

## RADIAL Thread Rolling

RSVP Radial rolling heads offer an ideal solution for producing very short threads with tight runout, rolling close to a shoulder or into an undercut. Due to the 3-roll action of the radial system, the component is well supported during the rolling process, even when threading the ends of long shafts. Since the rolling action is completed within one revolution of the rolls, cycle times are extremely short and in most cases, under 0.5 seconds.

Radial rolling heads are automatically reset after each threading pass. They are actuated by external means when positioned over the component to be rolled by use of the external trip lever on stationary heads, or an internal push rod on rotating heads.

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## RADIAL Thread Rolling Operation

Unlike the axial and tangential rolling systems, radial rolling does not require a controlled feed motion in order to produce a thread.

The RSVP RE style rolling head simply needs to be positioned over the part using the forward stroke of the machine. This may be a standard turret lathe, CNC machine or rotary transfer machine.

When the head is in position, the trip lever is actuated and the rolling process begins (fig. 2). The external trip can only be actuated when the head is stationary. For applications where the head is revolving, an internal trip must be actuated by a push rod mechanism through the shank (or flange) of the head.

The tripping of the head causes all 3 rolls to rotate under spring pressure until they contact the blank. At this point they pinch up against the part, and are driven round one full revolution. During this rotation of the rolls, their geometry effects a “squeezing down” in a radial direction and the thread is rapidly formed (fig. 3).

Once the rolls have completed the threading cycle, they are returned to the start position with their flats facing the threaded part. This allows the head to be retracted without damage to the thread. The head is now re-set and ready for the next cycle (fig. 4).

It is not advisable to trip the head without a blank in position as the rolls would not return to their start point. If a rolling pass is then attempted, the rolls will hit against the blank, damaging the rolls and possibly the head.

In automatic, un-manned cycles, it is advisable to operate some means of checking device, to ensure that the head is in the reset position before any attempt is made to roll a thread. The external trip lever can be actuated automatically or by

hand. For manual operation, a ball type handle can be attached to the trip lever which accepts an M5 x 0.8 thread. For automatic tripping, it is required that the external lever is brought up against a machine stop precisely at the point when the head reaches the desired rolling position. The head must not still be advancing forward after it is tripped.

### Rotating direction of spindle

Most conventional spindles run in a right-hand, or clockwise direction, so RE radial heads and rolls are primarily supplied for this condition. These standard, right hand heads should not be solely associated with right hand threads. Right and left hand threads can be produced on the same head; it is only the roll design that alters.

The standard shank style heads illustrated in this publication can be mounted in most lathe turrets and used stationary, in which case the component & spindle rotate in the conventional right hand direction.

When used in rotating mode, RSVP radial heads can be shank or flange mounted. The heads must then be tripped by an internal push rod that passes through the back of the head. Actuation is normally by mechanical, hydraulic or pneumatic means.

### Clamping of the component

The radial rolling action is completed in one revolution of the rolls which requires high momentary torque. This in turn imparts high loads on the part being rolled. It is imperative the work holding system is able to resist these high forces, and hydraulic clamping is usually preferred.

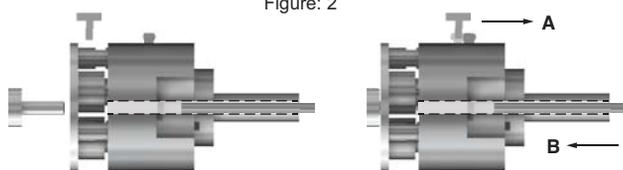
### Blank preparation

Ensuring the blank diameter is correct is an essential ingredient for trouble free thread rolling. As with other rolling methods, the blank diameter is initially set at or just below the pitch diameter of the thread. Successive rolling passes will then determine the best blank size by trial and error. Threads rolled by the radial method should not exhibit smooth, fully formed crests as this indicates over-rolling which will shorten roll life.

### Safety

Radial thread rolling combines high spindle speeds with extremely fast cycle times. Machinery should always be adequately guarded. If RSVP radial heads are to be fitted to manually operated lathes, then full eye protection should always be worn.

