

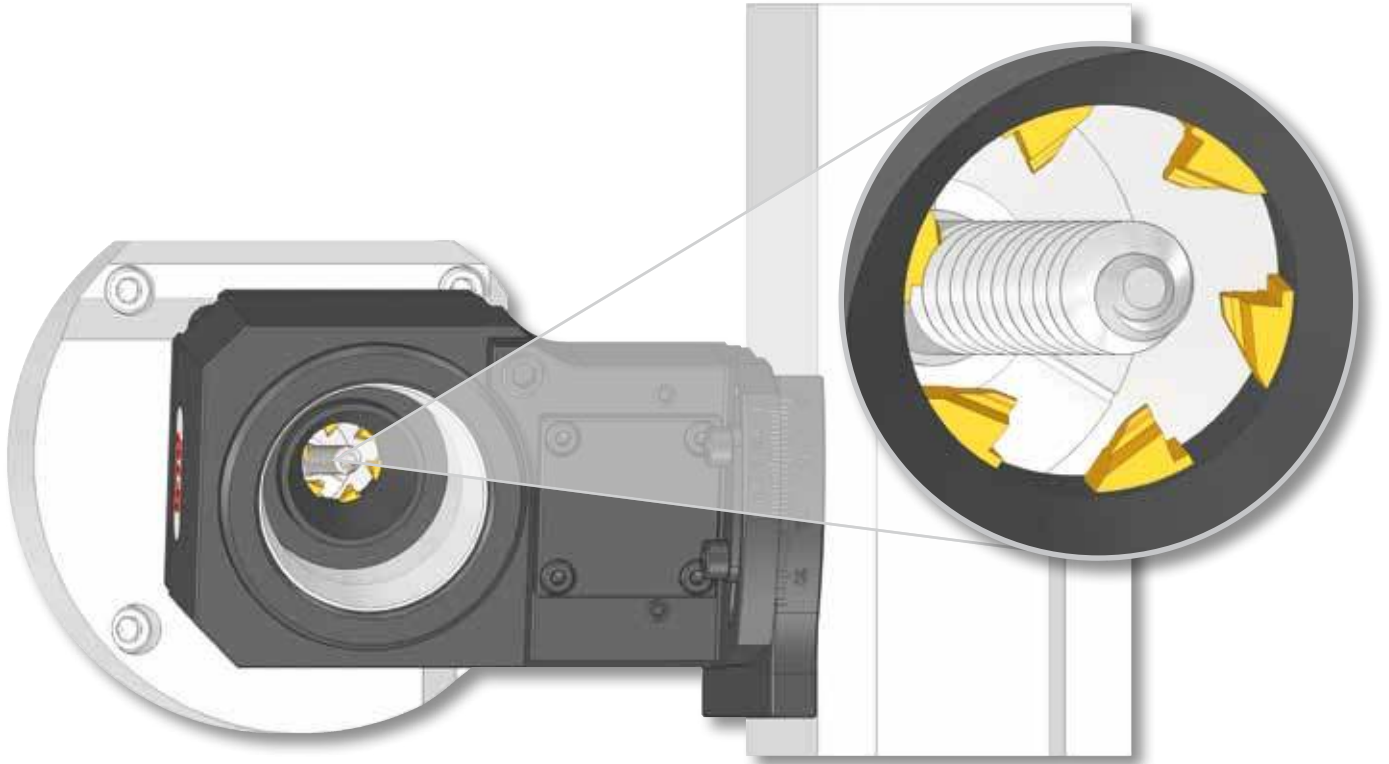
# Thread Whirling Unit

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

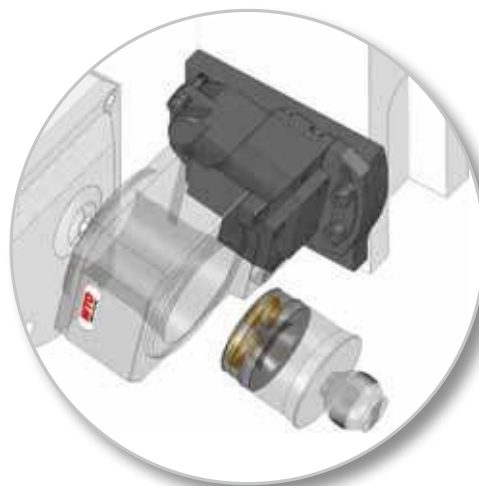
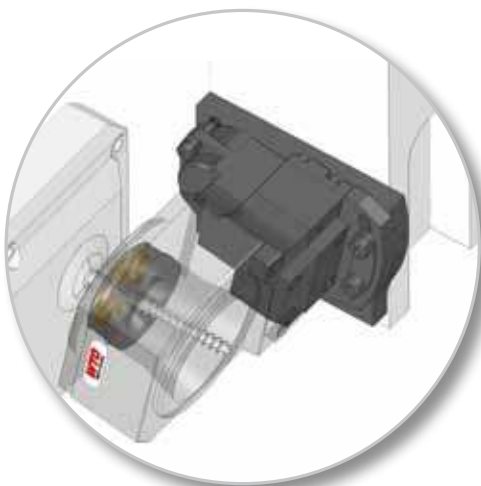
Suitable insert holders available from leading cutting tool manufacturers.



