

NAREX ROLL s.r.o.

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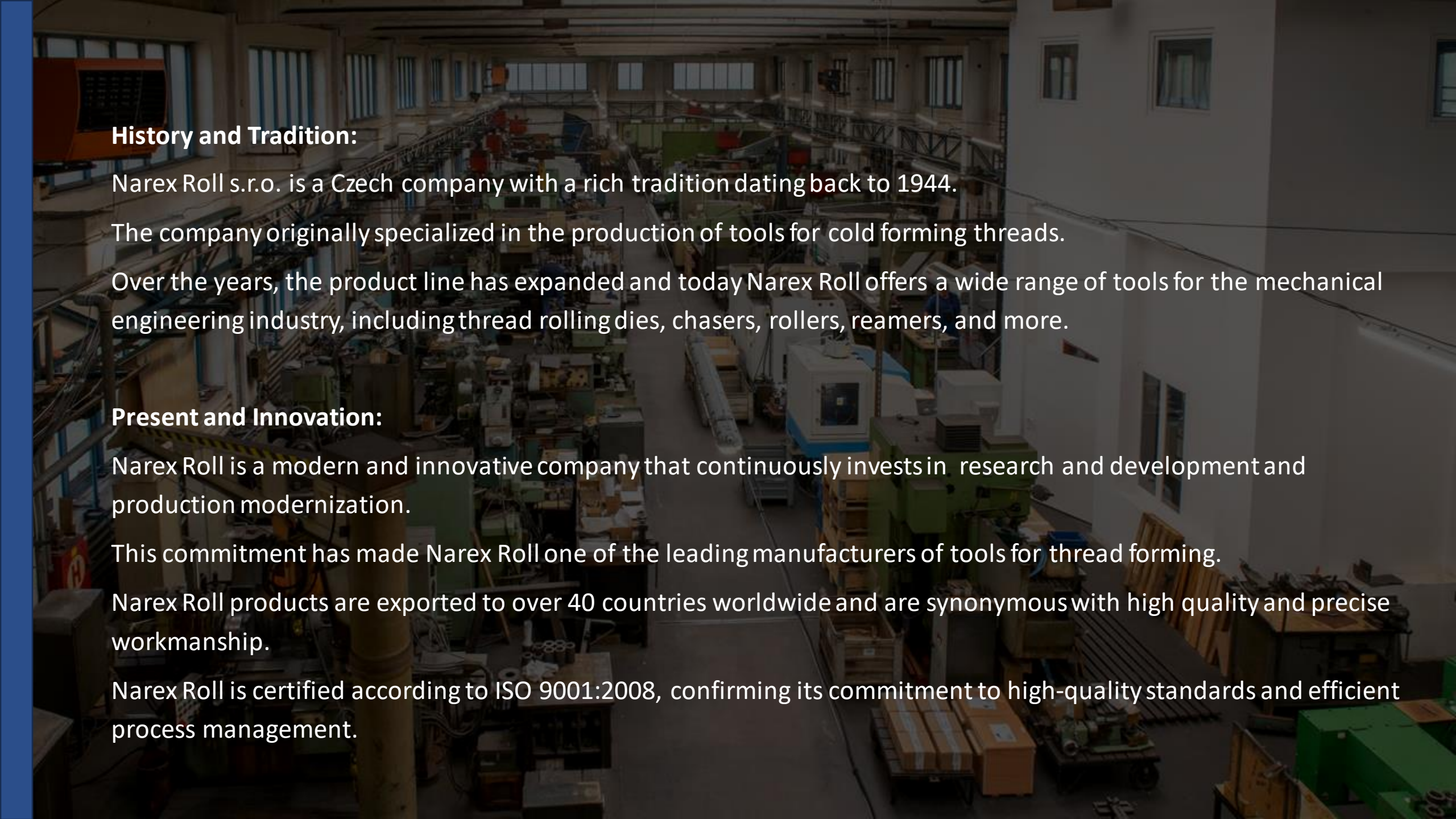
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narex
ROLL

The background image shows a vast industrial factory floor. In the foreground, there are several large pieces of machinery, including what appears to be a lathe or similar metalworking equipment. The floor is filled with various tools, parts, and equipment. In the middle ground, there are more machines and workstations. The background shows a long, well-lit aisle with windows on the upper level, suggesting a multi-story industrial building. The overall scene is one of a busy, modern manufacturing environment.

History and Tradition:

Narex Roll s.r.o. is a Czech company with a rich tradition dating back to 1944.

The company originally specialized in the production of tools for cold forming threads.

Over the years, the product line has expanded and today Narex Roll offers a wide range of tools for the mechanical engineering industry, including thread rolling dies, chasers, rollers, reamers, and more.

Present and Innovation:

Narex Roll is a modern and innovative company that continuously invests in research and development and production modernization.

This commitment has made Narex Roll one of the leading manufacturers of tools for thread forming.

Narex Roll products are exported to over 40 countries worldwide and are synonymous with high quality and precise workmanship.

