

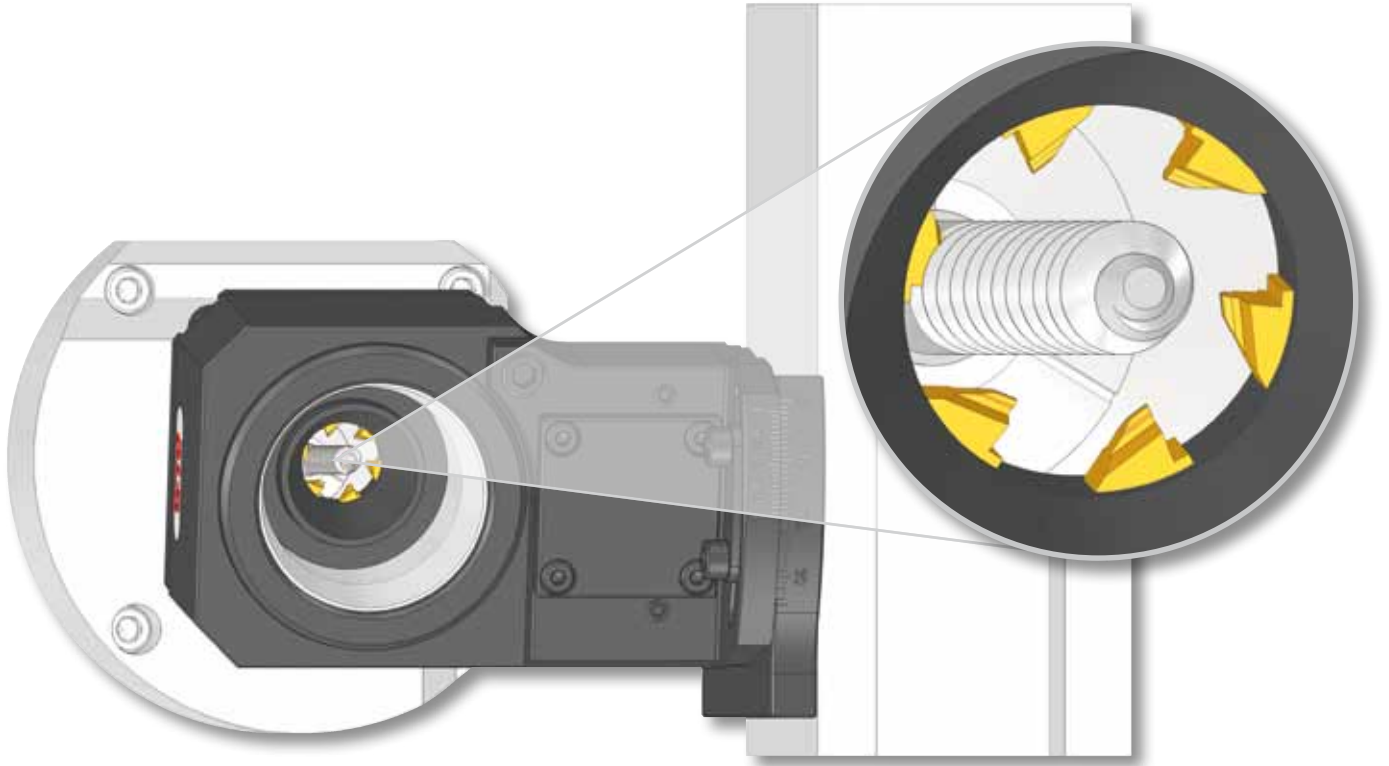
Thread Whirling Unit

High Productive Thread Whirling with patented quick change system for significant reduction of tool set-up time.

