

CERGIL INDUSTRY S.r.l.

Sede legale: Via Fieno 3 – 20123 Milano

Sede operativa e stabilimento: Via degli Artigiani 2/4 27010 Localita' Prado Cura Carpignano (PV) -IT-

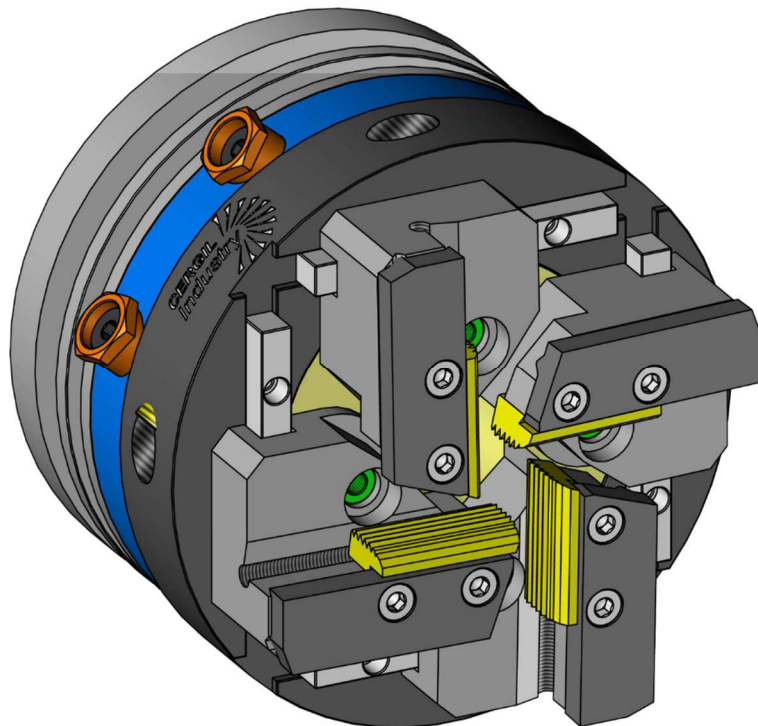
www.cergil.it phone number 0039 0382 465089 fax number 0039 0382 461468

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Codice fiscale e partita IVA 08295050960

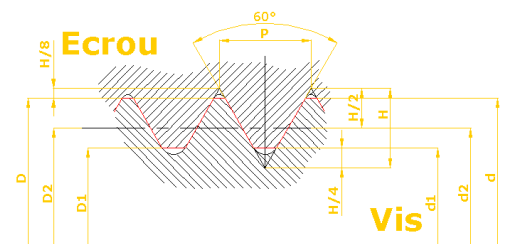


## Threading and turning heads with automatic opening. Heads for axial machining. Tools: chasers - regrindable blades - carbide tools



### Fields of application:

- ✓ Large threads
- ✓ Fine threads
- ✓ Cylindrical threads
- ✓ Tapered threads
- ✓ Pipe Threads
- ✓ Trapezoidal threads
- ✓ Round threads
- ✓ Other special forms
- ✓ Very fast diameter turning



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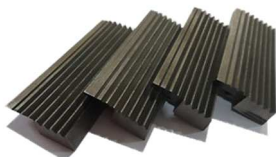
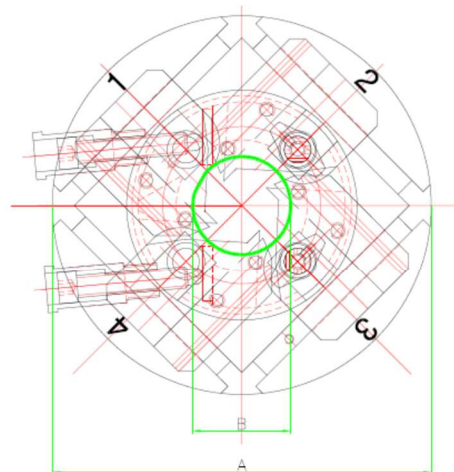
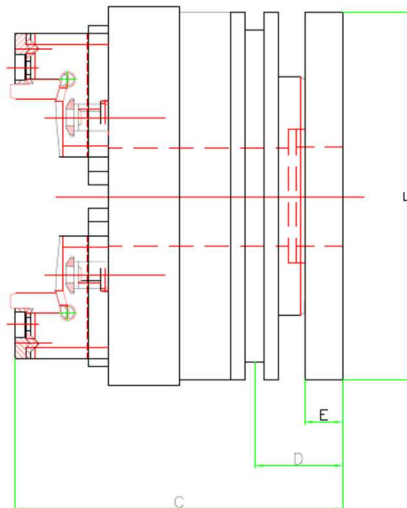
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**DIMENSIONS AND WEIGHT:**



