> / <sub>8</sub> " 管接头<br>L- and I-Fitting G <sup>1</sup> / <sub>8</sub> " |                                                                                                                                                 |                                |                  |
| 12                                             | 2          | 螺钉<br>Screw                                                                                   |                                                                                                                                                 |                                |                  |



|                 | L <sub>4</sub> | L <sub>4a</sub> | L <sub>6</sub> | L <sub>9</sub> | L <sub>9a</sub> | L <sub>10</sub>      | m-Rs                 |
|-----------------|----------------|-----------------|----------------|----------------|-----------------|----------------------|----------------------|
|                 | —              | —               | 5   0.197 "    | 85,9   3.382 " | 订制 Individual   | 9,1   0.358 "        | 约0,34 kg 近似等于0.75 lb |
|                 | —              | —               | 5   0.197 "    | 85,9   3.382 " | 订制 Individual   | 9,1   0.358 "        | 约0,37 kg 近似等于0.82 lb |
|                 | —              | —               | 5   0.197 "    | 85,9   3.382 " | 订制 Individual   | 9,1   0.358 "        | 约0,34 kg 近似等于0.75 lb |
|                 | —              | —               | 5   0.197 "    | 85,9   3.382 " | 订制 Individual   | 9,1   0.358 "        | 约0,37 kg 近似等于0.82 lb |
|                 | —              | —               | 5   0.197 "    | 85,9   3.382 " | 订制 Individual   | 9,1   0.358 "        | 约0,4kg 近似等于0.88 lb   |
| 104,5   4.114 " | 144   5.669 "  | 5   0.197 "     | 85,9   3.382 " | 订制 Individual  | 9,1   0.358 "   | 约0,7kg 近似等于1.54 lb   |                      |
| 107,5   4.232 " | 147   5.787 "  | 5   0.197 "     | 85,9   3.382 " | 订制 Individual  | 9,1   0.358 "   | 约0,94 kg 近似等于2.07 lb |                      |
| 156,5   6.161 " | 196   7.717 "  | 5   0.197 "     | 85,9   3.382 " | 订制 Individual  | 9,1   0.358 "   | 约1,42 kg 近似等于3.13 lb |                      |
| 101,5   3.996 " | 141   5.551 "  | 5   0.197 "     | 85,9   3.382 " | 订制 Individual  | 9,1   0.358 "   | 约1kg 近似等于2.21 lb     |                      |

m-Rs = 连接柄重量      Weight shank



| MF                                             |  |                 |                 |
|------------------------------------------------|--|-----------------|-----------------|
| 公称尺寸x节距<br>Nominal size x pitch<br>mm   inch   |  | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                                |  | 订 货号            |                 |
| MF 12 ... 14 x 1                               |  | 1516800         | 1516819         |
| MF 14 ... 16 x 1                               |  | 1516828         | 1516837         |
| MF 16 ... 18 x 1                               |  | 1516846         | 1516855         |
| MF 18 ... 20 x 1                               |  | 1516864         | 1516882         |
| MF 16 ... 18 x 1,5                             |  | 1517006         | 1517015         |
| MF 18 ... 20 x 1,5                             |  | 1517042         | 1517060         |
| MF 20 ... 22 x 1,5                             |  | 1517088         | 1517113         |
| MF 22 ... 24 <sup>1)</sup> x 1,5               |  | 1517159         | 1517177         |
| MF 24 <sup>1)</sup> ... 27 <sup>1)</sup> x 1,5 |  | 1517195         | 1517202         |
| MF 27 <sup>1)</sup> ... 30 <sup>1)</sup> x 1,5 |  | 1517220         | 1517248         |

