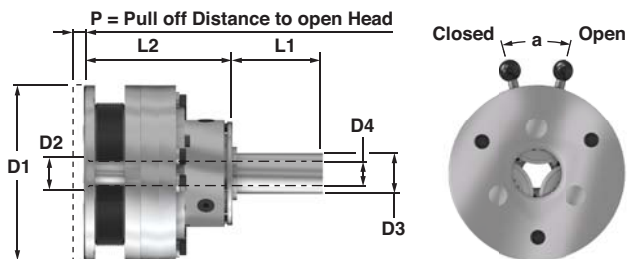


A4 Axial Head

EDP	Shank	EDP	Shank
7121	1/1/02	7121-40	40mm
7124	2"	7124-50	50mm

Approximate Weight: 30 lbs



Axial Thread Rolling Heads

For Right Hand Threads
For Stationary Applications

A4 Axial Head Dimensions

Dimensions

Helix Angle in Head = 2° 30'	D1	D2	D3	D4
Allowable Component Lead inches	6.339	1.811	1.5 / 2	1.100 / 1.260
Angle = 1° 30' - 3° 10'	mm	161	46	40 / 50
				28 / 32

Dimensions Continued

Helix Angle in Head = 2° 30'	L1	L2	P	a
Allowable Component Lead inches	2.953	6.142	0.157	30°
Angle = 1° 30' - 3° 10'	mm	75	156	4

Left hand heads 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.

The Following Thread Rolls May Be Ordered As Standard On The A4 Axial Head

ISO Metric		
1K EDP	2K EDP	Description
8745	8746	M14.0 - 16.0 x 2.0
8747	8748	M18.0 - 20.0 x 2.5
8592	8750	M20.0 - 22.0 x 2.5
8749	8690	M24.0 - 27.0 x 3.0
2826	2827	M27.0 - 30.0 x 3.5

Unified Coarse UNC		
1K EDP	2K EDP	Description
8759	8760	9/16 x 12
8696	8697	5/8 x 11
2514	2523	3/4 x 10
8699	2850	7/8 x 9
1742	1638	1" x 8
8761	8762	1-1/8 x 7

Unified Fine UNF		
1K EDP	2K EDP	Description
2181	8763	9/16 - 5/8 x 18
8693	8764	3/4 x 16
2496	8765	7/8 x 14
2547	2548	1 x 12
8597	8599	1 x 14

National Pipe Thread NPT		
1K EDP	2K EDP	Description
8766	8767	1/2 x 14 NPT

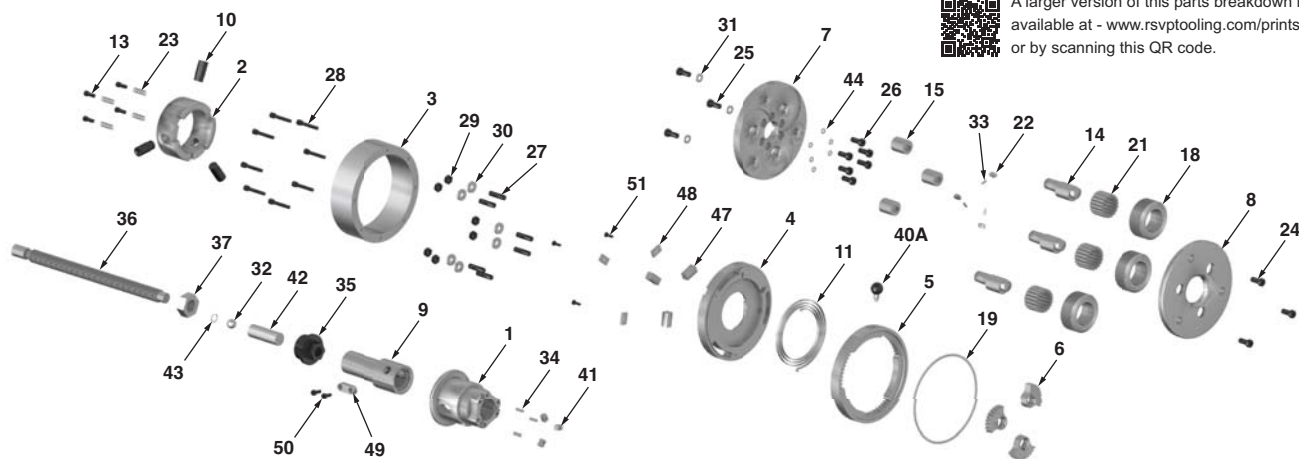
National Pipe Thread Dryseal NPTF		
1K EDP	2K EDP	Description
8768	8769	1/2 x 14 NPTF

ISO Metric Fine		
1K EDP	2K EDP	Description
8751	8752	M14.0 - 16.0 x 1.5
8753	8754	M16.0 - 18.0 x 1.5
8755	8756	M18.0 - 20.0 x 2.0
8757	8758	M22.0 - 24.0 x 2.0

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.

Nitrided Rolls are available for use in rolling special alloys such as Stainless Steel.

Component Parts Breakdown



Ref	Qty	Description	EDP
1	1	Flange	4-001
2	1	Clutch	4-002
3	1	Operating Ring	4-003
4	1	Spring Housing	4-004
5	1	Gear Ring	4-005
6	3	Gear Sectors	4-006
7	1	Center Plate	4-007
8	1	Front Plate	4-008
9	1	Shank 1-1/2	4-009
9A	1	Shank 2"	4-009A
9B	1	Shank 40mm	4-009B
9C	1	Shank 50mm	4-009C
10	1	Pin	4-010
11	1	Coil Spring	4-011
13	4	Spring Pin	4-013
14	3	Eccentric Spindles	4-014
15	3	Spacer Studs	4-015

Ref	Qty	Description	EDP
18	3	Thread Roll	
		(See Chart for Size & EDP)	
19	116	Steel Ball	4-019
21	57	Needle Roller Bearings	4-021
21*	3	Carbide Bushing	1462
22	3	Fitting Key	4-022
23	4	Pressure Ring	4-023
24	3	Cap Screw	4-024
25	3	Cap Screw	4-025
26	6	Cap Screw	4-026
27	6	Stud	4-027
28	8	Cap Screw	4-028
29	6	Hex Nut	4-029
30	6	Washer	4-030
31	3	Lock Washer	4-031
32	1	Steel Ball	4-032
33	3	Shear Pins	4-033

Ref	Qty	Description	EDP
34	3	Roll Pins	4-034
35	1	Stop Screw Body	4-035
36	1	Stop Screw Body	4-036
37	1	Hex Nut	4-037
39	1	Hex Nut	4-039
40A	1	Handle Assy.	4-040A
41	3	Fitting Key	4-041
42	1	Rotating End Stop	4-042
43	1	Circlip	4-043
44	6	Circlip	4-044
47	3	Clutch Wedge	4-047
48	3	Cover Plate	4-048
49	1	Fitting Key	4-049
50	2	Cap Screw	4-050
51	3	Cap Screw	4-051