Narex Roll is certified according to ISO 9001:2008, confirming its commitment to high-quality standards and efficient process management.



Narex Roll Products:

- rolling dies
- knurling rollers
- rollers
- flat dies
- radial and tangential chasers
- hand reamers
- axial and tangential rolling heads

Advantages of Narex products:

- high quality and precise workmanship
- long service life
- wide selection of products for various applications
- competitive prices
- reliable customer service

Narex Roll is a reliable partner for all those seeking high-quality and innovative tools for the mechanical engineering industry. With their wide range of products and reliable customer service, Narex Roll is the perfect choice for companies and individuals.

ROLLING DIES

Rolling dies are the basic product of our production.

Rolling dies for thread rolling in radial and axial rolling for all types of rolling machines (2-roller, 3-roller). We also offer renovation of used cylinders.

min. thread pitch = 0.3

thread types - M, G, R, W, UNC, Tr, special threads upon customer request

max. diameter of the die = 350

max. width of the die = 210

bore according to the type of machine

material 1.2379 (D2), 1.3343 (M2) with the possibility of plasma nitriding, on customer's request also of other materials.

Rolling dies for knurling according to DIN 82 (RAA, RGE, RKE)

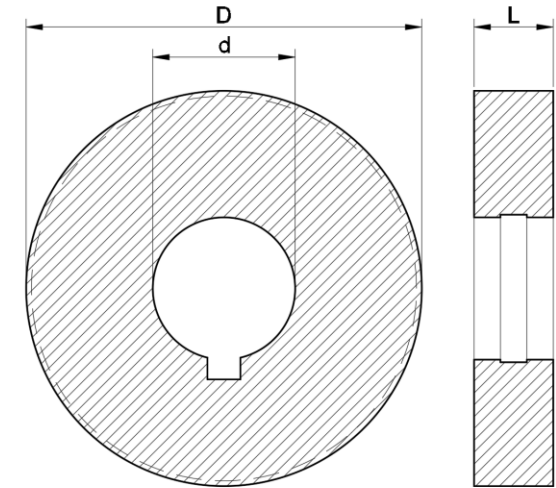
min. pitch = 0.4 max

diameter of the die = 190

max width of the die = 140

bore according to the type of machine

material 1.2379 (D2), 1.3343 (M2) with the possibility of plasma nitriding, on customer's request also of other materials.



ROLLERS FOR THREAD ROLLING

Rollers for thread rolling heads are used for the production of threads or modules by cold forming.

The design of thread rollers corresponds to the rolling process.

The rollers enable the manufacture of all types of profiles – M, G, BSW, Tr, Rd, Pz, ACME, API .

We produce rollers for all types of thread rolling heads and tangential heads: NAREX, RK, FETTE, Gradex, etc.

Rollers are supplied in sets of 3 for axial heads and in sets of 2 for tangential heads.

For longer service life, they are usually made of material 1.3343 and are nitrided, on customer's request also of other materials.



AXIAL ROLLING SYSTEMS

All components are made of quick-cutting material, nitrided. As a result, the rolling head has a very long service life compared to the competitive systems.

Our axial rolling systems are usable on all common machine tools such as CNC centers, manual machine tools and, if required, on jig boring machines.

Setup on the machine tool is quick, easy and flexible for all tasks. The quality of the threads you produce as well as the durability of our rolling systems and their rollers are the best reasons to choose thread and profile rolling systems over cutting tools.

Machine tool setup and downtime are kept to a minimum. The production process goes through short cycles.

Gradex axial rolling heads - 11 shank type sizes with a working range of 2.6 - 30 mm and 4 flange type sizes with a working range of 1.4 - 45 mm.



1. Shank type

Rolling system - size	Working range		OD - Shank Diameter - Standard		OD - Housing Diameter - Standard	
	from mm	up mm	mm	inch	mm	inch
A 0	2,6	5,5	20	3/4"	50	1,9680
A 001	2,6	4,0	20, 16	3/4"	40	1,5748
A 01	3,5	6,0	20, 16	3/4"	40	1,5748
A 1	6,0	11,0	20, 16	3/4"	64	2,5196
A 12	6,0	12,0	20, 16	3/4"	64	2,5196
A 1223	5,0	8,0	20, 16	3/4"	56	2,2047
A 2	8,0	16,0	25	1"	88	3,4645
A 23	8,0	22,0	25	1"	88	3,4645
A 233400	16,0	36,0	30, 25	1", 1.1/4"	96	3,7795
A 3	12,0	22,0	30	1.1/2", 1.1/4"	117	4,6063
A 34	12,0	30,0	30	1.1/2", 1.1/4"	117	4,6063

2. Flange type

Rolling system - size	Working range		OD - Flange Diameter - Standard		OD - Housing Diameter - Standard	
	from mm	up mm	mm	inch	mm	inch
A 4-1	14	30	140	5,5118	165	6,4960
A 5-1	18	39	200	7,8740	200	7,8740
A 56-1	22	52	200	7,8740	200	7,8740
A 6b-1	30	45	200	7,8740	255	10,0393

TANGENTIAL ROLLING SYSTEMS

All components are made of quick-cutting material, nitrided. As a result, the rolling head has a very long service life compared to the competitive systems.