| <div>UN</div> <div>UNF</div> <div>UNEF</div> |                                         |     |                 |                 |
|----------------------------------------------|-----------------------------------------|-----|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI               |                                         |     | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                              |                                         |     | 订 货号            |                 |
| UNEF                                         | 1/2                                     | -28 | 2243650         | 2243655         |
| UN                                           | 5/8 ... 11/16                           | -28 | 2165494         | 2246320         |
| UN                                           | 11/16 ... 3/4                           | -28 | 2246314         | 2246321         |
| UN                                           | 3/4 ... 13/16                           | -28 | 2246315         | 2246322         |
| UN                                           | 13/16 ... 7/8                           | -28 | 2246318         | 2246324         |
| UNEF                                         | 9/16 ... 5/8                            | -24 | 2243651         | 2243656         |
| UNEF                                         | 5/8 ... 11/16                           | -24 | 2240319         | 2243657         |
| UN                                           | 5/8 ... 11/16                           | -20 | 2246313         | 2246319         |
| UNEF                                         | 3/4 ... 13/16                           | -20 | 2243652         | 2243658         |
| UNEF                                         | 13/16 ... 7/8                           | -20 | 2166331         | 2166820         |
| UNEF                                         | 7/8 ... 15/16 <sup>1)</sup>             | -20 | 2243653         | 2243659         |
| UNEF                                         | 15/16 <sup>1)</sup> ... 1 <sup>1)</sup> | -20 | 2168615         | 2243660         |
| UNF                                          | 5/8                                     | -18 | 1517505         | 1517514         |
| UNEF                                         | 11/16 <sup>1)</sup> ... 11/8            | -18 | 2243654         | 2243661         |
| UNF                                          | 11/16 ... 3/4                           | -16 | 2169256         | 2241532         |
| UNF                                          | 3/4 ... 13/16                           | -16 | 1517523         | 1517541         |
| UN                                           | 7/8 ... 15/16 <sup>1)</sup>             | -16 | 2246317         | 2241474         |
| UNF                                          | 7/8                                     | -14 | 1517550         | 1517569         |
| UN                                           | 7/8 ... 15/16 <sup>1)</sup>             | -12 | 2246316         | 2246323         |
| UNF                                          | 1 <sup>1)</sup>                         | -12 | 1517578         | 1517587         |

| BSFS                                               |                 |                 |     |
|----------------------------------------------------|-----------------|-----------------|-----|
| 公称尺寸xTPI<br>Nominal size x TPI                     | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k | 订货号 |
|                                                    |                 |                 |     |
| BSFS 9/16 ... 5/8 -26                              | 2243620         | 2243634         |     |
| BSFS 5/8 ... 11/16 -26                             | 2243621         | 2243635         |     |
| BSFS 11/16 ... 3/4 -26                             | 2243622         | 2243636         |     |
| BSFS 3/4 ... 13/16 -26                             | 2243623         | 2243637         |     |
| BSFS 9/16 ... 5/8 -20                              | 2243624         | 2243638         |     |
| BSFS 5/8 ... 11/16 -20                             | 2243625         | 2243639         |     |
| BSFS 11/16 ... 3/4 -20                             | 2243626         | 2243640         |     |
| BSFS 3/4 ... 13/16 -20                             | 2243627         | 2243641         |     |
| BSFS 13/16 ... 7/8 <sup>1)</sup> -20               | 2243629         | 2243642         |     |
| BSFS 7/8 <sup>1)</sup> ... 15/16 <sup>1)</sup> -20 | 2243630         | 2243643         |     |
| BSFS 15/16 <sup>1)</sup> ... 1 <sup>1)</sup> -20   | 2240197         | 2243644         |     |
| BSFS 11/16 ... 3/4 -16                             | 2241703         | 2243645         |     |
| BSFS 3/4 ... 13/16 -16                             | 2243631         | 2243646         |     |
| BSFS 11/8 <sup>1)</sup> -12                        | 2243632         | 2243647         |     |
| BSFS 11/16 <sup>1)</sup> -10                       | 2243633         | 2243648         |     |

