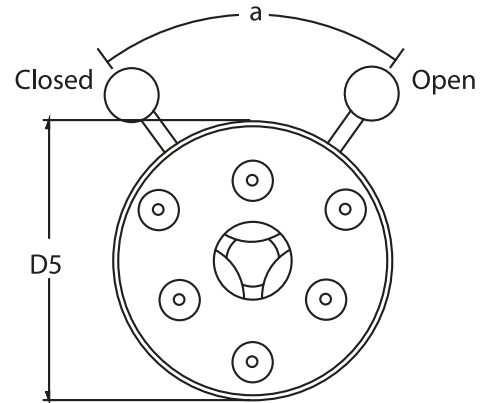
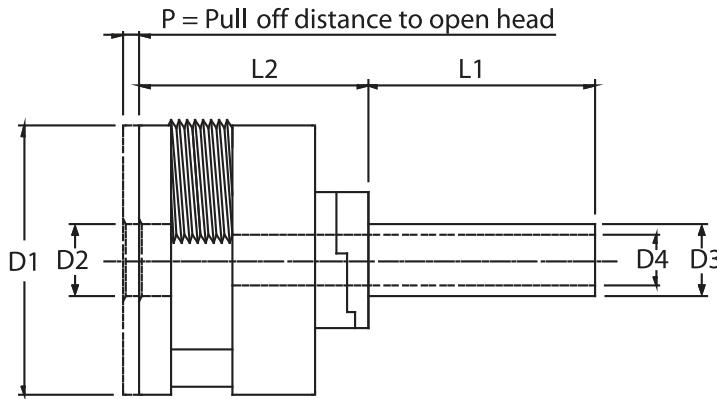


Axial Thread Rolling

RA-12 - Axial Head

AXIAL THREAD ROLLING HEADS
FOR RIGHT HAND THREADS
FOR STATIONARY APPLICATIONS



Dimensions

Helix Angle in Head = 1° 50'		D1	D2	D3	D4	D5 max	L1	L2	P	a
Allowable Component Lead	inches	2.520	0.790	3/4	0.430	2.756	2.360	1.970	0.080	60°
Angle = 1° 5' - 2° 23'	mm	64	20	20	11	70	60	50	2	

The following thread rolls may be ordered as standard on the RA-12 head

ISO Metric

Nominal Size x Pitch mm

M 6.0 - M 7.0 x 0.5
M 7.0 - M 8.0 x 0.5
M 6.0 - M 7.0 x 0.75
M 8.0 - M 9.0 x 0.75
M 9.0 - M 10.0 x 0.75
M 10.0 - M 11.0* x 0.75
M 11.0* - M 12.0* x 0.75
M 8.0 - M 9.0 x 1.0
M 9.0 - M 10.0 x 1.0
M 10.0 - M 11.0* x 1.0
M 11.0* - M 12.0* x 1.0
M 10.0 - M 11.0* x 1.25
M 11.0* - M 12.0* x 1.25
M 12.0* x 1.5

Unified Fine UNF Whitworth Fine BSF

Nominal Size x TPI

1/4 - 5/16 x 40
5/16 - 3/8 x 36
7/16* x 36
5/16 - 3/8 x 32
7/16* - 1/2* x 32
3/8 - 7/16* x 28
1/2* x 28
7/16* - 1/2* x 26
3/8 - 7/16* x 24
7/16* - 1/2* x 24
7/16* - 1/2* x 22
7/16* - 1/2* x 20

Whitworth Pipe BSP

Nominal Size x TPI

G 1/8 x 28
G 1/4* x 19

American Pipe Threads

Nominal Size x TPI

1/8x27 NPT & NPTF
1/4x18 NPT & NPTF

* For short threads up to 0.551" length including thread run-out

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.