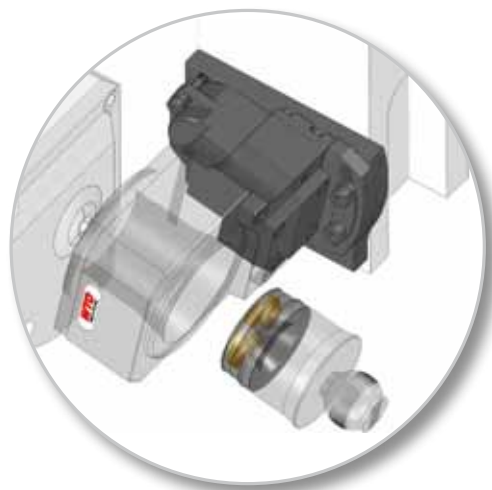
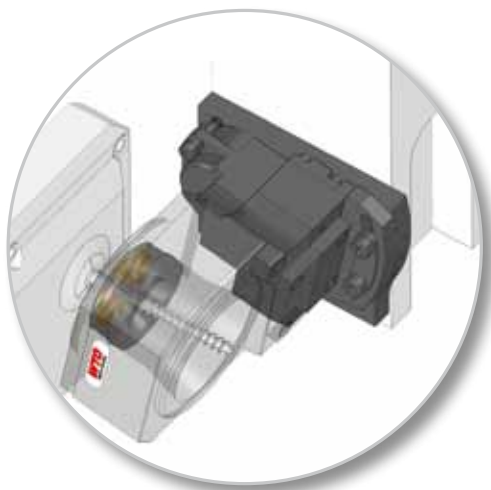
Suitable insert holders available from leading cutting tool manufacturers.



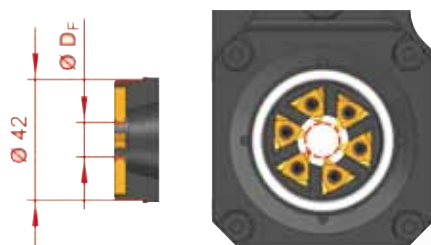
High Productive Thread Whirling



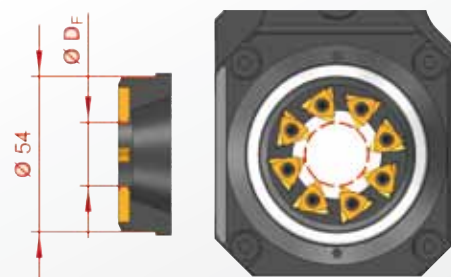
- | Patented quick change system for significant reduction of tool change time
- | The insert holder can quickly be changed from the backside
- | The thread whirling unit can remain installed and aligned in the machine tool
- | Low runout tolerance and high repeatability of the cutting inserts (± 0.005 mm)



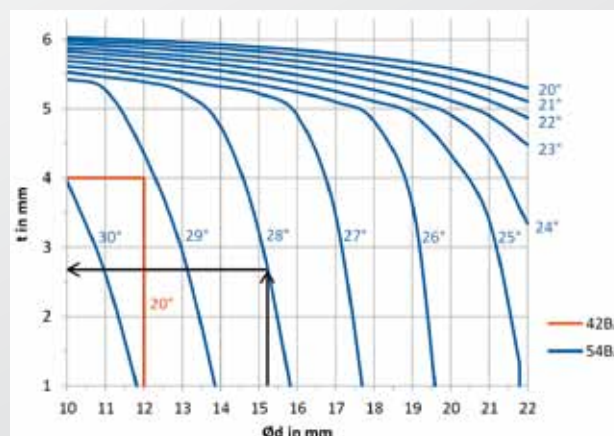
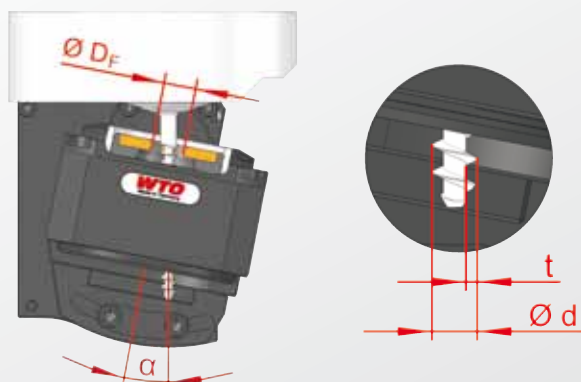
Thread whirling unit type 42BJ



