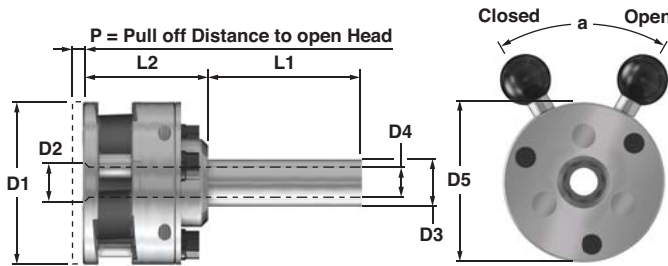


## A1 Axial Head

EDP	Shank
7104	3/4
7104-20	20mm

Approximate Weight: 2.0 lbs



## Axial Thread Rolling Heads For Right Hand Threads For Stationary Applications

### A1 Axial Head Dimensions

#### Dimensions

	D1	D2	D3	D4	D5 max
Helix Angle in Head = 3° 30'					
Allowable Component Lead inches	2.520	0.670	3/4	0.440	2.756
Angle = 2° 5' - 4° 33'	mm	64	17	20	11

#### Dimensions Continued

	L1	L2	P	a
Helix Angle in Head = 3° 30'				
Allowable Component Lead inches	2.360	1.970	0.080	60°
Angle = 2° 5' - 4° 33'	mm	60	50	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 A1 Axial Head

ISO Metric		
1K EDP	2K EDP	Description
8001	8002	M6.0 - 8.0 x 1.0
8003	8004	M8.0 - 9.0 x 1.25
8005	8006	M10.0 x 1.5

ISO Metric Fine		
1K EDP	2K EDP	Description
8047	8046	M6.0 - 8.0 x 0.75
8055	8056	M8.0 - 10.0 x 1.0
9945	9953	M10.0 - 11.0 x 1.25

Unified Coarse UNC		
1K EDP	2K EDP	Description
8007	8008	1/4 x 20
8009	8010	5/16 x 18
8011	8012	3/8 x 16
8013	8014	7/16 x 14

Unified Fine UNF		
1K EDP	2K EDP	Description
8015	8016	1/4 x 28
8017	8018	5/16 - 3/8 x 24
8068	8070	7/16 x 20

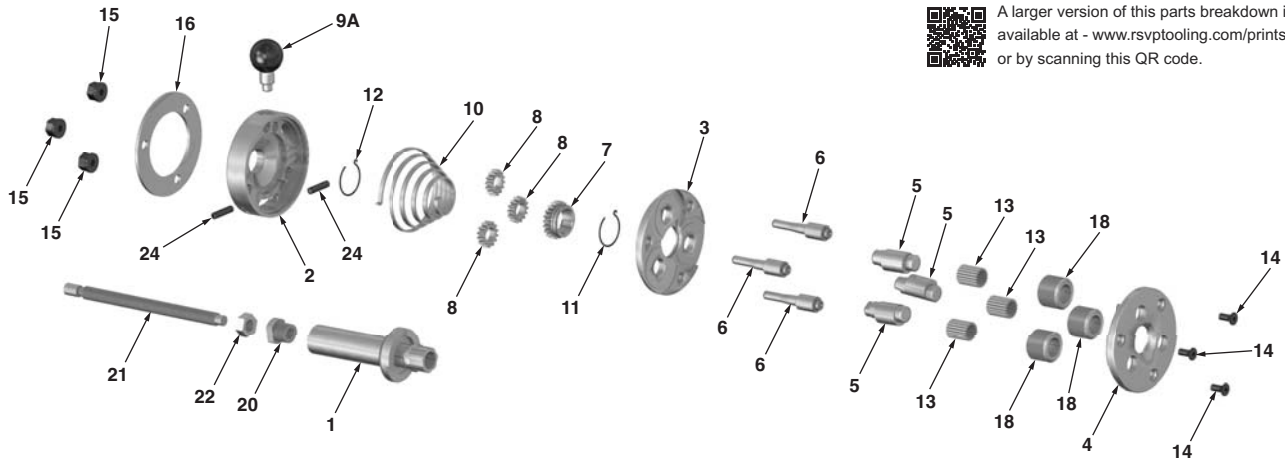
National Pipe Thread NPT		
1K EDP	2K EDP	Description
8058	8059	1/16 x 27 NPT
8060	8061	1/8 x 27 NPT

National Pipe Thread Dryseal NPTF		
1K EDP	2K EDP	Description
8062	8063	1/16 x 27 NPTF
8064	8065	1/8 x 27 NPTF

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.rsvptooling.com/prints.html](http://www.rsvptooling.com/prints.html) or by scanning this QR code.

Ref	Qty	Description	EDP
1	1	Shank 3/4"	7554
1A	1	Shank 20mm	7554-20
2	1	Spring Housing	7571
3	1	Center Plate	7556
4	1	Front Plate	7557
5	3	Eccentric Spindle	7558
6	3	Spacer Stud	7559
7	1	Center Gear	7560

Ref	Qty	Description	EDP
8	3	Outer Gear	7561
9A	1	Handle Assy.	7576A
10	1	Coil Spring	7563
11	1	Circlip	7564
12	1	Circlip	7565
13	57	Needle Roller Bearings	7566
13*	3	Carbide Bushing	1455
14	3	Front Plate Screw	7568

Ref	Qty	Description	EDP
15	3	Hexagon Nut	7578
16	1	Ring Washer	7570
18	3	Thread Roll (See Chart for Size & EDP)	
20	1	Stop Screw Body	2185
21	1	Stop Screw	2187
22	1	Hexagon Nut	2186
24	2	Set Screw (2/set)	2190

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