

Selbsttätigen Rohrwalzen BV

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Bei den selbsttätigen Rohrwalzen liegen die Mittelachsen von Dorn und Rollen nicht auf einer Ebene, d.h. die Rollen sind gegenüber dem Dorn schräg (drallgängig) gelagert. Das Prinzip dieser Rohrwalze beruht auf dem automatischen Selbstvorschub (im Englischen self-feeding), bedingt durch die Schräglage der Rollen. Diese Rohrwalzen können sowohl von Hand als auch maschinell angetrieben werden. Sie sind teilweise mit Kugellagern ausgestattet, so dass die Reibungswärme auf ein Minimum reduziert wird.



TECHNISCHE DATEN ROHRWALZEN BV

FÜR ROHRE MIT METRISCHEN ODER ZOLLMESSUNGEN

Größe = Körper-Ø	Rohrboden-dicke	Rollen-länge	Rollen-parabeln	Baureihe	Kappen-ausführung
mm	mm	mm			
7,2 - 8,5	10 - 30	30	1	BV) volle Kappe = 36
9,0 - 10,0	15 - 50	40	1	BV) Hebelkappe = 37
10,6 - 84,0	15 - 70	40	1	BV) Spannkappe = 38
7,2 - 8,5	10 - 100	30	2	BVL) volle Kappe = 36
9,0 - 10,0	15 - 100	40	2	BVL) Hebelkappe = 37
10,6 - 84,0	15 - 100	40	2	BVL) Spannkappe = 38
7,2 - 8,5	10 - 100	30	2	BVL) volle Kappe = 36
9,0 - 10,0	15 - 100	40	2	BVL) Hebelkappe = 37
10,6 - 84,0	15 - 100	40	2	BVL) Spannkappe = 38
10,6 - 84,0	25 - 70	50	1	BV) volle Kappe = 36
10,6 - 84,1	25 - 100	50	2	BVL) Hebelkappe = 37
10,6 - 84,2	25 - 150	50	2	BVL) Spannkappe = 38
10,6 - 84,0	35 - 70	60	1	BV) volle Kappe = 36
10,6 - 84,1	35 - 100	60	2	BVL) Hebelkappe = 37
10,6 - 84,2	35 - 150	60	2	BVL) Spannkappe = 38

Rohrwalzen für Rohrböden über 150 mm Dicke sind in Abstufungen von 50 mm erhältlich.

NUTZTIEFE 30 / 100 / 150 · ROLLENLÄNGE 30 mm (GRÖSSEN 7,2 - 8,5)

Größe = Körper-Ø	Aus-dehnung bis	Rohr-innen-Ø min.	Rohr-außen-Ø min.	Rohr-außen-Ø max.	Außen-kappe-Ø	Rohrvorstand / Eindrehung Kappe 0437	Rohrvorstand / Eindrehung Kappe 0438	Verst. von	WB*) bis	Nutz tiefe	Dorn vierkant
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm / inch
7,2	8,2	7,5	9,5	11,0	28,0	0	15,0	10 - 25	(20)	30	Zylinderschaft
7,5	8,5	7,8	9,5	12,0	28,0	0	15,0	10 - 25	(20)	oder	Zylinderschaft
7,7	8,7	8,0	9,5	13,0	28,0	0	15,0	10 - 25	(20)	100	Zylinderschaft
8,0	9,0	8,2	10,0	13,0	28,0	0	15,0	10 - 25	(20)	oder	Zylinderschaft
8,2	9,2	8,5	10,0	13,0	28,0	0	15,0	10 - 25	(20)	150	Zylinderschaft
8,5	9,5	8,8	10,0	14,0	28,0	0	15,0	10 - 25	(20)	...	Zylinderschaft

*) Klammerwerte = max. Walzbreite für Rollen mit beidseitiger Parabel

Selbsttätigen Rohrwalzen BV

NUTZTIEFE 50 / 70 / 100 / 150 mm · ROLLENLÄNGE 40 mm (GRÖSSEN 8,8 - 70,0)

