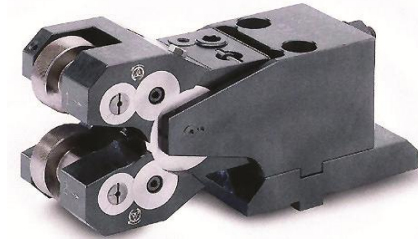


ALCO TANGENTIAL THREAD ROLLING HEADS



This range of thread rolling heads includes:-
RT10, RT20, RT30.

Rolls are in sets of two. A separate set of rolls is required for each thread. The maximum length of thread is the width of the rolls.

Can be used on CNC, Multi spindle and automatic lathes.

This head is for use on the cross slide where the work is rotating and the feed is controlled. The thread is produced within 15 - 30 revolutions of the work piece.

Very short threads, tapered threads and threads behind a shoulder can be produced. Threads can also be rolled both sides of a shoulder if they are identical. See component on left as an example.

The whole attachment consists of the head and an adaptor to fit it to the machine. The adaptor is designed for the particular machine and is priced separately.



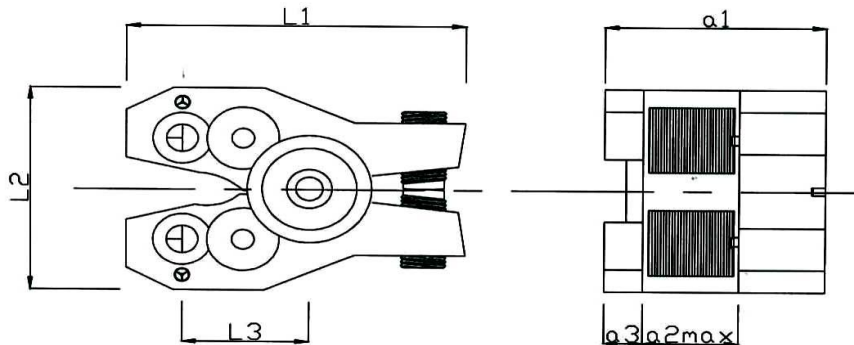
Operation of the head

The head is fed in on the cross slide until it contacts the work piece at 90 degrees to its axis. As it is fed onto the work piece it tangentially cold forms the thread. The thread will be completed as the centre line of the rolls approaches the centre line of the work piece, the head can then be withdrawn. Thread rolling speeds are 20-100 metres/minute. Typical rolling times are; 1/2"UNC 0.92 seconds, 1"BSF 2 seconds, 1/4 BSP 0.95 seconds.

Adjusting the head to size.

A setting piece is used to adjust the head to the thread diameter and locate the holder.

Dimensions



HEAD	L1	L2	L3	a1	a2 MAX*	a3	HEAD WEIGHT	HOLDER WEIGHT	ROLLS WEIGHT
RT10	69	64.5-68	23.2-27.6	43	15.5	7.2	0.65Kg	0.75Kg	0.2Kg
RT20	104	80-100.6	38.4	58	21.5	11.1	1.7Kg	2.4Kg	0.45Kg
RT30	124	115.5-143	43.1-53.5	83	31	15.8	4.9Kg	4.2Kg	1.4Kg

All dimensions are in mm. *a2max is maximum thread length. Weights are approximate.

Capacities

HEAD	METRIC/IMPERIAL	PIPE	MINIMUM PITCH	MAX ROLL WIDTH
RT10	mm	1.6 - 14	BSP 1/8 - 1/4	1.5
	inch	1/16 - 9/16	NPT 1/16 - 1/4	16
RT20	mm	2 - 30	BSP 1/8 - 3/4	2
	inch	5/64 - 1.3/16	NPT 1/6 - 3/4	12
RT30	mm	2 - 42	BSP 1/8 - 1.1/4	2.5
	inch	5/64 - 1.5/8	NPT 1/16 - 1.1/4	10