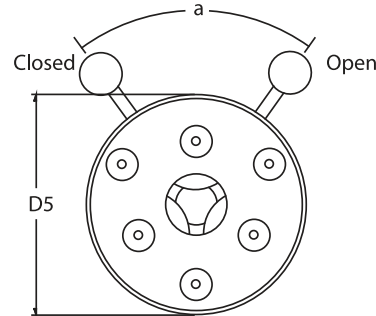
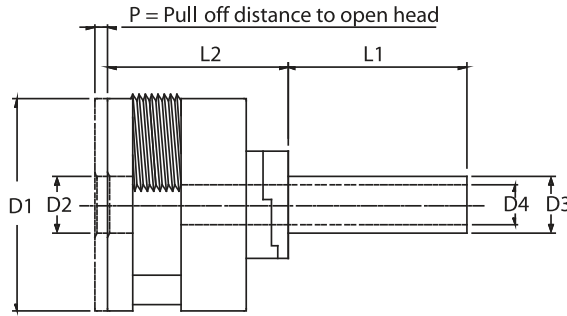


Axial Thread Rolling

RA-233400 - Axial Head

AXIAL THREAD ROLLING HEADS
FOR RIGHT HAND THREADS
FOR STATIONARY APPLICATIONS



Dimensions

Helix Angle in Head = 1° 15'		D1	D2	D3	D4	D5 max	L1	L2	P	a
Allowable Component Lead	inches	3.780	1.540	1 / 1.1/4	0.550	4.528	2.360	3.250	0.120	30°
Angle = 0° 45' - 1° 40'	mm	96	39	25 / 30	14	115	60	82.5	3	

The following thread rolls may be ordered as standard on the RA-233400 head

ISO Metric Fine

Nominal Size x Pitch mm

M 16* - M 18* x 1.5
M 18* - M 20* x 1.5
M 20* - M 22* x 1.5
M 22* - M 24* x 1.5
M 24* - M 26* x 1.5
M 26* - M 28** x 1.5
M 28** - M 30** x 1.5
M 30** - M 32** x 1.5
M 32** - M 34** x 1.5
M 34** - M 36** x 1.5
M 22* - M 24* x 2.0
M 24* - M 26* x 2.0
M 26* - M 28** x 2.0
M 28** - M 30** x 2.0
M 30** - M 32** x 2.0
M 32** - M 34** x 2.0
M 34** - M 36** x 2.0

* For short threads up to 2.638" length including thread run-out

** For short threads up to 0.945" length including thread run-out

Whitworth Pipe BSP

Nominal Size x TPI

G 3/8* x 19
G 1/2* x 14
G 5/8* x 14
G 3/4* x 14
G 7/8** x 14
G 1** x 11

Unified Fine UNF Whitworth Fine BSF

Nominal Size x TPI

3/4* x 26
5/8* x 24
11/16* x 24
3/4* x 24
7/8* x 24
3/4* x 22
7/8* x 22
5/8* - 11/16* x 20
11/16* - 3/4* x 20
3/4* - 13/16* x 20
13/16* - 7/8* x 20
7/8* - 15/16* x 20
15/16* - 1* x 20

continued...

Unified Fine UNF Whitworth Fine BSF

continued...

Nominal Size x TPI

1* - 1.1/16* x 20
1* - 1.1/16* x 20
1.1/16* - 1.1/8** x 20
1.1/8** - 1.3/16** x 20
5/8* x 18
3/4* x 18
7/8* x 18
1* x 1.1/16* x 18
1.1/16* - 1.1/8** x 18
1.1/8 - 1.3/16 x 18
11/16* - 3/4* x 16
3/4* - 13/16* x 16
13/16* - 7/8* x 16
7/8* - 15/16* x 16
15/16* - 1* x 16
1* - 1.1/16* x 16
1.1/16* - 1.1/8** x 16
1.1/8** - 1.3/16** x 16
1.3/16** - 1.1/4** x 16
1.1/4** - 1.5/16** x 16
1.5/16** - 1.3/8** x 16

continued...

Unified Fine UNF Whitworth Fine BSF

continued...

Nominal Size x TPI

1.3/8** - 1.7/16** x 16
13/16* - 7/8* x 14
7/8* - 15/16* x 14
15/16* - 1* x 14
1* - 1.1/16* x 14
1.1/16* - 1.1/8** x 14
1.1/8** - 1.3/16** x 14
1.3/16** - 1.1/4** x 14
1.1/4** - 1.5/16** x 14
1.5/16** - 1.3/8 x 14
1.3/8** - 1.7/16** x 14
7/8* - 15/16* x 12
15/16* - 1* x 12
1* - 1.1/16* x 12
1.1/16* - 1.1/8** x 12
1.1/8** - 1.3/16** x 12
1.3/16** - 1.1/4** x 12
1.1/4** - 1.5/16** x 12
1.5/16** - 1.3/8** x 12
1.3/8** - 1.7/16** x 12

American Pipe Threads

Nominal Size x TPI

3/8x18 NPT & NPTF

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.