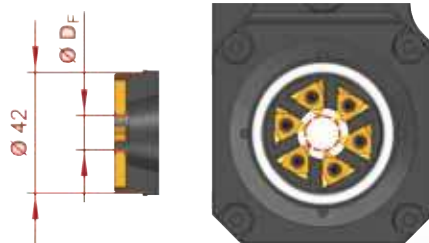
# High Productive Thread Whirling



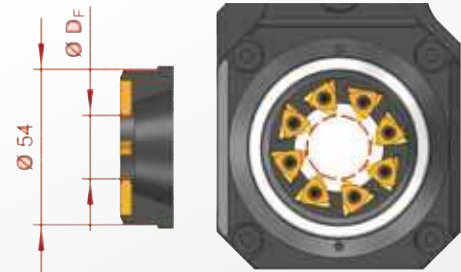
- | Patented quick change system for significant reduction of tool change time
- | The insert holder can quickly be changed from the backside
- | The thread whirling unit can remain installed and aligned in the machine tool
- | Low runout tolerance and high repeatability of the cutting inserts ( $\pm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



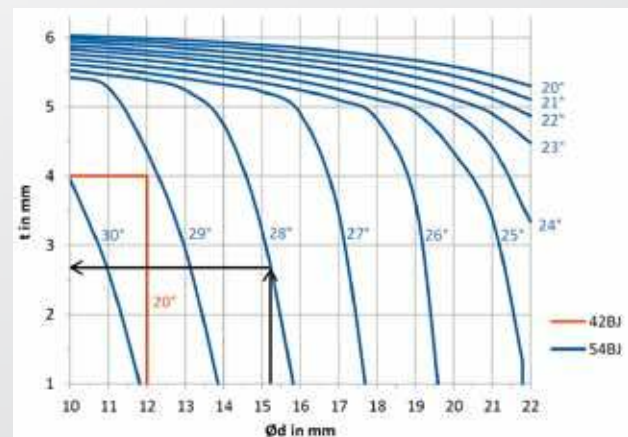
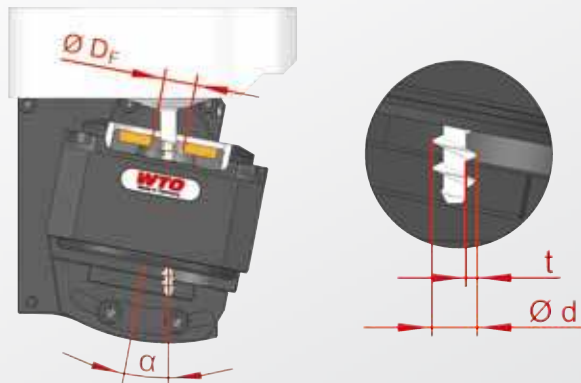
## Thread whirling unit type 42BJ



## Thread whirling unit type 54BJ



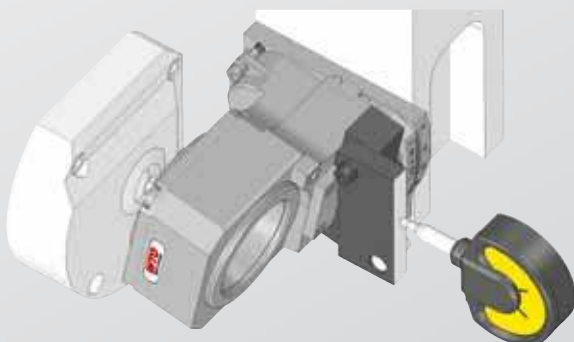
Type 42BJ		Type 54BJ
12 mm	Max. working diameter $D_F$	22 mm
0 – 20°	Adjustable range $\alpha$	0 – 30°
4 mm	Max. profile depth $t$	6 mm
1 : 1	Ratio $i$ ( $n_1:n_2$ )	1.36 : 1
8,000 1/min	Max. RPM ( $n_2$ )	6,000 1/min



