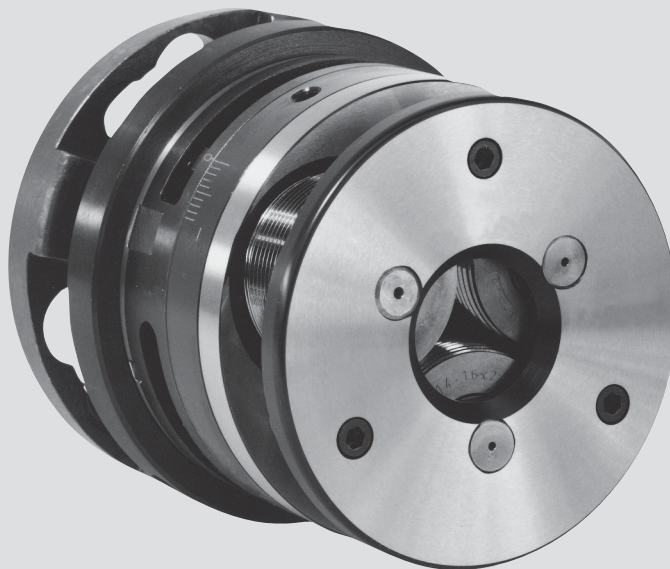


Betriebsanleitung
Gewinde-Rollköpfe FU 32, FU 3-1, FU 34-1
Operating Instruction
Thread Rolling Heads FU 32, FU 3-1, FU 34-1