Größe = Körper-Ø	Aus- dehnung bis	Rohr- innen-Ø min.	Rohr- außen-Ø min.	Rohr- außen-Ø max.	Außen- kappe-Ø	Rohrvorstand / Eindrehung		Verst. WB*) von	Verst. WB*) bis	Nutz- tiefe	Dom Vierkant
						Kappe 0437	Kappe 0438				
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	zoll
8,8	10,0	9,0	11,0	14,0	28,0	2	20,0	15	35 (30)	50	3/8
9,0	10,2	9,3	11,0	14,0	28,0	2	20,0	15	35 (30)	oder	3/8
9,6	10,8	10,0	11,5	14,0	28,0	2	20,0	15	35 (30)	100	3/8
10,0	11,3	10,3	12,0	14,0	28,0	2	20,0	15	35 (30)	oder	3/8
10,6	11,8	11,0	12,5	16,0	28,0	2	20,0	15	35 (30)	150	3/8
11,4	12,7	11,8	13,5	16,0	28,0	2	20,0	15	35 (30)		3/8
12,0	13,8	12,3	14,5	19,0	30,0	2	20,0	15	35 (30)	70	3/8
12,6	14,6	13,0	15,5	19,0	30,0	2	20,0	15	35 (30)	oder	3/8
13,0	15,0	13,3	15,7	19,0	30,0	2	20,0	15	35 (30)	100	3/8
13,8	15,9	14,0	16,5	20,0	32,0	2	20,0	15	35 (30)	oder	3/8
14,5	16,6	14,8	17,5	20,0	32,0	2	20,0	15	35 (30)	150	3/8
15,0	17,3	15,3	18,0	20,0	32,0	2	20,0	15	35 (30)		3/8
15,5	17,7	15,8	18,5	20,0	32,0	2	20,0	15	35 (30)		3/8
16,0	18,4	16,3	19,0	23,0	35,0	3	20,0	15	35 (30)		3/8
16,5	18,6	16,8	19,5	23,0	35,0	3	20,0	15	35 (30)		3/8
17,0	19,0	17,3	20,0	23,0	35,0	3	20,0	15	35 (30)		3/8
17,5	19,7	18,0	20,5	25,4	35,0	3	20,0	15	35 (30)		3/8
18,4	21,2	19,0	22,0	25,4	40,0	3	20,0	15	35 (30)		3/8
19,0	21,5	19,5	22,5	25,4	40,0	3	20,0	15	35 (30)		3/8
19,5	21,8	20,0	23,0	25,4	40,0	3	20,0	15	35 (30)		3/8
20,0	23,0	20,5	24,0	32,0	42,0	3	20,0	15	35 (30)		3/8
20,5	23,6	21,0	24,5	32,0	42,0	3	20,0	15	35 (30)		3/8
21,0	24,0	21,5	25,0	32,0	42,0	3	20,0	15	35 (30)		3/8
22,0	25,0	22,5	25,0	32,0	42,0	3	20,0	15	35 (30)		3/8
23,0	26,0	23,5	27,0	32,0	47,0	3	20,0	15	32 (26)		1/2
24,0	27,0	24,5	28,0	32,0	47,0	3	20,0	15	32 (26)		1/2
25,0	28,0	25,5	29,0	36,0	47,0	3	20,0	15	32 (26)		1/2
26,0	29,0	26,5	30,0	36,0	47,0	3	20,0	15	32 (26)		1/2
27,0	30,0	27,5	31,0	36,0	52,0	3	20,0	15	32 (26)		1/2
28,0	31,2	28,5	31,7	36,0	52,0	3	20,0	15	32 (26)		1/2
29,0	32,2	29,5	33,0	36,0	52,0	3	20,0	15	32 (26)		1/2
30,0	33,2	30,5	34,0	45,0	52,0	0	26,0	15	32 (26)		1/2
31,0	34,2	31,5	35,0	45,0	52,0	0	26,0	15	32 (26)		1/2
32,0	35,2	32,5	36,0	45,0	52,0	0	26,0	15	32 (26)		1/2
33,0	36,2	33,5	37,0	45,0	52,0	0	26,0	15	32 (26)		1/2
34,0	37,2	34,5	38,0	45,0	52,0	0	26,0	15	32 (26)		1/2
34,5	37,7	35,0	38,0	45,0	52,0	0	26,0	15	32 (26)		1/2
35,0	38,2	35,5	39,0	45,0	52,0	0	26,0	15	32 (26)		3/4
36,0	40,0	36,5	41,0	45,0	52,0	0	26,0	15	32 (26)		3/4
38,0	42,0	38,5	43,0	45,0	52,0	0	26,0	15	32 (26)		3/4
40,0	44,0	40,5	45,0	56,0	65,0	0	26,0	15	32 (26)		3/4
42,0	46,0	42,5	47,0	56,0	65,0	0	26,0	15	32 (26)		3/4
44,0	48,0	44,5	49,0	56,0	65,0	0	34,0	15	32 (26)		3/4
46,0	50,0	46,5	51,0	56,0	65,0	0	34,0	15	32 (26)		3/4
48,0	52,0	48,5	53,0	56,0	65,0	0	34,0	15	32 (26)		3/4
50,0	55,0	50,5	55,0	66,0	75,0	0	34,0	15	32 (26)		3/4
52,0	57,0	53,0	58,0	66,0	75,0	0	34,0	15	30 (24)		3/4
54,0	59,0	55,0	60,0	66,0	75,0	0	34,0	15	30 (24)		3/4
56,0	61,0	57,0	62,0	66,0	75,0	0	34,0	15	30 (24)		3/4
58,0	63,0	59,0	64,0	66,0	75,0	0	34,0	15	30 (24)		3/4
60,0	65,0	61,0	66,0	83,0	95,0	0	34,0	15	30 (24)		3/4
62,0	67,0	63,0	68,0	83,0	95,0	0	34,0	15	30 (24)		3/4
64,0	69,0	65,0	70,0	83,0	95,0	0	34,0	15	30 (24)		3/4
66,0	71,0	67,0	72,0	83,0	95,0	0	34,0	15	30 (24)		3/4
68,0	73,0	69,0	74,0	88,0	100,0	0	34,0	15	30 (24)		1
70,0	75,0	71,0	76,0	88,0	100,0	0	34,0	15	30 (24)		1

