

SELBSTTÄTIGE ROHRWALZEN BV



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

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 Kappe 0437	Rohrvorstand / Eindrehung Kappe 0438	Verst. WB*) von	Verst. WB*) bis	Nutz- tiefe	Dorn vierkant
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

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		Verst. WB*) von	Verst. WB*) bis	Nutz- tiefe	Dorn vierkant
						Kappe 0437	Kappe 0438				
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

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	Rohrvorstand / Eindrehung 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