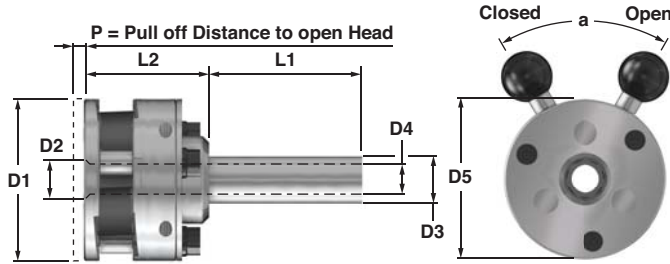


A23 Axial Head

EDP	Shank
7107	1"
7107-25	25mm

Approximate Weight: 4.2 lbs



Axial Thread Rolling Heads For Right Hand Threads For Stationary Applications

A23 Axial Head Dimensions

Dimensions

Helix Angle in Head = 1° 25'	D1	D2	D3	D4	D5 max	
Allowable Component Lead	inches	3.470	1.100	1	0.670	3.681
Angle = 0° 50' - 2° 0'	mm	88	28	25	17	93.5

Dimensions Continued

Helix Angle in Head = 1° 25'	L1	L2	P	a	
Allowable Component Lead	inches	2.990	2.720	0.120	60°
Angle = 0° 50' - 2° 0'	mm	76	69	3	

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 A23 Axial Head

ISO Metric Fine		
1K EDP	2K EDP	Description
8323	8324	M8.0 - 10.0 x 0.5
8325	8326	M8.0 - 10.0 x 0.75
8289	8290	M10.0 - 12.0 x 0.75
8291	8292	M10.0 - 12.0 x 1.0
8293	8294	M12.0 - 14.0 x 1.0
8341	8342	M14.0 - 16.0 x 1.0
8297	8298	M16.0 - 18.0 x 1.0
8299	8300	M18.0 - 20.0 x 1.0
8301	8302	M14.0 - 16.0 x 1.25
8303	8304*	M16.0 - 18.0 x 1.5
8305	8306*	M18.0 - 20.0 x 1.5
8307	8308*	M20.0 - 22.0 x 1.5

Unified Fine UNF		
1K EDP	2K EDP	Description
8327	8328	5/16 - 3/8 x 32
8329	8330	3/8 - 7/16 x 32
8331	8332	7/16 - 1/2 x 28
8333	8334	7/16 - 1/2 x 32
8353	8354	1/2 - 9/16 x 20
8337	8338	1/2 - 9/16 x 28
8339	8340	1/2 - 9/16 x 32
8365	8366	9/16 - 5/8 x 18
8343	8344	9/16 - 5/8 x 20
8345	8346	9/16 - 5/8 x 24
8347	8348	9/16 - 5/8 x 28
8335	8336	9/16 - 5/8 x 32

Unified Fine UNF (Continued)		
1K EDP	2K EDP	Description
8351	8352	5/8 - 11/16 x 16*
8349	8350	5/8 - 11/16 x 20*
8367	8368	5/8 - 11/16 x 24*
8369	8370	5/8 - 11/16 x 28*
8359	8360	11/16 - 3/4 x 16*
8361	8362	11/16 - 3/4 x 20*
8363	8364	3/4 - 13/16 x 16*
8365	8366	3/4 - 13/16 x 20*
8355	8356	13/16 - 7/8 x 20*

National Pipe Thread NPT		
1K EDP	2K EDP	Description
8309	8310	1/8 x 27 NPT
8313	8314	1/4 x 18 NPT
8315	8316	3/8 x 18 NPT

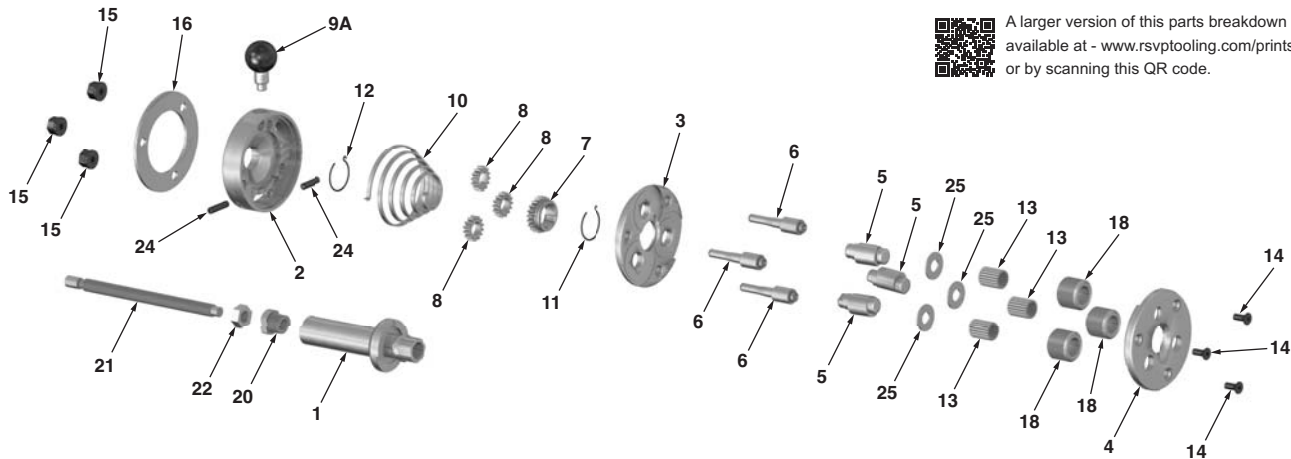
National Pipe Thread Dryseal NPTF		
1K EDP	2K EDP	Description
8317	8318	1/8 x 27 NPTF
8319	8320	1/4 x 18 NPTF
8321	8322	3/8 x 18 NPTF

(*) Limited to short threads up to 19mm (0.748") including thread runout

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.rsvp tooling.com/prints.html or by scanning this QR code.



Ref	Qty	Description	EDP
1	1	Shank 1"	7590
1A	1	Shank 25mm	7590-25
2	1	Spring Housing	7310
3	1	Center Plate	7491
4	1	Front Plate	7492
5	3	Eccentric Spindle	7589
6	3	Spacer Stud	7493
7	1	Center Gear	7494

Ref	Qty	Description	EDP
8	3	Outer Gear	7495
9A	1	Handle Assy.	7604A
10	1	Coil Spring	7600
11	1	Circlip	7601
12	1	Circlip	7683
13	57	Needle Roller Bearings	7566
13*	3	Carbide Bushing	1455
14	3	Front Plate Screw	7605

Ref	Qty	Description	EDP
15	3	Hexagon Nut	7606
16	1	Ring Washer	7596
18	3	Thread Roll (See Chart for Size & EDP)	
20	1	Stop Screw Body	7592
21	1	Stop Screw	7599
22	1	Hexagon Nut	7602
24	2	Set Screw (2/set)	7311
25	3	Washer	7673

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