*) Klammerwerte = max. Walzbreite für Rollen mit beidseitiger Parabel

Selbsttätigen Rohrwalzen BV

NUTZTIEFE 50 / 70 / 100 / 150 mm · ROLLENLÄNGE 50 mm (GRÖSSEN 10,6 - 84,0)

Größe = Körper-Ø	Aus- dehnung bis	Rohr- innen-Ø min.	Rohr- außen-Ø min.	Rohr- außen-Ø max.	Außen- kappe-Ø	Rohrvorstand / Eindrehung Kappe 0437 Kappe 0438		Verst. WB*) von	Verst. WB*) bis	Nutz- tiefe	Dorn Vierkant
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	zoll
10,6	11,8	11,0	12,5	16,0	28,0	2	20,0	25	45 (40)	70	3/8
11,4	12,7	11,8	13,5	16,0	28,0	2	20,0	25	45 (40)	oder	3/8
12,0	13,8	12,3	14,5	19,0	30,0	2	20,0	25	45 (40)		3/8
12,6	14,6	13,0	15,5	19,0	30,0	2	20,0	25	45 (40)	100	3/8
13,0	15,0	13,3	15,7	19,0	30,0	2	20,0	25	45 (40)	oder	3/8
13,8	15,9	14,0	16,5	20,0	32,0	2	20,0	25	45 (40)	150	3/8
14,5	16,6	14,8	17,5	20,0	32,0	2	20,0	25	45 (40)		3/8
15,0	17,3	15,3	18,0	20,0	32,0	2	20,0	25	45 (40)		3/8
15,5	17,7	15,8	18,5	20,0	32,0	2	20,0	25	45 (40)		3/8
16,0	18,4	16,3	19,0	23,0	35,0	3	20,0	25	45 (40)		3/8
16,5	18,6	16,8	19,5	23,0	35,0	3	20,0	25	45 (40)		3/8
17,0	19,0	17,3	20,0	23,0	35,0	3	20,0	25	45 (40)		3/8
17,5	19,7	18,0	20,5	25,4	35,0	3	20,0	25	45 (40)		3/8
18,4	21,2	19,0	22,0	25,4	40,0	3	20,0	25	45 (40)		3/8
19,0	21,5	19,5	22,5	25,4	40,0	3	20,0	25	45 (40)		3/8
19,5	21,8	20,0	23,0	25,4	40,0	3	20,0	25	45 (40)		3/8
20,0	23,0	20,5	24,0	32,0	42,0	3	20,0	25	45 (40)		3/8
20,5	23,6	21,0	24,5	32,0	42,0	3	20,0	25	45 (40)		3/8
21,0	24,0	21,5	25,0	32,0	42,0	3	20,0	25	45 (40)		3/8
22,0	25,0	22,5	25,0	32,0	42,0	3	20,0	25	45 (40)		3/8
23,0	26,0	23,5	27,0	32,0	47,0	3	20,0	25	42 (36)		1/2
24,0	27,0	24,5	28,0	32,0	47,0	3	20,0	25	42 (36)		1/2
25,0	28,0	25,5	29,0	36,0	47,0	3	20,0	25	42 (36)		1/2
26,0	29,0	26,5	30,0	36,0	47,0	3	20,0	25	42 (36)		1/2
27,0	30,0	27,5	31,0	36,0	52,0	3	20,0	25	42 (36)		1/2
