



TANGENTIAL Thread Rolls

Unified Threads			
Thread Size	RT10	RT20	RT30
2-56 UNC	X	X	
2-64 UNF	X	X	
3-48 UNC	X	X	
3-56 UNF	X	X	
4-40 UNC	X	X	
4-48 UNF	X	X	
5-40 UNC	X	X	
5-44 UNF	X	X	
6-32 UNC	X	X	
6-40 UNF	X	X	
8-32 UNC	X	X	
10-24 UNC	X	X	
10-32 UNF	X	X	
12-24 UNC	X	X	
12-28 UNF	X	X	
12-32 UNEF	S	S	
1/4-20 UNC	X	X	X
1/4-28 UNF	X	X	X
1/4-32 UNEF	S	S	S
5/16-18 UNC	X	X	X
5/16-24 UNF	X	X	X
5/16-32 UNEF	S	S	S
3/8-16 UNC	X	X	X
3/8-24 UNF	X	X	X
3/8-32 UNEF	S	S	S
7/16-14 UNC		X	X
7/16-20 UNF	X	X	X
7/16-28 UNEF	S	S	S
1/2-13 UNC	X	X	
1/2-20 UNF	X	X	X
1/2-28 UNEF	S	S	S
9/16-12 UNC		X	X
9/16-18 UNF	X	X	X
9/16-24 UNEF	S	S	S
5/8-11 UNC			X
5/8-18 UNF		X	X
5/8-24 UNEF		S	S
1 1/16-24 UNEF		S	S
3/4-10 UNC		X	X
3/4-16 UNF		X	X
3/4-20 UNEF		X	X
13/16-20 UNEF		S	S
7/8-14 UNF		X	X
7/8-20 UNEF		X	X
15/16-20 UNEF		S	S
1-12 UNF		X	X
1-20 UNEF		X	X
1-1/16-18 UNEF		S	S
1-1/8-12 UNF		X	X
1-1/8-18 UNEF		S	S
1-3/16-18 UNEF		S	S
NPT/NPTF Threads			
1/16-27	X	X	X
1/8-27	X	X	X
1/4-18		X	X
3/8-18		X	X
1/2-14		X	X
3/4-14		X	X
1-11.5			X
1-1/4-11.5			X

Standard Rolls For
Rolling Heads "X" Indicates Standard
For Designed Head Size "S" Indicates Special

Standard Roll Widths

RT10 Rolls Available In: 4MM, 6MM, 8MM, 10MM, 12MM, 14MM, 15.5MM

RT20 Rolls Available In: 6MM, 8MM, 10MM, 12MM,
14MM, 16MM, 18MM, 21.5MM

RT30 Rolls Available In: 8MM, 10MM, 12MM, 14MM, 16MM, 18MM,
20MM, 22MM, 24MM, 26MM, 28MM, 30MM

Thread Rolls Are Interchangeable With:

RT10 with T12 **RT20** with T18 **RT30** with T27

Metric Threads			
Thread Size	RT10	RT20	RT30
M2 X 0.4	X		
M2.2 X 0.45	X		
M2.5 X 0.45	X		
M3 X 0.5	X	X	
M3.5 X 0.5	X	X	
M4 X 0.7	X	X	
M5 X 0.8	X	X	
M5 X 0.5	S	S	
M6 X 1	X	X	X
M6 X 0.75	S	S	S
M6 X 0.5	S	S	S
M8 X 1.25	X	X	X
M8 X 1.25	X	X	X
M8 X 0.75	S	S	S
M8 X 0.5	S	S	S
M10 X 1.5	X	X	X
M10 X 1.25	X	X	X
M10 X 1	X	X	X
M10 X 0.75	S	S	S
M12 X 1.75		X	X
M12 X 1.5	X	X	X
M12 X 1.25	X	X	X
M12 X 1	X	X	X
M14 X 2		X	X
M14 X 1.5	X	X	X
M14 X 1.25	X	X	X
M14 X 1	X	X	X
M16 X 2		X	X
M16 X 1.5		X	X
M16 X 1.5		X	X
M16 X 1		X	X
M18 X 2		X	X
M18 X 1.5		X	X
M18 X 1.5		X	X
M20 X 2		X	X
M20 X 1.5		X	X
M20 X 1		X	X
M22 X 2		X	X
M22 X 1.5		X	X
M22 X 1		X	X
M24 X 2		X	X
M24 X 1.5		X	X
M24 X 1		X	X
M26 X 1.5		X	X
M27 X 2		X	X
M27 X 1.5		X	X
M28 X 1.5		X	X
M30 X 2		X	X
M30 X 1.5		X	X
M33 X 2			X
M33 X 1.5			X
M35 X 1.5			X
M36 X 2			X
M36 X 1.5			X
M39 X 2			X
M39 X 1.5			X
M40 X 1.5			X
M42 X 2			X
M42 X 1.5			X
Whitworth Pipe Parallel			
G1/8-28	X	X	X
G1/4-19	X	X	X
G3/8-19		X	X
G1/2-14		X	X
G5/8-14		X	X
G3/4-14		X	X
G7/8-14			X
G1-11			X
G1-1/8-11			X
G1-1/4-11			X