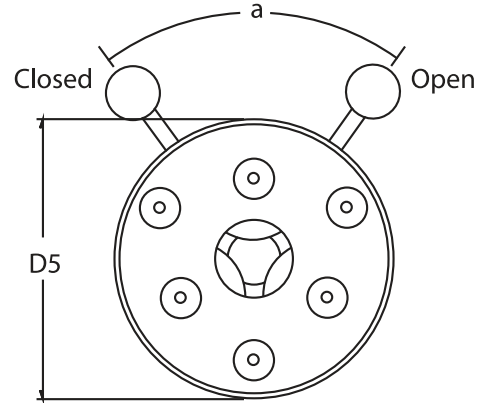
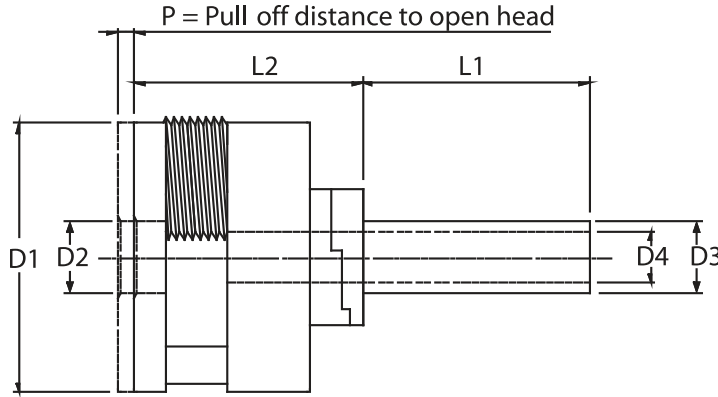


# Axial Thread Rolling

## RA-I - Axial Head

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



### Dimensions

Helix Angle in Head = 3° 30'		D1	D2	D3	D4	D5 max	L1	L2	P	a
Allowable Component Lead	inches	2.520	0.670	3/4	0.440	2.756	2.360	1.970	0.080	60°
Angle = 2° 5' - 4° 33'	mm	64	17	20	11	70	60	50	2	

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

#### ISO Metric

Nominal Size x Pitch mm

M 6.0 - M 7.0 x 1.0

M 8.0 - M 9.0 x 1.25

M 10.0 x 1.5

#### ISO Metric Fine

Nominal Size x Pitch mm

M 6.0 - M 7.0 x 0.75

M 8.0 x 1.0

M 10.0 x 1.25

#### Unified Coarse UNC

Nominal Size x TPI

1/4 x 20

5/16 x 18

3/8 x 16

7/16 x 14

#### Unified Fine UNF

Nominal Size x TPI

1/4 x 28

5/16 - 3/8 x 24

#### Whitworth BSW

Nominal Size x TPI

1/4 x 20

5/16 x 18

3/8 x 16

#### Whitworth Fine BSF

Nominal Size x TPI

1/4 x 26

5/16 x 22

3/8 x 20

7/16 x 20

#### American Pipe Threads

Nominal Size x TPI

1/16x27 NPT & NPTF

1/8x27 NPT & NPTF

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.