## DOUBLE D4

**SKU:** 1052

Double Rolling Mill - Double D4 rolling mill from Durston Tools. This exceptional rolling mill has two sets of rolls, the top set for flat rolling and the bottom set grooved for square wire rolling. Both sets of rolls also have extension rollers. The top rolls incorporate four half rounds and the bottom rolls an additional three half rounds. The rolling mill is supplied with two turning levers.

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## PRODUCT DESCRIPTION

This exceptional rolling mill has two sets of rolls, the top set for flat rolling and the bottom set grooved for square wire rolling. Both sets of rolls also have extension rollers. The top rolls incorporate four half rounds and the bottom rolls an additional three half rounds. The rolling mill is supplied with two turning levers. The first is used for heavy rolling, and this includes a gear reduction of 11-1. The second turning lever can be used for lighter rolling at twice the speed with a gear ratio of 5-1. Lever changeover takes only a few seconds. The top mill features an extra wide flat area of 158mm between two rollers with a diameter of 60 mm, each enabling a maximum roll thickness of 6 millimetres. The bottom mill has a total of 19 square wire grooves and 3 half rounds (7x1.75mm, 6x1.5mm,  5x1.25mm) allowing wire rolling from 10mm to 1mm. The side extensions enable half round rolling of 8, 7, 6, 5, 4, 3, 2, and 1.5mm. Safety features include all gearing being covered with plastic housing. The mill itself is constructed from a single piece of cast iron to maximise rigidity and strength, and all rollers are induction hardened to 64 RC to ensure your rolls lasts a lifetime. This is an exceptional workhorse of a rolling mill and will offer years of service.

Click here to download the instruction manual.

Click here to download the mounting hole diagram.

**D4 158 Additional Instructions**

The D4 158 has a second lever which is used for doubling the turning speed of the rolls. This second lever is useful when you are rolling out the smaller jobs where not so much effort is required, making the rolling quicker. For larger jobs, the lower lever, which is located on the wire roll, is the best to use as it gives you the maximum reduction on the gearbox.

To change the standard lever (lower lever on the wire roll) to the second lever, remove the circlip on the wire roll (right-hand side) and the first lever will slide off. Now insert the second lever into the cover on the lower sheet roll. The two hardened dowels will locate into the gear. Then tighten up the two 10mm bolts (17mm spanner).

When turning with the standard lever, turn the lever anti-clockwise. When using the second lever, turn clockwise.

Lower turning reduction (First turning handle): 11-1 on the Flat rolls and 5-1 on the Wire rolls. (Lower turning handle is the lighter lever with the gear on the end. It locates on the end of the wire roll and is secured using a circlip)

Higher turning reduction (second turning handle): 5-1 on the Flat rolls and 2.5-1 on the Wire rolls (Higher turning handle is the heavier lever with the 4" round boss. It locates on the end of the flat roll and is secured using the 2 bolts)

**Additional or Replacement Extension Rollers available for this model:**
Extension Roller 8, 6 & 3mm for Double Rolling Mills (Included as standard)
Extension Roller 10 & 7mm for Double Rolling Mills
Extension Roller 4, 3, 2 & 1.5mm for Double Rolling Mills (Included as standard)
Extension Roller Plain for Double Rolling Mills (Included as standard)
Please read our Rolling Mill FAQs tab for more information.

## ADDITIONAL INFORMATION

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| **Weight** | 85.4 kg |
| **Dimensions** | 74 × 47 × 46 cm |
| **Product Weight (kg)** | 85KG |
| **Product Length (mm)** | 420 |
| **Product Width (mm)** | 220 |
| **Product Height (mm)** | 600 |

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| **Gearbox** | 2.5-to-1 gearbox, 5-to-1, 11-to-1 |
| **Number of Grooves** | 19 |
| **Half round sizes (mm)** | 6 & 5mm, 7 |
| **Max. Sheet Thickness (mm)** | 6 |
| **Roller Type** | Combination |
| **Roller diameter (mm)** | 60 |
| **Roller Length (mm)** | 158 |
| **Side Extensions** | 1.5, 2, 3, 4, 6 and 8mm |
| **Max. wire capacity (mm)** | 10mm |