Figure: 2



A - External trip actuated on contacting fixed stop

B - Internal trip actuated by pushrod through shank or flange

Figure: 3

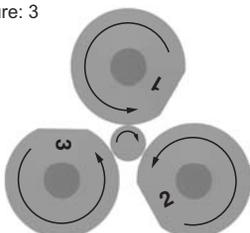
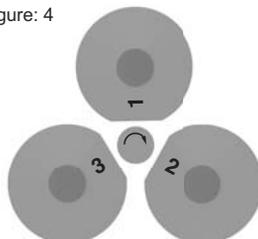


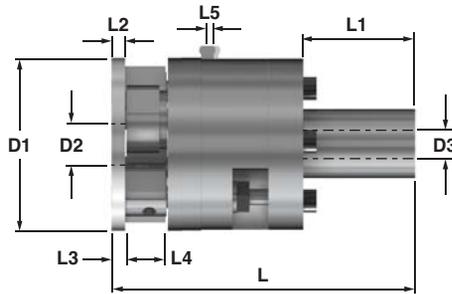
Figure: 4



## RE-8 Radial Head

Radial Thread Rolling Heads  
Standard Shank Style Illustrated  
Flange Mounting Also Available

EDP	Shank	EDP	Shank	EDP	Shank
0800E	3/4"	0800E-1.25	1-1/4"	0800E-25	25mm
0800E-1	1"	0800E-20	20mm	0800E-30	30mm



### RE-8 Radial Head Dimensions

#### Dimensions

Shank Ø Options	D1	D2	D3	L	L1	
3/4 - 1 - 1-1/4	inches	2.520	0.591	0.413	4.551	1.575
20 - 25 - 30	mm	64	15.0	10.5	115.6	40.0

#### Dimensions Continued

Shank Ø Options	L2	L3	L4max	L5	
3/4 - 1 - 1-1/4	inches	0.197	0.205	0.457	0.087
20 - 25 - 30	mm	5	5.2	11.6	2.2

L4 = Maximum width of rolls

L5 = Stroke to trip head

### The Following Thread Rolls May Be Ordered As Standard On The RE-8 Radial Head

1K EDP	ISO Metric Description
0803E	M3.5 x 0.5
0804E	M3.5 x 0.6
0805E	M4.0 x 0.7
0806E	M4.0 x 0.5
0807E	M5.0 x 0.8
0808E	M5.0 x 0.5
0809E	M6.0 x 1.0
0810E	M6.0 x 0.75
0811E	M6.0 x 0.5

1K EDP	ISO Metric (Continued) Description
0812E	M8.0 x 1.25
0813E	M8.0 x 1.0
0814E	M8.0 x 0.75
0815E	M8.0 x 0.5
0816E	M10.0 x 1.5
0817E	M10.0 x 1.25
0818E	M10.0 x 1.0
0819E	M10.0 x 0.75

1K EDP	Unified Fine UNF Description
0824E	5 x 40
0825E	5 x 44
0826E	6 x 32
0827E	6 x 40
0831E	8 x 32
0829E	8 x 36
0830E	10 x 24
0828E	10 x 32
0832E	12 x 24
0833E	12 x 28

1K EDP	Unified Fine UNF (Cont.) Description
0834E	1/4 x 20
0835E	1/4 x 28
0836E	1/4 x 32
0865E	5/16 x 18
0801E	5/16 x 24
0838E	5/16 x 32
0839E	3/8 x 16
0840E	3/8 x 24
0841E	3/8 x 32

1K EDP	National Pipe Thread NPT Description
0820E	1/16 x 27 NPT
0821E	1/8 x 27 NPT

