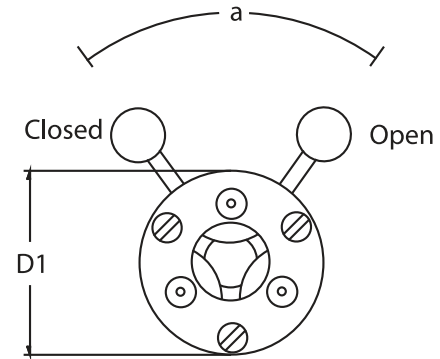
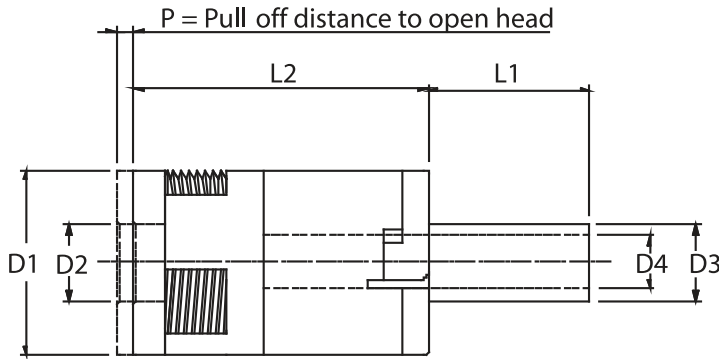


# Axial Thread Rolling

## RA-01 - Axial Head

**AXIAL THREAD ROLLING HEADS**  
FOR RIGHT HAND THREADS  
FOR STATIONARY APPLICATIONS



### Dimensions

Helix Angle in Head = 3° 30'		D1	D2	D3	D4	L1	L2	P	a
Allowable Component Lead	inches	1.575	0.470	3/4 / 5/8	0.295	0.950	1.710	0.060	32°
Angle = 2° 5' - 4° 33'	mm	40	12	20 / 16	7.5	24	43.5	1.5	

The following thread rolls may be ordered as standard on the RA-01 head

#### ISO Metric

Nominal Size x Pitch mm

M 3.5 x 0.6

M 4.0 x 0.7

M 4.0 - M 4.5 x 0.75

M 5.0 x 0.8

M 5.0 - M 5.5 x 0.9

M 6.0 x 1.0

#### ISO Metric Fine

Nominal Size x Pitch mm

M 4.0 - M 5.0 x 0.5

#### Unified Coarse UNC

Nominal Size x TPI

No. 8 x 32

No. 10 - No. 12 x 24

1/4 x 20

#### Unified Fine UNF

Nominal Size x TPI

No. 6 x 40

No. 8 x 36

No. 10 x 32

No. 12 x 28

1/4 x 28

#### Whitworth BSW

Nominal Size x TPI

5/32 x 32

3/16 - 7/32 x 24

#### Whitworth Fine BSF

Nominal Size x TPI

3/16 x 32

7/32 x 28

1/4 x 26

Threads outside of the above standard series may also be rolled on this head provided that their helix does not fall outside the permissible range.

Left hand threads are dimensionally the same as right hand heads but open and close on the opposite direction. Thread rolls can be used in both right hand and left hand heads.