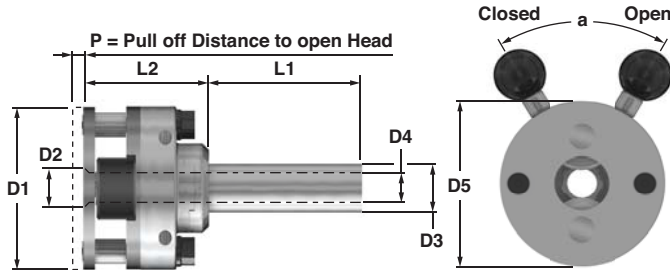


AO Axial Head

EDP	Shank
7101	3/4
7101-20	20mm

Approximate Weight: 1.2 lbs



Axial Thread Rolling Heads For Right Hand Threads For Stationary Applications

AO Axial Head Dimensions

Dimensions

		D1	D2	D3	D4	D5 max
Helix Angle in Head = 4°						
Allowable Component Lead	inches	1.970	0.453	3/4	0.260	2.146
Angle = 2° 25' - 5° 12'	mm	50	11.5	20	6.5	54.5

Dimensions Continued

		L1	L2	P	a
Helix Angle in Head = 4°					
Allowable Component Lead	inches	1.970	1.520	0.080	50°
Angle = 2° 25' - 5° 12'	mm	50	39	2	

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 AO Axial Head

ISO Metric		
1K EDP	2K EDP	Description
8101	8102	M1.4 x 0.3
8103	8104	M1.6 - 1.8 x .035
8105	8106	M2.0 - 2.3 x 0.4
8107	8108	M2.2 - 2.6 x 0.45
8109	8110	M2.5 - 3.0 x 0.5
8111	8112	M3.0 - 3.5 x 0.6
8113	8114	M4 x .07
8115	8116	M4.0 - 4.5 x 0.75
8117	8118	M5 x 0.8
8119	8120	M5.0 - 5.5 x 0.9

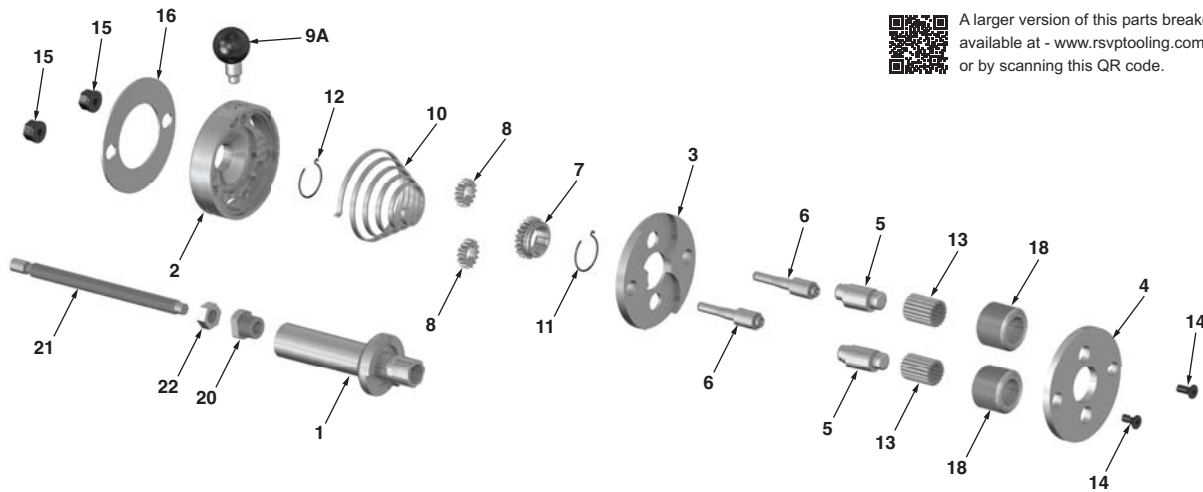
Unified Coarse UNC		
1K EDP	2K EDP	Description
8121	8122	No. 1 x 64
8123	8124	No. 2 x 56
8125	8126	No. 3 x 48
8127	8128	No. 4 - 5 x 40
8129	8130	No. 6 - 8 x 32
8131	8132	No. 10 - 12 x 24

Unified Fine UNF		
1K EDP	2K EDP	Description
8133	8134	No. 0 x 80
8135	8136	No. 1 x 72
8137	8138	No. 2 x 64
8139	8140	No. 3 x 56
8141	8142	No. 4 x 48
8143	8144	No. 5 x 44
8145	8146	No. 6 x 40
8147	8148	No. 8 x 36
8149	8150	No. 10 x 32
8151	8152	No. 12 x 28

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



A larger version of this parts breakdown is available at - www.rsptooling.com/prints.html or by scanning this QR code.

Ref	Qty	Description	EDP
1	1	Shank	7500
2	1	Spring Housing	7501
3	1	Center Plate	7502
4	1	Front Plate	7503
5	2	Eccentric Spindle	7504
6	2	Spacer Stud	7505
7	1	Center Gear	7506
8	2	Outer Gear	7507

Ref	Qty	Description	EDP
9A	1	Handle Assy.	7508A
10	1	Coil Spring	7509
11	1	Circlip	7510
12	1	Circlip	7511
13	36	Needle Bearings	7512
13*	2	Carbide Bushing	1466
14	2	Front Plate Screw	7514
15	2	Hexagon Nut	7515

Ref	Qty	Description	EDP
16	1	Ring Washer	7516
18	3	Thread Roll (See Chart for Size & EDP)	
20	1	Stop Screw Body	7517
21	1	Stop Screw	7518
22	1	Hexagon Nut	7519

(*) #13 Needle Bearings are provided as standard. Optional Carbide Bushings provided at additional cost upon request.