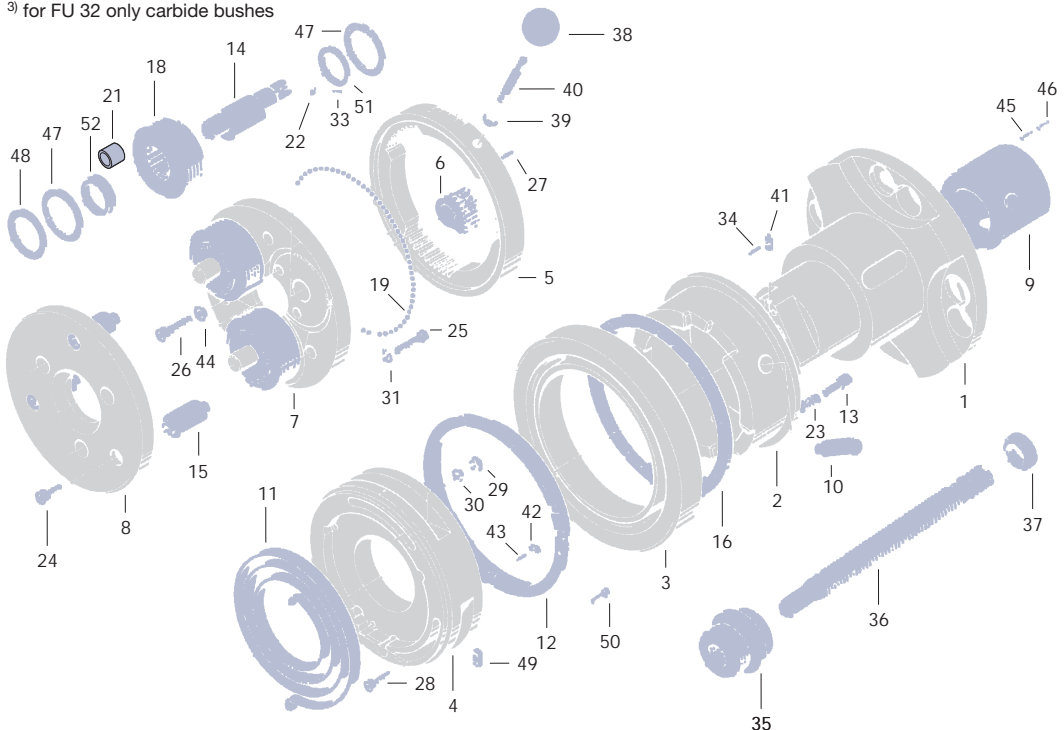
Spare Parts

| No. | Pieces | Description | No. | Pieces | Description |
|------------------|---------------------|----------------------------------------------|------------------|--------|-----------------|
| 1 | 1 | Flange | 27 | 6 | Studs |
| 2 | 1 | Dog coupling | 28 | 3 | Allen screws |
| 3 | 1 | Operating ring | 29 | 6 | Hexagon nuts |
| 4 | 1 | Spring housing | 30 | 6 | Washer |
| 5 | 1 | Gear ring | 31 | 3 | Spring washer |
| 6 | 3 | Gear sectors | 33 | 3 | Pins |
| 7 | 1 | Centre plate | 34 | 3 | Locking pins |
| 8 | 1 | Front plate | 35 | 1 | Stop screw body |
| 9 | 1 | Sleeve | 36 | 1 | Stop screw |
| 10 | 3 | Pin | 37 | 1 | Hexagon nut |
| 11 | 1 | Coil spring | 38 ²⁾ | 1 | Ball for handle |
| 12 | 1 | Brake ring | 39 ²⁾ | 1 | Hexagon nut |
| 13 | 4 | Spring pads | 40 ²⁾ | 1 | Handle |
| 14 | 3 | Eccentric spindles | 41 | 3 | Fitting keys |
| 15 | 3 | Spacing studs | 42 | 2 | Fitting keys |
| 16 | 1 | Ball bearing cage | 43 | 2 | Locking pin |
| 18 | 3 | Thread rolls | 44 | 6 | Schnorr-circlip |
| 19 | 87 | Ball bearings | 45 | 3 | Grub screw |
| 21 | 1 set ³⁾ | Needle roller bearings or carbide bushing | 46 | 3 | Grub screw |
| | | | 47 ¹⁾ | 6 | Thrust bearings |
| 22 | 3 | Keys | 48 ¹⁾ | 3 | Axial washer |
| 23 | 4 | Coil spring | 49 | 3 | Coupling wedge |
| 24 | 3 | Allen screws | 50 | 8 | Allen screws |
| 25 | 3 | Allen screws | 51 ¹⁾ | 3 | Centering plate |
| 25 ¹⁾ | 2 | Allen screws | 52 ¹⁾ | 3 | Centering plate |
| 26 | 6 | Handle | | | |

¹⁾ only for Typ FU 34-1

²⁾ only for fixed application

³⁾ for FU 32 only carbide bushes



Example of Assembly for Rolling Heads in “FU”-design

- Separate Parts to be assembled into groups (fig. 1). Apply ample grease to Ball Bearings to avoid drop out when putting into the Gear Ring (fig. 2). The gears on the Gear Sector then point to the centre.
- The gears are to be brought into engagement (fig. 3), attention is to be paid to uniformness and perhaps marking “0” is to be noted. Gearings to be brought into approx. centre position.
- Assembly group (fig. 3) to be put on Lower Assembly Group (fig. 4). The “0” marking has to be in the area of the Guide Scale. Care should be taken to ensure that there is no gap within the ball track, because otherwise the Ball Bearings could drop out.

Fig. 1



Fig. 2

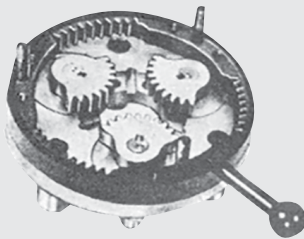


Fig. 3

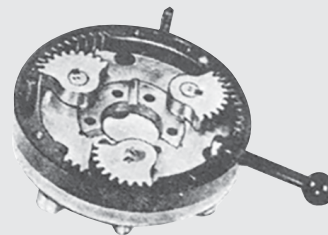
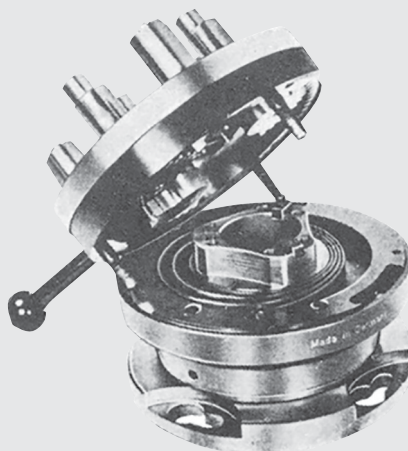


Fig. 4





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