

ROLL FORMING IN **HIGH-TENSILE STEELS**

DURAMAX HZP KA BX for highest tool life in demanding materials.

Roll forming is the ideal machining process in materials up to 1.400 N/mm² and a elongation at rupture of at least 8 %.

High-strength steels in the range of 1,000 to 1,400 N/mm² place significantly higher demands on the tools used – this is where our new HZP geometry steps in.

The new polygon shape was specifically developed for machining high-tensile steels and has proven successful in many series production projects, demonstrating itself to be the most economical solution on the market. Now comes the next step: its introduction as a new standard geometry.

Another advantage of the HZP family is the increased number of polygons. This ensures a more even distribution of forces during the forming process and thus contributes significantly to a longer tool life.

The DURAMAX HZP is manufactured from a material developed specifically for roll taps, which guarantees maximum stability and durability.

The tool is completed by the new high-performance BX coating, which was also developed for high-tensile steels. It impresses with its excellent heat resistance and exceptionally smooth surface. This significantly reduces

adhesion and abrasion wear – for maximum machine uptime and process reliability.

The DURAMAX HZP. Our flagship product for chipless thread machining in high-strength steels.

OUR GEOMETRIES

DURAMAX N

for all formable materials,
good cutting speed and tool life

DURAMAX H

for all formable materials,
high cutting speed and tool life

DURAMAX GAL

for aluminum alloys

DURAMAX HZP

for high-tensile steels



CATALOG PROGRAM

DURAMAX HZP KA BX

- » coating: BX
- » coolant: axial
- » chamfer form: C / 2-3
- » thread tolerances: 6HX, 6GX
- » shank tolerance: h6
- » material: HSSE-PM

** M3 without internal coolant

Ød ₁	P	ID 6HX	ID 6GX
M 3	0,5	098006**	097898**
M 4	0,7	098009	097899
M 5	0,8	098010	097901
M 6	1	097892	097903
M 8	1,25	098011	097904
M 10	1,5	098013	098020
M 12	1,75	098014	098022
M 14	2	097893	098108
M 16	2	076820	098109
M 18	2,5	097895	098107
M 20	2,5	097897	098015

Ød ₁	P	ID 6HX	ID 6GX
MF 8	1	098103	098118
MF 10	1	098106	098120
MF 12	1	098110	098121
MF 12	1,5	098111	098122
MF 14	1,5	098113	098123
MF 16	1,5	098114	098124
MF 18	1,5	098115	098125
MF 20	1,5	098117	098126