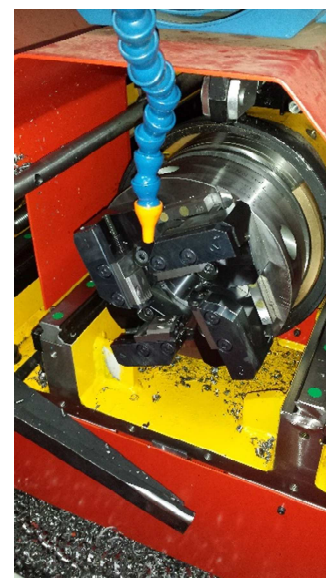
TYPE	Threading capacity			Weight Kg	A mm	B mm	C mm	D mm	E mm	F mm
	Metric	Withworth	Gas							
R 33	8-33	3/8"-1 1/4"	1/8"- 1"	21	185	34	170	40	18	153
R 60	10-60	7/16"-2 1/4"	1/4"- 2"	54	260	62	208	57	25	233
R114	33-114	1 1/4"- 4 1/2"	1"- 4"	92	330	116	216	59	25	324



**Installation: fixed or rotating. Opening with manoeuvring-collar operated mechanically or with cylinder.**

**Installation example 1:  
on the Cergil F60 Threading Machine**

**Installation example 2:  
on the CNC turning spindle**



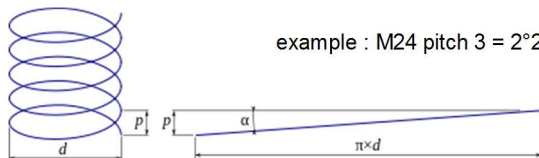
### Chasers holders and helix angle:



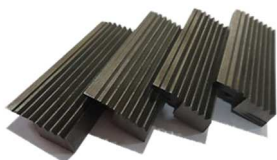
- A single series of chaser-holders can perform all diameters in the capacity of the head. Only the helix angle (inclination of the chasers) is adapted according to the quality and the request.
- Our chase holders have an installation extremely hard on the head, that avoids the introduction of the chasers in threaded piece and greatly decrease the risk of tool breakage.

d2 = diameter on the side (average)  
p – thread pitch

$$\alpha = \arctan \left( \frac{p}{\pi d_2} \right)$$

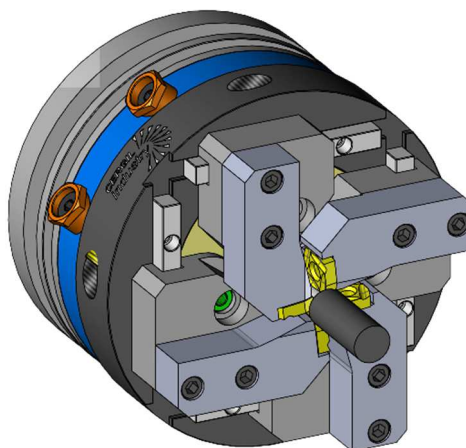


- Right or left threading with chaser-holders replacement.
- Quick and easy installation of the chasers on the chaser-holders.



### Version for operating the lathe:

- With standard chasers holders and special tools HSS or from high-speed steels, strongly allied, developed by metal industry of powders for the manufacturing's submitted to the shock such as structural steels for the reinforced concrete.
- With tools carbides adapted to the high-speed reduction of the diameters of steel circles smooth.



### Our tools:

- All our chasers are made of high quality speed steel manufactured in Europe.
- Threads profiles are entirely made for rectification after heat treatment. This allows us to get a consistent quality of the hardness of threading teeth.
- We can offer coatings such as TIN TICN CRN.... The coating of the high speed steel is frequently used to improve their sealing and machining quality.
- All our chasers and tools can be adapted to your needs and working conditions. All thread profiles are achievable on all metals and plastics.



**Contact us with your projects we will meet your expectations.**