| <div>G</div>                   |                                            |                 |                 |
|--------------------------------|--------------------------------------------|-----------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI |                                            | 导程1k<br>Lead 1k | 导程2k<br>Lead 2k |
|                                |                                            | 订 货 号           |                 |
| G                              | $\frac{3}{8}$ - 19                         | 1517408         | 1517417         |
| G                              | $\frac{1}{2}$ ... $\frac{5}{8}^{(1)}$ - 14 | 1517435         | 1517444         |
| G                              | $\frac{3}{4}^{(1)}$ - 14                   | 1517462         | 1517471         |
| G                              | $\frac{7}{8}^{(1)}$ - 14                   | 2168006         | 2243649         |

| NPT                            |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
|                                | 订货号             |
| NPT 3/4 - 14                   | 1517756         |
| NPT 1/2 - 14                   | 1517738         |
| NPT 3/8 - 18                   | 1517710         |

| NPTF                           |                 |
|--------------------------------|-----------------|
| 公称尺寸xTPI<br>Nominal size x TPI | 导程1k<br>Lead 1k |
|                                | 订货号             |
| NPTF 3/4 – 14                  | 1517774         |
| NPTF 1/2 – 14                  | 1517765         |
| NPTF 3/8 – 18                  | 2165391         |

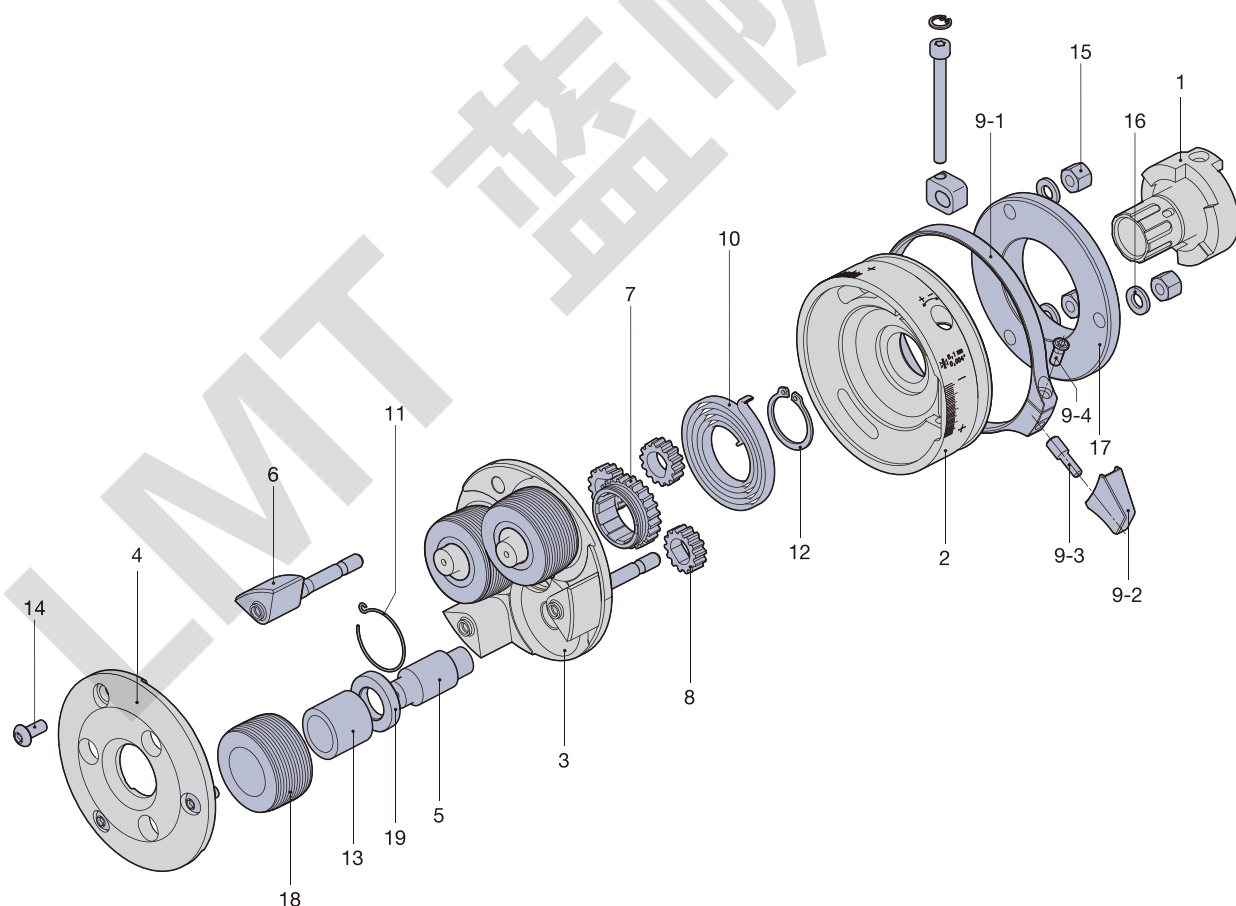
<sup>1)</sup> 适用于24 mm/0.945"以内的短螺纹，含退刀槽。