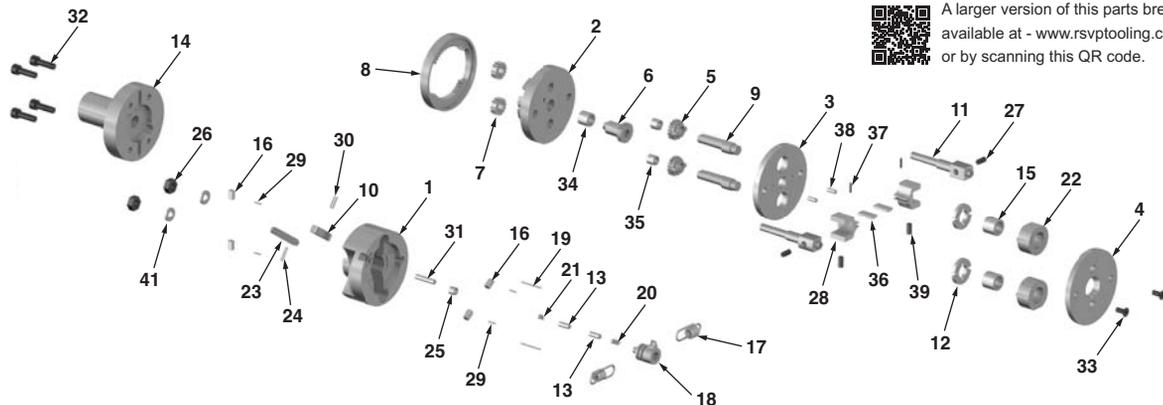
#### National Pipe Thread Dryseal NPTF

1K EDP	Description
0822E	1/16 x 27 NPTF
0823E	1/8 x 27 NPTF

The range of sizes shown can normally be safely rolled on the RE-8 head. For thread forms other than those listed, please contact our technical department.

Thread rolls are supplied as standard to suit right hand heads. This refers to the direction of rotation of the spindle and not the thread itself. Both right and left hand threads can be rolled using the same head; only the rolls are changed.

### Component Parts Breakdown



A larger version of this parts breakdown is available at - [www.rsptooling.com/prints.html](http://www.rsptooling.com/prints.html) or by scanning this QR code.

Ref	Qty	Description	EDP
1	1	Spring Housing	08-001
2	1	Drive Gear Plate	08-002
3	1	Cover Plate	08-003
4	1	Front Plate	08-004
5	2	Synchronizing Gear w/Bushing	08-005
6	1	Center Gear	08-006
7	2	Adjusting Gear	08-007
8	1	Gear Rim	08-008
9	2	Eccentric Spindle	08-009
10	1	External Trip Release Lever	08-010
11	2	Spacer Pin	08-011
12	2	Drive Plate	08-012
13	2	Coupling Pin	08-013
14	1	Shank 3/4	08-014
14A	1	Shank 1"	08-014A

Ref	Qty	Description	EDP
14B	1	Shank 1-1/4	08-014B
14C	1	Shank 20mm	08-014C
14D	1	Shank 25mm	08-014D
14E	1	Shank 30mm	08-014E
15	2	Bushing	08-015
16	4	Fitting Key	08-016
17	1	Tension Spring (2 pcs.)	08-017
18	1	Clutch Stop	08-018
19	2	Pin	08-019
20	1	Pressure Spring, Heavy	08-020
21	1	Pressure Spring, Light	08-021
22	2	Thread Roll (see chart for size and EDP)	
23	1	Internal Trip Release Lever	08-023
24	1	Pin	08-024
25	1	Bushing	08-025

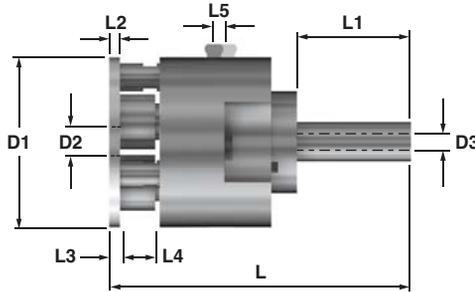
Ref	Qty	Description	EDP
26	2	Hex Nut	08-026
27	2	Set Screw	08-027
28	2	Guide with Carbide Blade	08-028
29	4	Stud	08-029
30	1	Pin	08-030
31	1	Pin	08-031
32	4	Cap Screw	08-032
33	2	Cap Screw	08-033
34	1	Bushing	08-034
35	2	Bushing - see Item 5	08-035
36	2	Carbide Blade - see Item 28	08-036
37	2	Pin	08-037
38	2	Pin	08-038
39	2	Set Screw	08-039
41	2	Washer	08-041

## RE-10 Radial Head

Radial Thread Rolling Heads  
Standard Shank Style Illustrated  
Flange Mounting Also Available