Thread whirling unit type 54BJ



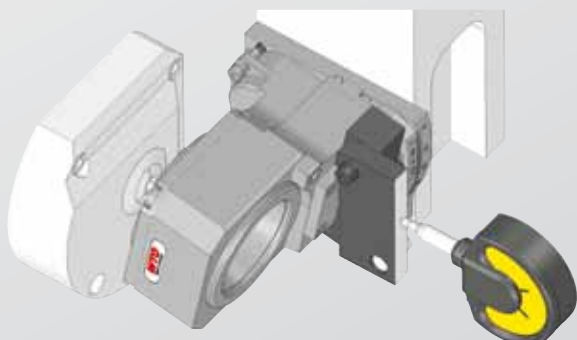
Type 42BJ		Type 54BJ
12 mm	Max. working diameter D_F	22 mm
0 – 20°	Adjustable range α	0 – 30°
4 mm	Max. profile depth t	6 mm
1 : 1	Ratio i ($n_1:n_2$)	1.36 : 1
8,000 1/min	Max. RPM (n_2)	6,000 1/min



Example type 54BJ: $\varnothing d = 15.2$ mm; $\alpha = 28^\circ \rightarrow t \leq 2.7$ mm

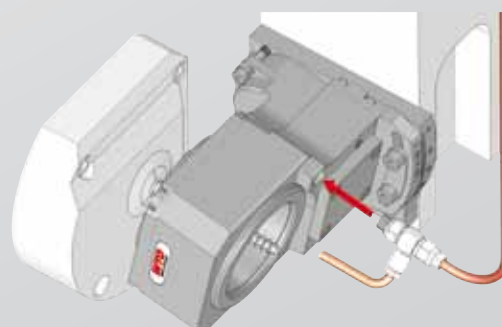
Optional accessories

Sine bar for high accurate angular adjustment



Item No. 96394

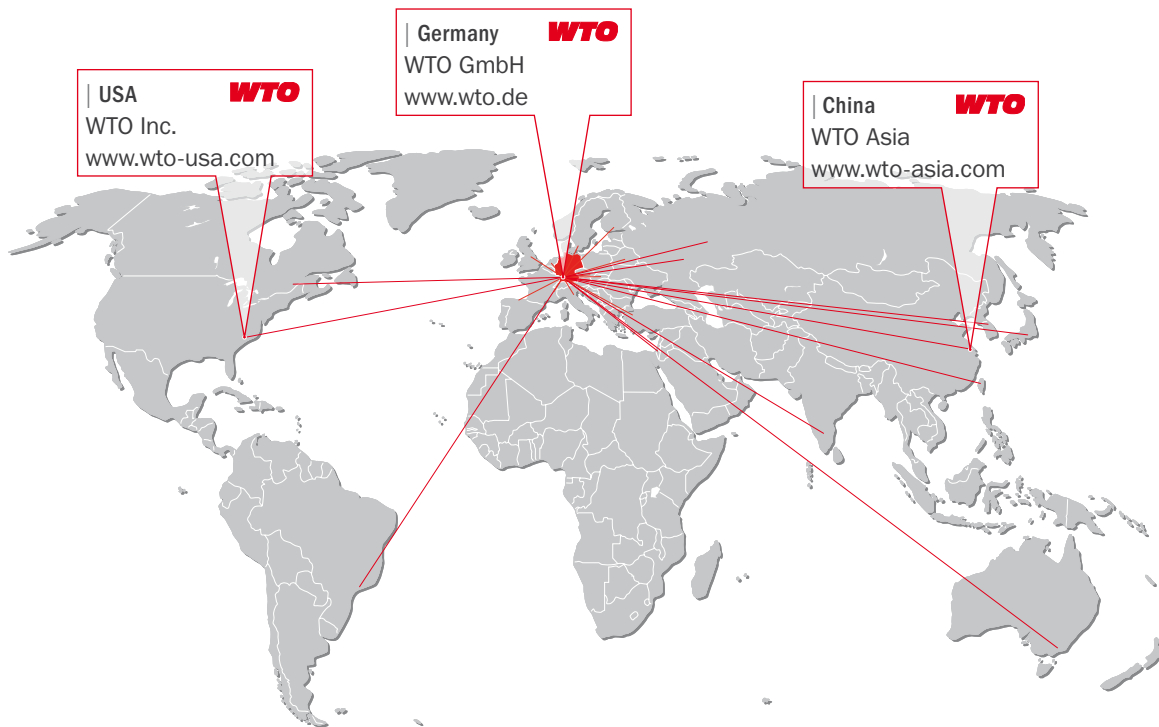
External coolant supply



Item No. 91749

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