28,0	31,2	28,5	31,7	36,0	52,0	3	20,0	25	42 (36)		1/2
29,0	32,2	29,5	33,0	36,0	52,0	3	20,0	25	42 (36)		1/2
30,0	33,2	30,5	34,0	45,0	52,0	0	26,0	25	42 (36)		1/2
31,0	34,2	31,5	35,0	45,0	52,0	0	26,0	25	42 (36)		1/2
32,0	35,2	32,5	36,0	45,0	52,0	0	26,0	25	42 (36)		1/2
33,0	36,2	33,5	37,0	45,0	52,0	0	26,0	25	42 (36)		1/2
34,0	37,2	34,5	38,0	45,0	52,0	0	26,0	25	42 (36)		1/2
34,5	37,7	35,0	38,0	45,0	52,0	0	26,0	25	42 (36)		1/2
35,0	38,2	35,5	39,0	45,0	52,0	0	26,0	25	42 (36)		3/4
36,0	40,0	36,5	41,0	45,0	52,0	0	26,0	25	42 (36)		3/4
38,0	42,0	38,5	43,0	45,0	52,0	0	26,0	25	42 (36)		3/4
40,0	44,0	40,5	45,0	56,0	65,0	0	26,0	25	42 (36)		3/4
42,0	46,0	42,5	47,0	56,0	65,0	0	26,0	25	42 (36)		3/4
44,0	48,0	44,5	49,0	56,0	65,0	0	34,0	25	42 (36)		3/4
46,0	50,0	46,5	51,0	56,0	65,0	0	34,0	25	42 (36)		3/4
48,0	52,0	48,5	53,0	56,0	65,0	0	34,0	25	42 (36)		3/4
50,0	55,0	50,5	55,0	66,0	75,0	0	34,0	25			3/4
52,0	57,0	53,0	58,0	66,0	75,0	0	34,0	25	40 (34)		3/4
54,0	59,0	55,0	60,0	66,0	75,0	0	34,0	25	40 (34)		3/4
56,0	61,0	57,0	62,0	66,0	75,0	0	34,0	25	40 (34)		3/4
58,0	63,0	59,0	64,0	66,0	75,0	0	34,0	25	40 (34)		3/4
60,0	65,0	61,0	66,0	83,0	95,0	0	34,0	25	40 (34)		3/4
62,0	67,0	63,0	68,0	83,0	95,0	0	34,0	25	40 (34)		3/4
64,0	69,0	65,0	70,0	83,0	95,0	0	34,0	25	40 (34)		3/4
66,0	71,0	67,0	72,0	83,0	95,0	0	34,0	25	40 (34)		3/4
68,0	73,0	69,0	74,0	88,0	100,0	0	34,0	25	40 (34)		1
70,0	75,0	71,0	76,0	88,0	100,0	0	34,0	25	40 (34)		1
72,0	77,0	73,0	78,0	90,0	105,0	0	34,0	25	40 (34)		1
74,0	79,0	75,0	80,0	92,0	105,0	0	34,0	25	40 (34)		1
76,0	81,0	77,0	82,0	94,0	110,0	0	34,0	25	38 (32)		1
78,0	83,0	79,0	84,0	96,0	110,0	0	34,0	25	38 (32)		1
80,0	85,0	81,0	86,0	98,0	115,0	0	34,0	25	38 (32)		1
82,0	87,0	83,0	88,0	100,0	120,0	0	34,0	25	38 (32)		1
84,0	89,0	85,0	90,0	102,0	120,0	0	34,0	25	38 (32)		1