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

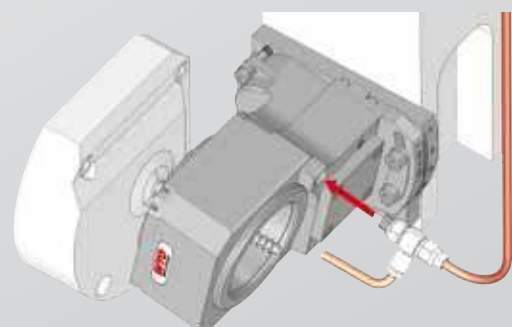
## Optional accessories

### Sine bar for high accurate angular adjustment



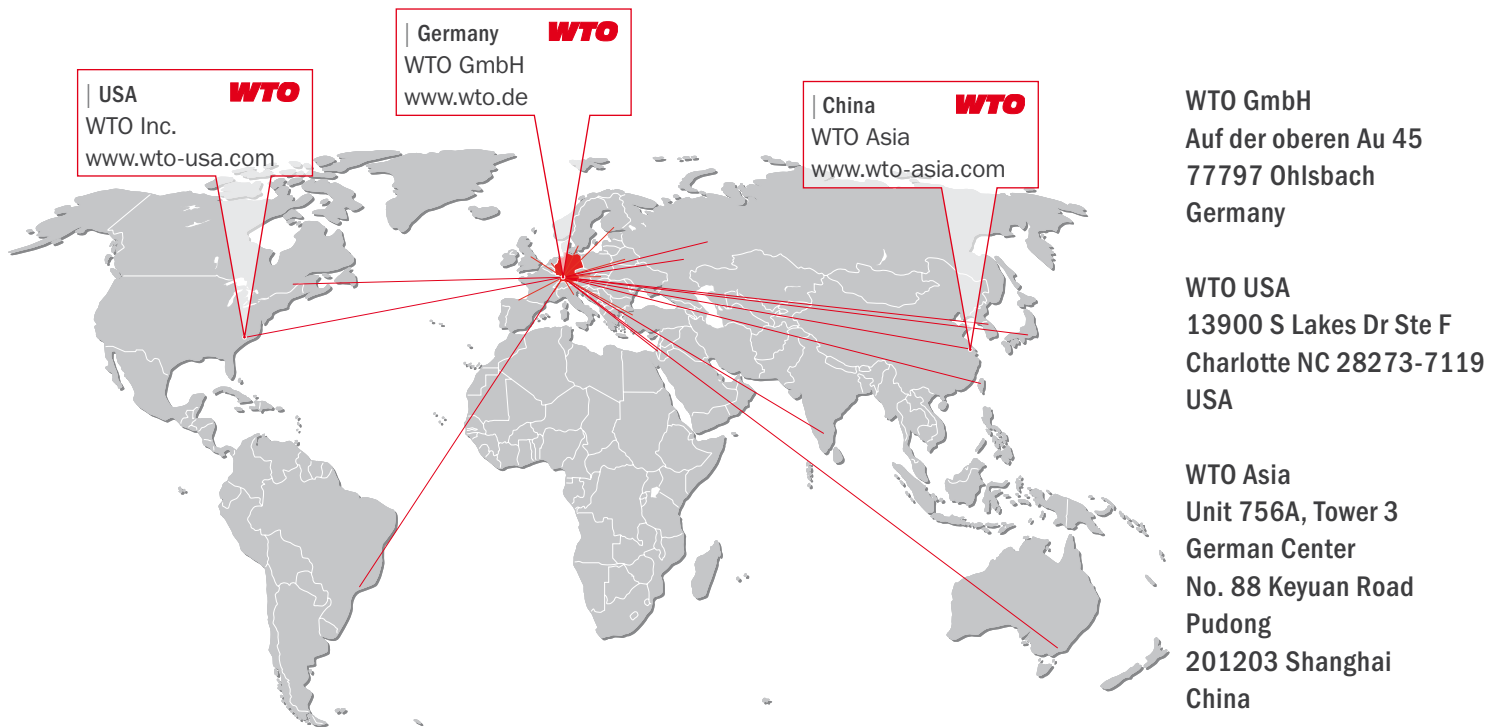
Item No. 96394

### External coolant supply



Item No. 91749

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