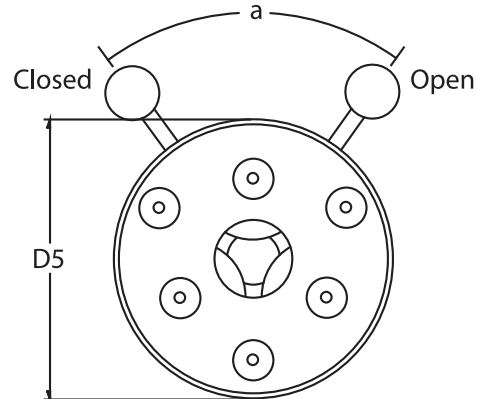
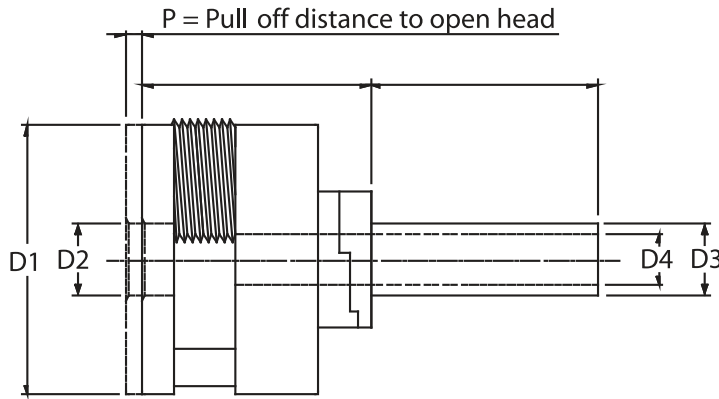


Axial Thread Rolling

RA-3 - Axial Head

AXIAL THREAD ROLLING HEADS
FOR RIGHT HAND THREADS
FOR STATIONARY APPLICATIONS



Dimensions

Helix Angle in Head = 2° 40'		D1	D2	D3	D4	D5 max	L1	L2	P	a
Allowable Component Lead	inches	4.600	1.500	1.25/1.5	0.870	5.157	3.540	3.270	0.160	60°
Angle = 1° 35' - 3° 30'	mm	117	38	30 / 40	22	131	89	83	4	

The following thread rolls may be ordered as standard on the RA-3 head

ISO Metric

Nominal Size x Pitch mm

M 12.0 - M 14.0 x 1.75

M 14.0 - M 16.0 x 2.0

M 18.0 - M 20.0 x 2.5

M 20.0 - M 22.0* x 2.5

ISO Metric Fine

Nominal Size x Pitch mm

M 12.0 - M 14.0 x 1.5

M 14.0 - M 16.0 x 1.5

M 18.0 - M 20.0 x 2.0

M 20.0 - M 22.0* x 2.0

Unified Coarse UNC

Nominal Size x TPI

7/16 x 14

1/2 x 13

9/16 x 12

5/8 x 11

3/4 x 10

7/8* x 9

Unified Fine UNF

Nominal Size x TPI

7/16 - 1/2 x 20

9/16 - 5/8 x 18

3/4 x 16

7/8 x 14*

Whitworth BSW

Nominal Size x TPI

7/16 x 14

1/2 - 9/16 x 12

5/8 - 11/16 x 11

3/4 x 10

7/8* - 15/16* x 9

Whitworth Fine BSF

Nominal Size x TPI

7/16 x 18

1/2 - 9/16 x 16

5/8 - 11/16 x 14

3/4 x 12

7/8* - 15/16* x 11

Whitworth Pipe BSP

Nominal Size x TPI

G 1/4 x 19

G 1/2 x 14

American Pipe Threads

Nominal Size x TPI

1/4x18 NPT & NPTF

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

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.