*) Klammerwerte = max. Walzbreite für Rollen mit beidseitiger Parabel

Selbsttätigen Rohrwalzen BV

NUTZTIEFE 50 / 70 / 100 / 150 mm · ROLLENLÄNGE 60 mm (GRÖSSEN 8,8 - 70,0)

Größe = Körper-Ø	Aus- dehnung bis	Rohr- innen-Ø min.	Rohr- außen-Ø min.	Rohr- außen-Ø max.	Außen- kappe-Ø	Rohrvorstand / Eindrehung Kappe 0437 Kappe 0438		Verst. WB*) von	Verst. WB*) bis	Nutz- tiefe	Dorn Vierkant
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	zoll
10,6	11,8	11,0	12,5	16,0	28,0	2	20,0	35	55 (50)	70	3/8
11,4	12,7	11,8	13,5	16,0	28,0	2	20,0	35	55 (50)	oder	3/8
12,0	13,8	12,3	14,5	19,0	30,0	2	20,0	35	55 (50)		3/8
12,6	14,6	13,0	15,5	19,0	30,0	2	20,0	35	55 (50)	100	3/8
13,0	15,0	13,3	15,7	19,0	30,0	2	20,0	35	55 (50)	oder	3/8
13,8	15,9	14,0	16,5	20,0	32,0	2	20,0	35	55 (50)	150	3/8
14,5	16,6	14,8	17,5	20,0	32,0	2	20,0	35	55 (50)		3/8
15,0	17,3	15,3	18,0	20,0	32,0	2	20,0	35	55 (50)		3/8
15,5	17,7	15,8	18,5	20,0	32,0	2	20,0	35	55 (50)		3/8
16,0	18,4	16,3	19,0	23,0	35,0	3	20,0	35	55 (50)		3/8
16,5	18,6	16,8	19,5	23,0	35,0	3	20,0	35	55 (50)		3/8
17,0	19,0	17,3	20,0	23,0	35,0	3	20,0	35	55 (50)		3/8
17,5	19,7	18,0	20,5	25,4	35,0	3	20,0	35	55 (50)		3/8
18,4	21,2	19,0	22,0	25,4	40,0	3	20,0	35	55 (50)		3/8
19,0	21,5	19,5	22,5	25,4	40,0	3	20,0	35	55 (50)		3/8
19,5	21,8	20,0	23,0	25,4	40,0	3	20,0	35	55 (50)		3/8
20,0	23,0	20,5	24,0	32,0	42,0	3	20,0	35	55 (50)		3/8
20,5	23,6	21,0	24,5	32,0	42,0	3	20,0	35	55 (50)		3/8
21,0	24,0	21,5	25,0	32,0	42,0	3	20,0	35	55 (50)		3/8
22,0	25,0	22,5	25,0	32,0	42,0	3	20,0	35	55 (50)		3/8
23,0	26,0	23,5	27,0	32,0	47,0	3	20,0	35	52 (46)		1/2
24,0	27,0	24,5	28,0	32,0	47,0	3	20,0	35	52 (46)		1/2
25,0	28,0	25,5	29,0	36,0	47,0	3	20,0	35	52 (46)		1/2
26,0	29,0	26,5	30,0	36,0	47,0	3	20,0	35	52 (46)		1/2
27,0	30,0	27,5	31,0	36,0	52,0	3	20,0	35	52 (46)		1/2
28,0	31,2	28,5	31,7	36,0	52,0	3	20,0	35	52 (46)		1/2