For short threads up to 24 mm/0.945" including runout.

同一栏内螺纹尺寸可以使用一组滚轮进行滚压加工。

Thread dimensions combined in one block can be rolled with **one** set of rolls.

| 滚压头<br>Rolling head |            |                                 | F34 EVO          | 滚压头<br>Rolling head |            |                               | F34 EVO          |
|---------------------|------------|---------------------------------|------------------|---------------------|------------|-------------------------------|------------------|
| 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description        | 订货号<br>Ident No. | 备件编号<br>Part No.    | 数量<br>Qty. | 备件描述<br>Part description      | 订货号<br>Ident No. |
| 1                   | 1          | 离合器<br>Clutch                   | 7146721          | 9-4                 | 1          | 螺钉<br>Screw                   | 2237766          |
| 2                   | 1          | 调节器壳体<br>Adjustment housing     | 7146722          | 10                  | 1          | 螺旋弹簧<br>Coil spring           | 2165032          |
| 3                   | 1          | 中心板<br>Center plate             | 7156357          | 11                  | 1          | 卡簧<br>Circlip                 | 2165033          |
| 4                   | 1          | 前板<br>Front plate               | 7156358          | 12                  | 1          | 卡簧 DIN 471<br>Circlip DIN 471 | 7132606          |
| 5                   | 3          | 偏心主轴<br>Eccentric spindle       | 2165534          | 13                  | 3          | 硬质合金衬套<br>Carbide bushing     | 2164887          |
| 6                   | 3          | 固定螺柱<br>Spacer stud             | 7156359          | 14                  | 3          | 螺钉<br>Screw                   | 7132607          |
| 7                   | 1          | 中心齿轮<br>Center gear             | 7156361          | 15                  | 3          | 螺母<br>Cover nut               | 2143583          |
| 8                   | 3          | 正齿轮<br>Spur gear                | 7156362          | 16                  | 3          | 垫圈<br>Washer                  | 2143366          |
| 9                   | 1          | 完整闭合手柄<br>Closing clip complete | 7146730          | 17                  | 1          | 防屑罩<br>Chip guard             | 7146725          |
| 9-1                 | 1          | 挡圈<br>Clip                      | 7146731          | 18                  | 3          | 滚轮<br>Roll                    | 订制<br>individual |
| 9-2                 | 1          | 手柄<br>Hand grip                 | 7146732          | 19                  | 3          | 垫圈<br>Washer                  | 2165539          |
| 9-3                 | 1          | 螺纹销<br>Threaded pin             | 7146733          |                     |            |                               |                  |