EDP	Shank	EDP	Shank	EDP	Shank	EDP	Shank
1000E	3/4"	1000E-1.25	1-1/4"	1000E-20	20mm	1000E-30	30mm
1000E-1	1"	1000E-1.5	1-1/2"	1000E-25	25mm	1000E-32	32mm

### RE-10 Radial Head Dimensions



#### Dimensions

Shank Ø Options	D1	D2	D3	L	L1
3/4 - 1 - 1-1/4	inches	3.937	1.024	0.492	6.480
20 - 25 - 30 - 32	mm	100	26.0	12.5	164.6

#### Dimensions Continued

Shank Ø Options	L2	L3	L4max	L5
3/4 - 1 - 1-1/4	inches	0.236	0.244	0.772
20 - 25 - 30 - 32	mm	6	6.2	20

L4 = Maximum width of rolls

L5 = Stroke to trip head

### The Following Thread Rolls May Be Ordered As Standard On The RE-10 Radial Head

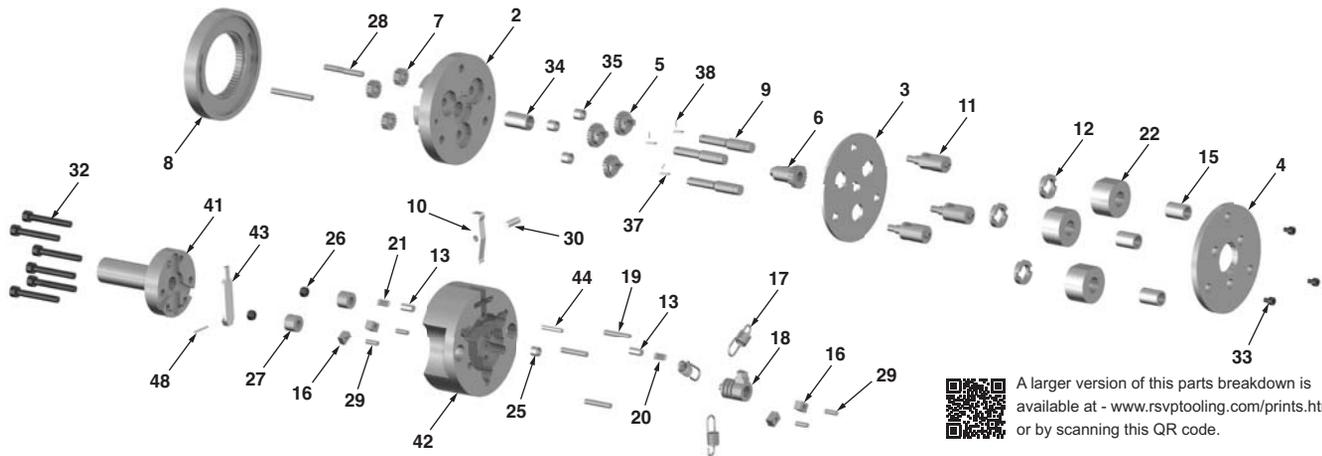
ISO Metric		ISO Metric (Continued)		Unified Fine UNF		Unified Fine UNF (Cont.)		National Pipe Thread NPT	
1K EDP	Description	1K EDP	Description	1K EDP	Description	1K EDP	Description	1K EDP	Description
1003E	M8.0 x 0.75	1009E	M12.0 x 1.0	1021E	5/16 x 20	1027E	7/16 x 28	1043E	1/16 x 27 NPT
1004E	M8.0 x 1.0	1010E	M12.0 x 1.25	1022E	5/16 x 24	1028E	1/2 x 20	1044E	1/8 x 27 NPT
1005E	M8.0 x 1.25	1011E	M12.0 x 1.5	1023E	5/16 x 32	1029E	1/2 x 28	1045E	1/4 x 18 NPT
1006E	M10.0 x 1.0	1012E	M14.0 x 1.25	1024E	3/8 x 16	1002E	9/16 x 18		
1007E	M10.0 x 1.25	1013E	M14.0 x 1.5	1025E	3/8 x 24	1030E	9/16 x 20		
1008E	M10.0 x 1.5	1014E	M14.0 x 1.0	1026E	3/8 x 32	1031E	9/16 x 24		
				1001E	7/16 x 20				

The range of sizes shown can normally be safely rolled on the RE-10 head. For thread forms other than those listed, please contact our technical department.