29,0	32,2	29,5	33,0	36,0	52,0	3	20,0	35	52 (46)		1/2
30,0	33,2	30,5	34,0	45,0	52,0	0	26,0	35	52 (46)		1/2
31,0	34,2	31,5	35,0	45,0	52,0	0	26,0	35	52 (46)		1/2
32,0	35,2	32,5	36,0	45,0	52,0	0	26,0	35	52 (46)		1/2
33,0	36,2	33,5	37,0	45,0	52,0	0	26,0	35	52 (46)		1/2
34,0	37,2	34,5	38,0	45,0	52,0	0	26,0	35	52 (46)		1/2
34,5	37,7	35,0	38,0	45,0	52,0	0	26,0	35	52 (46)		1/2
35,0	38,2	35,5	39,0	45,0	52,0	0	26,0	35	52 (46)		3/4
36,0	40,0	36,5	41,0	45,0	52,0	0	26,0	35	52 (46)		3/4
38,0	42,0	38,5	43,0	45,0	52,0	0	26,0	35	52 (46)		3/4
40,0	44,0	40,5	45,0	56,0	65,0	0	26,0	35	52 (46)		3/4
42,0	46,0	42,5	47,0	56,0	65,0	0	26,0	35	52 (46)		3/4
44,0	48,0	44,5	49,0	56,0	65,0	0	34,0	35	52 (46)		3/4
46,0	50,0	46,5	51,0	56,0	65,0	0	34,0	35	52 (46)		3/4
48,0	52,0	48,5	53,0	56,0	65,0	0	34,0	35	52 (46)		3/4
50,0	55,0	50,5	55,0	66,0	75,0	0	34,0	35	52 (46)		3/4
52,0	57,0	53,0	58,0	66,0	75,0	0	34,0	35	50 (44)		3/4
54,0	59,0	55,0	60,0	66,0	75,0	0	34,0	35	50 (44)		3/4
56,0	61,0	57,0	62,0	66,0	75,0	0	34,0	35	50 (44)		3/4
58,0	63,0	59,0	64,0	66,0	75,0	0	34,0	35	50 (44)		3/4
60,0	65,0	61,0	66,0	83,0	95,0	0	34,0	35	50 (44)		3/4
62,0	67,0	63,0	68,0	83,0	95,0	0	34,0	35	50 (44)		3/4
64,0	69,0	65,0	70,0	83,0	95,0	0	34,0	35	50 (44)		3/4
66,0	71,0	67,0	72,0	83,0	95,0	0	34,0	35	50 (44)		3/4
68,0	73,0	69,0	74,0	88,0	100,0	0	34,0	35	50 (44)		1
70,0	75,0	71,0	76,0	88,0	100,0	0	34,0	35	50 (44)		1
72,0	77,0	73,0	78,0	90,0	105,0	0	34,0	35	50 (44)		1
74,0	79,0	75,0	80,0	92,0	105,0	0	34,0	35	50 (44)		1
76,0	81,0	77,0	82,0	94,0	110,0	0	34,0	35	48 (42)		1
78,0	83,0	79,0	84,0	96,0	110,0	0	34,0	35	48 (42)		1
80,0	85,0	81,0	86,0	98,0	115,0	0	34,0	35	48 (42)		1
82,0	87,0	83,0	88,0	100,0	120,0	0	34,0	35	48 (42)		1
84,0	89,0	85,0	90,0	102,0	120,0	0	34,0	35	48 (42)		1

*) Klammerwerte = max. Walzbreite für Rollen mit beidseitiger Parabel