

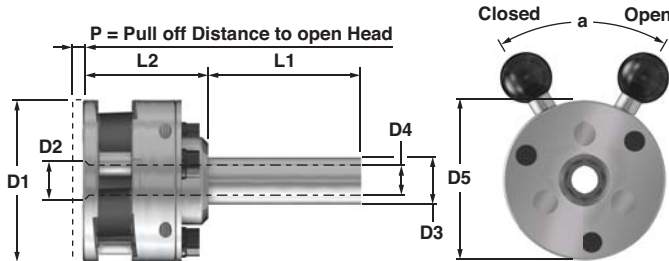
A3 Axial Head

EDP	Shank	EDP	Shank
7109	1-1/2	7109-30	30mm
7109-1.25	1-1/4	7109-32	32mm

Approximate Weight: 8.3 lbs

Axial Thread Rolling Heads For Right Hand Threads For Stationary Applications

A3 Axial Head Dimensions



Dimensions

	D1	D2	D3	D4	D5 max
Helix Angle in Head = 2° 40'					
Allowable Component Lead inches	4.600	1.500	1.25/1.5	0.870	5.157
Angle = 1° 35' - 3° 30'	mm	117	38	30 / 40	22

Dimensions Continued

	L1	L2	P	a
Helix Angle in Head = 2° 40'				
Allowable Component Lead inches	3.540	3.270	0.160	60°
Angle = 1° 35' - 3° 30'	mm	89	83	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 A3 Axial Head

ISO Metric		
1K EDP	2K EDP	Description
8523	8562	M12.0 - 14.0 x 1.75
8525	8526	M14.0 - 16.0 x 2.0
8527	8528	M18.0 - 20.0 x 2.5
8529	8530	M20.0 - 22.0 x 2.5

ISO Metric Fine		
1K EDP	2K EDP	Description
8531	8532	M12.0 - 14.0 x 1.5
8533	8534	M14.0 - 16.0 x 1.5
8535	8536	M18.0 - 20.0 x 2.0
8537	8538	M20.0 - 22.0 x 2.0

Unified Coarse UNC		
1K EDP	2K EDP	Description
8539	8540	7/16 x 14
8541	8542	1/2 x 13
8543	8563	9/16 x 12
8545	8546	5/8 x 11
8547	8548	3/4 x 10
8549	8550	7/8 x 9

Unified Fine UNF		
1K EDP	2K EDP	Description
8551	8552	7/16 - 1/2 x 20
8553	8554	9/16 - 5/8 x 18
1514	1492	3/4 x 16
8561	8560	7/8 x 14

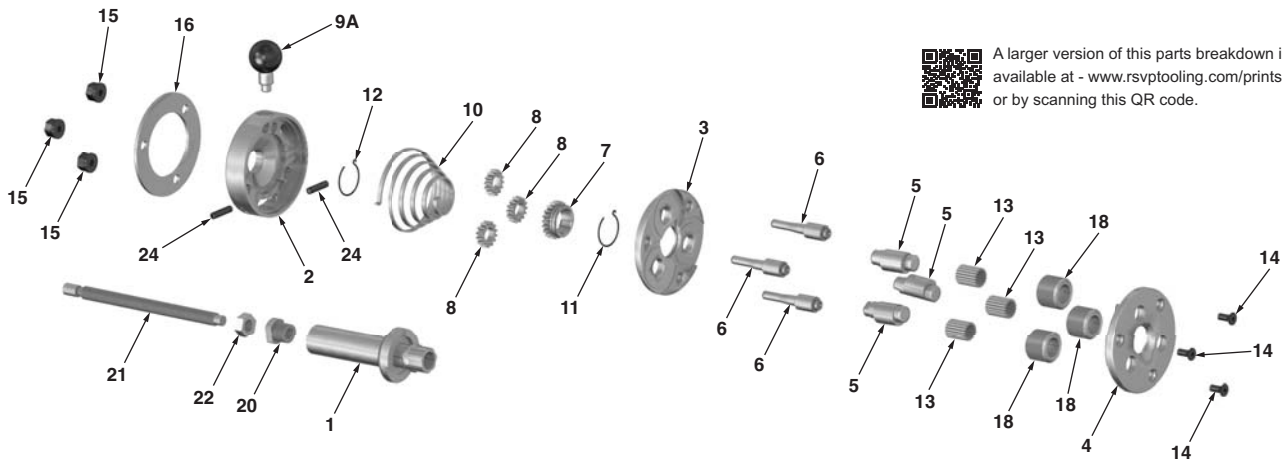
National Pipe Thread NPT		
1K EDP	2K EDP	Description
8569	8570	1/4 x 18 NPT

National Pipe Thread Dryseal NPTF		
1K EDP	2K EDP	Description
8567	8568	1/4 x 18 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 or by scanning this QR code.

Ref	Qty	Description	EDP
1	1	Shank 1-1/2	7364
1A	1	Shank 1-1/4	7361
1B	1	Shank 30mm	7364-30
1C	1	Shank 32mm	7364-32
2	1	Spring Housing	7375
3	1	Center Plate	7358
4	1	Front Plate	7359
5	3	Eccentric Spindle	7360
6	3	Spacer Stud	7357

Ref	Qty	Description	EDP
7	1	Center Gear	7362
8	3	Outer Gear	7363
9A	1	Handle Assy.	7369A
10	1	Coil Spring	7365
11	1	Circlip	7366
12	1	Circlip	7367
13	57	Needle Roller Bearings	7368
13*	3	Carbide Bushing	1460
14	3	Front Plate Screw	7370

Ref	Qty	Description	EDP
15	3	Hexagon Nut	7371
16	1	Ring Washer	7387
18	3	Thread Roll (See Chart for Size & EDP)	
20	1	Stop Screw Body	7372
21	1	Stop Screw	7373
22	1	Hexagon Nut	7374
24	2	Set Screw (2/set)	7312

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