Our tangential rolling systems increase the efficiency of thread and blank production in machining centers, on CNC milling and turning machines as well as on manual cross feed machines.

The main advantage of our tangential thread rolling systems is the ability to roll threads and runners in the workpiece between arms and different diameters, while rolling the shortest threads and runners.

For each of our tangential rolling systems we supply an individually adapted tangential rolling head holder. With this holder, the Gradex tangential rolling head is attached to your machine tool.

Gradex tangential rolling heads – 3 sizes with a working range 2 – 42 mm.



Tangential Rolling Systems – Types and Sizes

Rolling system - size	Working range		Rolls width, max.		Rolling heads length, min.	
	from mm	up mm	mm	Inch	mm	Inch
T10	2	14	15,5	0,6102	104	4,0944
T20	2	30	21,5	0,8464	131	5,1574
T30	2	42	31,0	1,2204	168	6,614

RADIAL AND TANGENTIAL THREAD CHASERS

• **Radial thread chasers** for cutting heads according to ČSN 231540 (41) - quantity = 4 pieces.

Threads: M, G, W, UNC

Type III - range M8 - M26

Type IV - range M10 - M27

Type V - range M12 - M33

• **Tangential thread chasers** for cutting heads LANDIS, WAGNER, and others, - quantity = 4 pieces.

• **Thread rolling chasers** for M, G, W, UNC threads

min. pitch = 0.4

max. width = 100

height according to customer request

max. length = 300

Most often from material 1.3343, on customer's request from other materials.

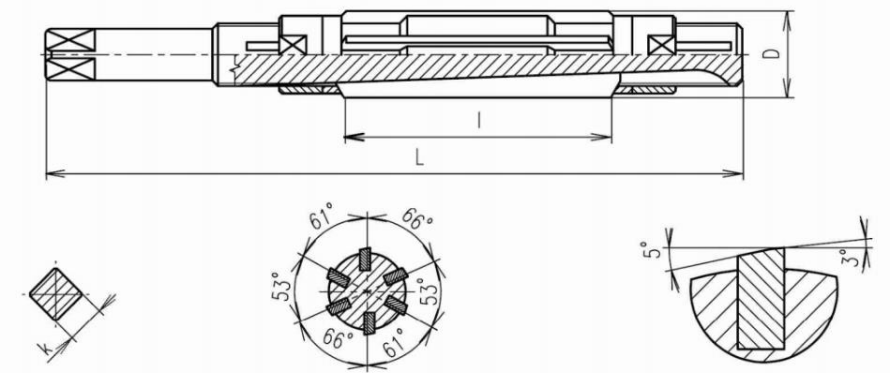


ADJUSTABLE HAND REAMERS

We supply adjustable hand reamers in 21 sizes ranging from 7.60mm to 60mm.

They are characterised by the irregular geometry of blade placement to ensure that an exactly circular hole is reamed. Adjustable reamers are used for finishing machining of cylindrical holes. Bored holes have exact size, geometric shape and smooth surface. The dimension of the reamer is continuously adjustable. Dimension is measured from a pair of opposing knives. The blade geometry is suitable for machining gray cast iron and bronze.

They are available individually or in two types of sets in the following ranges: small set 13.75 - 24mm, large set 10.25 - 33mm. Thanks to many years of experience and quality production, our reamers are extremely resistant.



Thread grinding and other services on our machines

For grinding threads, we use REISHAUER NRK CNC, REISHAUER BS CNC, MIKRONEX BZA, BNU.

On the **grinding machine BNU 26** we offer:

- tool grinding
- thread grinding
- grinding of shaped parts
- manufacturing of fluting wheels
- other special grinding

On the **thread grinding machine BZA 200 CNC** we offer:

- grinding of thread rolling tools (thread rollers, rollers for rolling heads)
- grinding of threads on screws (max. thread length = 300)
- NEW - grinding of various shapes on rotating parts of thread rolling tools (thread rollers, rollers for rolling heads)

We offer part manufacturing on the **Fanuc Alpha 400iA wire EDM machine**.

The machine is capable of performing various machining operations with a high degree of accuracy and repeatability. It can have up to 5 or 6 axes, which allows it to machine complex shapes from multiple sides simultaneously.

Its capabilities include: turning, milling, drilling, grinding, wire cutting.



Control Services

For thread dimension control, we have two universal microscopes ZEISS and a profile projector MITUTOYO

CV-310054.

We offer comprehensive external technical services in the field of parts inspection and measurement.

Our highly trained personnel have extensive knowledge and experience in the field, ensuring precise and reliable results. Thanks to our modern technical background, we can perform a wide range of measurements and inspections with maximum accuracy and efficiency.

