

# Thread Rolling Attachment

The non-cutting technology for:

- threads behind a collar
- threads close to a collar
- very short threads
- threads with a very short run-out
- in case axial machining is not possible due to lack of space
- in case the end of the work piece is not free



The **Thread Rolling Attachment** is a wonderful invention. It is produced with the know-how of the specialist WAGNER<sup>®</sup> Werkzeugsysteme Müller GmbH in Pliezhausen. With this Thread Rolling Attachment, you will produce external threads of highest surface quality in record times. Due to their non-interrupted fibre course, the rolled threads are built for greatest strains.

The **thread rolls** are built to the thread that is to be produced, in diameter, angle and form. Every pair of rolls is designed for one thread measure. The material and the production of our thread rolls has been developed for the special requirements of the non-cutting technology.

The **adaptor** is the component between the Thread Rolling Attachment and the tool machine. The prism clamping enables a fast exchange of tools. The exact positioning of

the Thread Rolling Attachment allows automatic focusing on the centre of the work piece.

#### Types of Threads:

- cylindrical and conical external threads
- right- and lefthand external threads
- norm- and fine external threads
- special threads

#### Material and Preparation:

- the material can be shaped in cold state
- the necessary start diameter can be achieved in the required precision

#### Numbers:

- great numbers
- serial parts

#### Machine tools:

- single- and multiple spindle lathes with cross slide
- CNC lathes

## Range of Tools:

### ✓ Thread Rolling Attachments

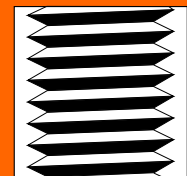
- Thread Rolling Heads
- Thread Cutting Heads
- Multi-Cutter Turning Heads
- Driven Tools

**Better**

**Faster**

**Cheaper**

**More robust**



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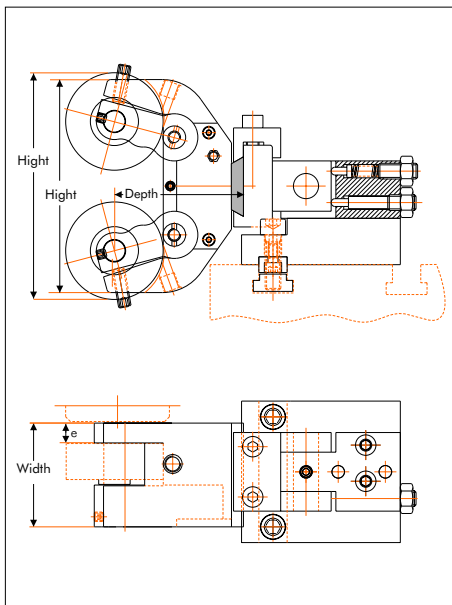
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## Thread Rolling Attachment

Make your choice for a WAGNER<sup>®</sup> Thread Rolling Attachment today:

- Rolls of the WAGNER<sup>®</sup> Thread Rolling Attachments programme reach long die-life-times as the rolls are big and the large diameter means that a long distance is available for wear and tear.
- Costs are reduced to a minimum as the WAGNER<sup>®</sup> Thread Rolling Attachment is extremely robust and build for a long life. Every single component fulfils highest requirements regarding stability and stiffness.
- The body of the WAGNER<sup>®</sup> Thread Rolling Attachment is closed and static. Thus, the forces caused by the shaping process are absorbed directly in the tool's body without
- WAGNER<sup>®</sup> Thread Rolling Attachments have a big gap in the tool and thus allow the insertion of thread rolls that fit perfectly in size and diameter.
- WAGNER<sup>®</sup> Thread Rolling Attachments roll highly precise thread profiles as the synchronisation of the pair of rolls is done via very stable gearwheels. Using an adjusting screw, the rolls can be adjusted very precisely during the work process. with this special development of WAGNER<sup>®</sup>, an optimum in thread rolling is achieved.



### Example for use:

A Thread Rolling Attachment on a cross slide

Do you need solutions for special tasks?  
Please ask us.



The WAGNER<sup>®</sup> Thread Rolling Attachment with an adaptor with VDI-shank for CNC-lathes with disk revolvers



The WAGNER<sup>®</sup> Thread Rolling Attachment in short build for CNC lathes with star revolver



The WAGNER<sup>®</sup> Thread Rolling Attachment with adaptor for single- and multi spindle lathes with cross slide

Type	Metric Norm Thread Desired-Ø	Metric Fine Thread Desired-Ø	Thread length max.	Weight kg		Max. Feed force N	Dimensions			Dimension »B«
				Tool with rolls	Adaptor		Width	Height	Depth	
B 8-W	1.6 - 12	2 - 13	14	1.0	appr. 1.5	1600	36.6	76.2	47.5	6.5
B 10-W	2 - 16	3 - 16	19	2.1	appr. 1.7	2490	50	92	65	10
B 13-W	3 - 22	3 - 30	25.5	3.8	appr. 2.0	4890	66	114	79.5	13
B 15-W	6 - 22	6 - 45	25.5	4.5	appr. 2.0	5700	66.2	135 to 147	83.4	13
B 18-W	6 - 27	6 - 42	32	7.0	appr. 3.0	6230	79	156	95.5	16
B 36	8 - 33	8 - 56	32	11.5	appr. 4.5	9790	90	200	115	21

Measures in mm

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