

Thread rolling heads and thread rolling with this heads:

Type: Zhv, Zhvu, RK

1.	What is usage of thread rolling heads?	By heads can be rolled thread on roller overware. This operation can be done on lathe, it is not necessary thread rolling machine.
2.	What heads do you produce?	NAREX MTE produces and delivers axial thread rolling heads fixed Zhv and universal heads Zhvu or heads RK (heads RK NAREX MTE does not produce, only sells).
3.	What threads can be rolled by these heads?	By fixed heads Zhv with unchanging slope of rolling disks can be rolled only sharp threads like metric - M, Whitwhorts - BSW, inch - UN, roller piped - G. By universal heads Zhvu or RK with changeable slope in range 0 - 5,5°, is possible to roll sharp threads, trapezial threads and round threads Rd.
4.	Is necessary for left run thread left head?	In case of fixed head Zhv - YES, in case of universal head Zhvu or RK - NO
5.	Why is impossible to roll with fixed head Zhv trapezial thread (Tr)?	For trapezila threads (Tr) rolling is necessary bigger angel of rolling disks than has fixed head Zhv.
6.	What more except rolling head is need for it?	Mainly thread rolling disks which are given according to type and size of the head and type and size of thread which we want to roll. Further we can need holder Dzvh for clamping head to the lathe.
7.	Where is head clamped to the lathe?	With holder DZH is clamped to tool head of lathe. On turret lathe is clamped to turret head, with special holder is possible to clamp it also to lathe tailstock.
8.	What to do with head before start of rolling?	A - on head put rolling disks in sequence according to instrucion for use B - head clamp to the machine C - aline head according to lathe spindle axial D - set head in light of middle diameter of rolling thread E - wind up the head
9.	What to do with machine?	A - clamp head B - choose suitable spindle revolutions according to rolling speed C - arrange stop on linear saddle in place where should head open D - set up cooling oil
10.	Is any demand on semiproduct on which will be thread rolled?	A - semiproducts material must have mechanical characteristics which allowe cold volumetric forming B - semiproducts diameter must be same like value from instrucion for use C - semiproducts face must have slope according to instructions for use
11.	Which material can be cold-rolling?	Constructional and alloyed steel with fort limit to 900 MPa and tuctility higher than 8%. Free cutting steel is unsuitable for cold rolling. Further aluminium alloy, copper alloy etc.
12.	Is it possible to bore threads on tubes?	It is possible. In case that tube has thiner wall must be used plug which is inserted in it not to be warped.
13.	Is it possible to roll threads to rustless material?	It is possible and in many cases it is more suitable to roll threads than its cutting. It must be fulfil condition of item 11 of this document.
14.	How long threads can be rolled by these heads?	Because these are axial heads, they can roll threads so long how you need. During rolling of extreme long threads is more suitable when semiproduct stands and head is turning.

15.	What the shortest threads can be rolled by these heads?	In this case is necessary to consider width of rolling rollers and thing that first two start mints do not have total profile and that is why they are functionless. If short thread should be functional in its full length there must start mints during switch-off the head finish in run-out of thread.
16.	What to do with head when there is impossible to screw the nut on cylindrical thread?	Middle diameter of rolled thread is too big and that is why is necessary to strip the head to smaller diameter. We use to it body scale of the head. After screwing of the nuts is body turned round for necessary number divisions of scale in direction of mark "-" (diameter diminish). Nuts are again tighten.
17.	What to do when thread can be screwed on the nut but heigh of rolled thread head is small?	In this case we will not do anything with head. A - try to heighten spindle revolutions to improve cross material flow B - slightly extend starting semiproducts diameter. The best way is to do both (A and B) simultaneously.
18.	Is used during thread rolling machine feed?	No it is not used, it is necessary fiercely fload by head on rotating semiproduct and after it only manually help to feeding saddle to avoid early switch-off the head.
19.	What to do when rooled thread is immediately followed by bigger diameter?	This is very uncomfortable situation for head because head must be the nearest to the face of bigger diameter and in this place reliably switch-off - it can not crash into the face . Here is suitable to use inside stop and the length of semiproduct will be produced in narrow toleration.
20.	Does cleanness of cooling fluid have any influence on rolled thread quality?	Of course it does. It is good and in some cases necessary to filter cooling fluid.
21.	Is it possible to roll by head double start thread?	It is possible, but it should be discussed with producer.