**自动闭合**  
**冷却液驱动闭合装置**  
Automated  
Closing with coolant-operated closing device

滚压加工后，滚压头自动打开  
Rolling process, head opens automatically



滚压头处于打开位置  
Rolling head to be returned to initial position



通过机床设备执行M-Function从而驱动闭合装置运行  
Operating the closing device by M-Function through machine control



滚压头闭合  
Rolling head is closed



闭合滚压头进入初始状态  
Moving the head to original position

**节省:**  
加工每个工件节省近7-15秒

**Saving:**  
Process time > approx. 7-15 sec. per workpiece  
(depending on process design)

**机械式闭合**  
**通过闭合环闭合**  
Mechanical  
Closing with closing clip

滚压加工后，滚压头自动打开  
Rolling process, head opens automatically



滚压头处于打开位置  
Rolling head to be returned to initial position



移动至闭合机件位置  
Positioning towards closing mechanism



移动滚压头（快速转动）以机械式方式闭合滚压头  
Moving the head (in rapid traverse rate resp. feed rate)  
to closing mechanism



滚压头闭合  
Rolling head will be closed



闭合滚压头进入初始状态  
Moving the head to original position



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## LMT 上海办事处

上海市长宁区金钟路968号凌空SOHO 6幢608室  
(邮编: 200335)  
电话: 021-62959800  
传真: 021-62959855

## LMT Shanghai Office

608#, Blk.6, Sky SOHO, No.968 Jinzhong Rd.,  
Changning District, Shanghai, 200335, PRC  
Tel: 021-62959800  
Fax: 021-62959855

## LMT 南京办事处

南京市江宁经济开发区蓝帆路9号  
(邮编: 211100)  
电话: 025-52128866  
传真: 025-52106376

## LMT Nanjing Office

9 Lanzhi Road, Jiangning Development Zone,  
Nanjing, 211100, PRC  
Tel: 025-52128866  
Fax: 025-52106376

## LMT 北京办事处

北京市朝阳区东四环中路39号华业国际中心B座605室  
(邮编: 100025)  
电话: 010-84801475  
传真: 010-84801474

## LMT Beijing Office

605#, Blk.B, No.39 Middle East 4th Ring Road,  
Chaoyang District, Beijing, 100025, PRC  
Tel: 010-84801475  
Fax: 010-84801474

## LMT 沈阳办事处

沈阳市铁西区建设中路12-5号万科金域国际4号2-17-2  
(邮编: 110021)  
电话: 024-25635819  
传真: 024-25635245

## LMT Shenyang Office

2-17-2#, Blk.4, Vanke Jinyu International, No.12-5  
Middle Jianshe Rd., Tiexi District, Shenyang, 110021, PRC  
Tel: 024-25635819  
Fax: 024-25635245

## LMT 重庆办事处

南京市江宁经济开发区蓝帆路9号  
(邮编: 211100)  
电话: 025-52128866  
传真: 025-52106376

## LMT Chongqing Office

9 Lanzhi Road, Jiangning Development Zone,  
Nanjing, 211100, PRC  
Tel: 025-52128866  
Fax: 025-52106376

## LMT 武汉办事处

南京市江宁经济开发区蓝帆路9号  
(邮编: 211100)  
电话: 025-52128866  
传真: 025-52106376

## LMT Wuhan Office

9 Lanzhi Road, Jiangning Development Zone,  
Nanjing, 211100, PRC  
Tel: 025-52128866  
Fax: 025-52106376

## 南京蓝帆金属加工技术有限公司 LMT China Co., Ltd.

南京市江宁经济开发区蓝帆路9号 (邮编: 211100)  
9 Lanzhi Road, Jiangning Development Zone,  
Nanjing, 211100, PRC  
电话: 025-52128866  
传真: 025-52106376  
Email: [info.cn@lmt-tools.com](mailto:info.cn@lmt-tools.com)  
[www.lmt-tools.com.cn](http://www.lmt-tools.com.cn)



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