

Thread Profiles



# 3 DIE THREAD ROLLING MACHINES

# 3R



3R-120



3R-3



3R-9



3R-12



3R-21



3R-45



3R-60

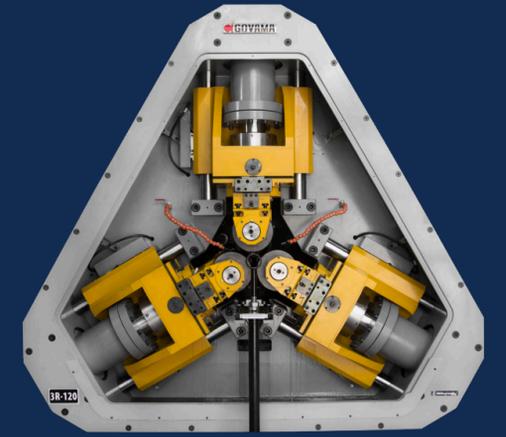
3R Series thread rolling machines have 3 rolling die, which work synchronized.

3R thread rolling machines can create force by hydraulically and electromechanical. Control units are Universal, PLC controls and MC controls.

3R Series thread rolling machine's rotation speed can be set as indefinitely, by Variable speed drive.

3R Series thread rolling machine's rolling force is between 3 tons to 120 tons. Our company is capable to produce 3 die machines, which have more than 120 tons rolling force, upon request.

3R Series thread rolling machines are capable to form different type of profiles on bars and hollow shaped parts between diameters 8mm to 400 mm.



3R Series Thread Rolling machines with three moveable bodies, which are positioned to each other 120 degrees, are used for forming circular cross section pipe materials by using 3 tons to 120 tons of rolling force. These machines which are called 3R series can obtain materials in any length by using annular type of dies as standard.

3 die cylindrical thread rolling machines mainly threads cold forming pipe material which has suitable thickness. In addition, 3R Series are preferred for solid bar materials, longer than 1 m.

### Advantages of Thread Rolling Process

- ▲ Durable Product
- ▲ High Quality Product
- ▲ High Speed Forming
- ▲ Material Saving
- ▲ Energy Saving

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# 3R

SERIES MACHINES



# TECHNICAL FEATURES

**3R-3**

**3R-9**

**3R-12**

**3R-15**

**3R-21**

**3R-45**

**3R-45IB**

**3R-60**

**3R-120**

<b>Rolling Force</b>	<b>(Kn)</b>	10 - 30	10 - 90	10 - 120	10 - 150	10 - 210	10 - 450	10 - 450	10 - 600	10 - 1200
<b>Speed Range</b>	<b>(Rpm)</b>	42-63-85-107-154-194-261-387	45-146	25 -85	25 -85	25-85	23-100	42	23-100	61-114
<b>Min. – Max. Die Dia.</b>	<b>(mm)</b>	Ø41-Ø80	Ø50 – Ø80	Ø60 - Ø120	Ø70 - Ø140	Ø110 - Ø175	Ø150 - Ø220	Ø150 - Ø160	Ø165 - Ø220	Ø150 - Ø220
<b>Die Spindle Dia.</b>	<b>(mm)</b>	Ø25,4	Ø25,4	Ø40	Ø40	Ø54 (Ø69.85 optional)	Ø69.85	Ø69.85	Ø80	Ø110
<b>Max. Die Length</b>	<b>(mm)</b>	40	40	80	90	100	140	140	140	140
<b>Workpiece Dia.</b>	<b>(mm)</b>	Ø8 – Ø30	Ø12 – Ø40	Ø12 – Ø40	Ø12 – Ø90 (Ø65)	Ø20 – Ø90 (Ø65)	Ø30 – Ø210 (Ø85)	Ø28 – Ø32 (Ø85)	Ø30 – Ø210 (Ø85)	Ø28 – Ø120 (Ø85)
<b>Max Pitch For Pipe</b>	<b>(mm)</b>	1,75	1,75	2	4	5	7	-	10	-
<b>Max Pitch For Bars</b>	<b>(mm)</b>	1,5	2	2	2,5	3	5	12	6	12
<b>Swivel Angle</b>		±8°	±8°	±8°	±8°	±8°	±12°	±12°	±12°	±12°
<b>Main Motor (Kw)</b>	<b>(Kw)</b>	2,2	5,5	7,5	11	15	22	15	30	75
<b>Total Power (Kw)</b>	<b>(Kw)</b>	3,8	8,8	11,8	15,3	19,3	32,34	18,89	40,34	100
<b>Weight (Kg)(~)</b>	<b>(kg)(~)</b>	750	2150	2400	4150	4500	6260	4900	6950	17700

## Options

- \*Foot pedal
- \*Hand held pendant
- \*Specially designed manual feeding fixtures
- \*Automatic feeding and discharging applications
- \*Part counter
- \*Open Steady rest design
- \*Support for thread length adjustment
- \*Magnetic filter for coolant oil filtration

\*Technical values may be variable upon material type and hardness.

\*Depends on customer request or technical requirements of project; our machines can be equipped with Universal, PLC, MC(Motion Controls) and EM (Electromechanical) Technologies. Please contact with us for details.

\*It is possible to produce machines, which are not specified in above given technical values table. Please contact with us.

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