

ALCO FIXED / ROTATING 'R' TYPE THREAD ROLLING HEADS



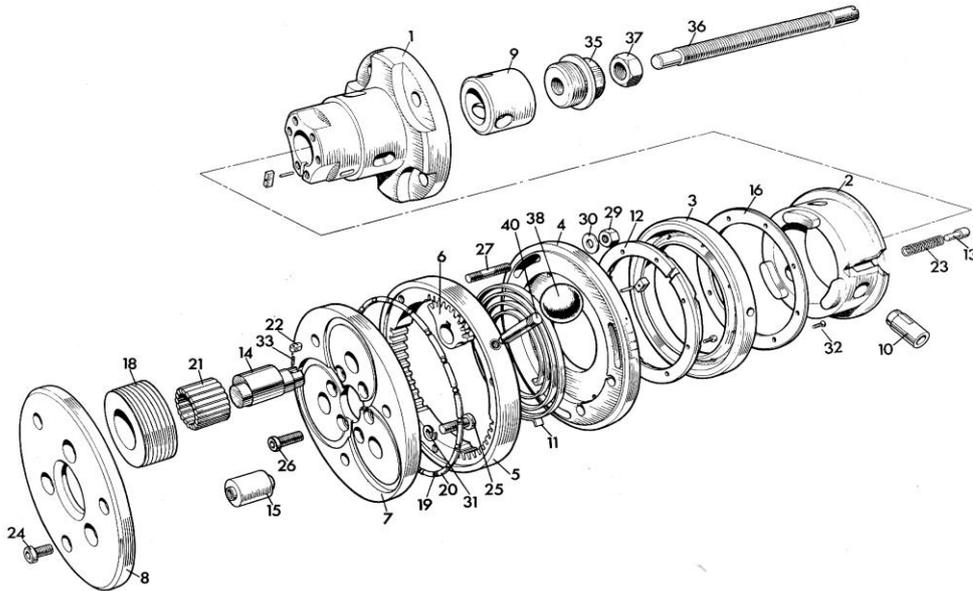
This range of heads includes:-
for coarse threads; **A4, A5, A6**
for fine threads; **A45, A56**

All are three roll heads. Thread rolls for these heads are not held in stock but can be supplied in 7-10 days.

The rolls are mounted onto the eccentric spindles in the same manner as for the 'F' type heads.

These heads are flange mounted. Shank mounted versions can be supplied, these are suffixed RN, eg A4RN.

Operated as a stationary head, closure is by means of the handle. Opening is achieved by use of an internal stop (36).



When operated in rotating mode the head is closed as follows:-

The non rotating operating ring (3) is forced against the brake ring (12) causing a reduction of speed of the gear ring (5) relative to the flanged driver (1). This has the same effect as using the handle in stationary mode, closing the head.

The head opens when the workpiece contacts the stop mechanism (36) causing the dog coupling (2) attached to the flanged driver (1) to move away from the head, and disengaging, allowing the spring (11) to throw the head open. For long threads the head can be opened by arresting its forward axial movement. The operating ring (3) will then push against the conral ring (16), which in turn forces the coupling (2) to disengage, releasing the spring (11).

Adjusting the head to size.

Ensure that the head is mounted so that the setting scale on the spring housing (4) is visible with the head closed.

Slacken the three nuts (29) until the internal gear ring (5) can be turned relative to the spring housing (4).

Close the head using the handle (38), ensuring the flange (1) is held stationary.

Insert a screw plug setting gauge or a plain gauge turned to the root diameter of the thread to be rolled, between the rolls and rotate the roll cage (front of the head) anti clockwise until the rolls locate onto the gauge.

Remove the gauge and set the head closer by 1 to 1.5 divisions on the scale. This takes up the play in the needle bearings. Tighten the nuts (29). Do not over tighten.