

Long die Pocket Thread Roller, VA-20-S

Closed Structure Thread Rollers with a Long Thread Die Pocket and a Dual Feed Rail system for rolling of:

- T Bolts and Flanged T Bolts
- Long Bolts, up to 300mm long under the head
- Flanged Bolts with threads rolled above the flange
- Standard Screws

Main Features:

- **Closed Frame structure** (the main spindle is pivoted on both sides) allowing to roll any length of parts up to 250mm long thread without compromising on the thread quality. Parallel thread is guaranteed!
- 250mm/300mm thread rolling dies pocket, that can be split into 2 or 3 separate pockets for the purpose of rolling a variety of parts, either under the head or over the head. A separate chamfer station is also available.
- **2 Separate Feed Rails**, for feeding long and short parts, as well as parts with a long portion above the head.
- **Hydraulic Clamping** of the thread rolling dies and **Micrometric Screws** for quick-change and precise adjustment of the thread rolling dies. When using more than one die pocket, each die is independently set.
- **Controlled Feed**, equalizing the line speed of the blank to the speed of the rotary die, thus eliminating slippage and resulting in high quality threads.
- **Introduction Shaft** with two floating feed arms mounted on it. The blank feed is done by one or two arms, assuring precise feed for many years of operation. There is no feed slide, and no springs. The feed force is by a pneumatic piston.
- Both sets of **Feed Rails are made out of stainless steel** with replaceable hardened liners in the working area. One rail is fixed in place, and the other one is adjusted by hand wheels, with no wrenches. The upper rail swings around a pivot, and is equipped with a spring loaded end, over the wide hold back finger, for parts threaded up to the head.
- Automatic air shut-off systems turn off the air supply to the feeder during the time it is not working and to the feed rails when the machine is not operating.
- The fine adjustment matching device allows perfect match of the dies, with the touch of a finger, without a plastic hammer. No other way is so simple and so effective for matching dies. Matching takes 3 minutes.
- An AC speed controller is supplied, enabling to run at the highest possible rate for each part.
- The Vibratory Feeder has fine adjustment settings, and a noise absorption layer inside. The feeder base is adjustable by manual



levers, without wrenches. To change the thread length, the whole feeder is lifted, from one point, with the feed rails.

- The whole feeder has quick-change features, enabling to replace one feeder by another, for special application parts.
- The VA series is designed to work 24 hours a day. It has no clutches, slides or hydraulics, and is requiring almost no maintenance.