Thread rolls are supplied as standard to suit right hand heads. This refers to the direction of rotation of the spindle and not the thread itself. Both right and left hand threads can be rolled using the same head; only the rolls are changed.

National Pipe Thread Dryseal NPTF	
1K EDP	Description
1046E	1/16 x 27 NPTF
1047E	1/8 x 27 NPTF
1048E	1/4 x 18 NPTF

### Component Parts Breakdown



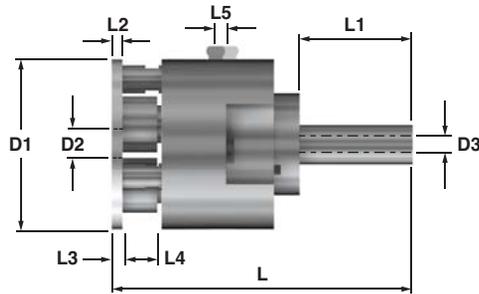
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Ref	Qty	Description	EDP	Ref	Qty	Description	EDP	Ref	Qty	Description	EDP
2	1	Drive Gear Plate	10-002	17	1	Tension Spring (3 pcs.)	10-017	34	1	Bushing	10-034
3	1	Cover Plate	10-003	18	1	Clutch Stop	10-018	35	3	Bushing - see Item 5	10-035
4	1	Front Plate	10-004	19	3	Pin	10-019	37	3	Fitting Key	10-037
5	3	Synchronizing Gear w/Bushing	10-005	20	1	Pressure Spring, Heavy	10-020	38	3	Pin	10-038
6	1	Center Gear	10-006	21	1	Pressure Spring, Light	10-021	41	1	Shank 3/4	10-041
7	3	Adjusting Gear	10-007	22	3	Thread Roll (see chart for size and EDP)		41A	1	Shank 1"	10-041A
8	1	Gear Rim	10-008	25	1	Bushing	10-025	41B	1	Shank 1-1/4	10-041B
9	3	Eccentric Spindle	10-009	26	2	Hex Nut	10-026	41C	1	Shank 20mm	10-041C
10	1	External Trip Release Lever	10-010	27	2	Washer	10-027	41D	1	Shank 25mm	10-041D
11	3	Spacer Pin	10-011	28	2	Stud	10-028	41E	1	Shank 30mm	10-041E
12	3	Drive Plate	10-012	29	4	Pin	10-029	41F	1	Shank 32mm	10-041F
13	2	Coupling Pin	10-013	30	1	Pin	10-030	42	1	Spring Housing	10-042
15	3	Bushing	10-015	32	6	Cap Screw	10-032	43	1	Internal Trip Release Lever	10-043
16	4	Fitting Key	10-016	33	3	Cap Screw	10-033	44	1	Pin	10-044
								48	1	Pin	10-048

## RE-13 Radial Head

Radial Thread Rolling Heads  
Standard Shank Style Illustrated  
Flange Mounting Also Available

EDP	Shank	EDP	Shank
1300E	1-1/2"	1300E-30	30mm
1300E-1.25	1-1/4"	1300E-40	40mm



### RE-13 Radial Head Dimensions

#### Dimensions

Shank Ø Options	D1	D2	D3	L	L1
1-1/4 - 1-1/2 inches	4.921	1.260	0.492	7.622	3.150
30 - 40 mm	125	32.0	12.5	193.6	80.0

#### Dimensions Continued

Shank Ø Options	L2	L3	L4max	L5
1-1/4 - 1-1/2 inches	0.315	0.323	0.968	0.118
30 - 40 mm	8	8.2	24.6	3

L4 = Maximum width of rolls  
L5 = Stroke to trip head

### The Following Thread Rolls May Be Ordered As Standard On The RE-13 Radial Head

ISO Metric	
1K EDP	Description
1303E	M10.0 x 0.75
1304E	M10.0 x 1.0
1305E	M10.0 x 1.25
1306E	M10.0 x 1.5
1307E	M12.0 x 1.0
1308E	M12.0 x 1.25
1309E	M12.0 x 1.5
1310E	M12.0 x 1.75

ISO Metric (Continued)	
1K EDP	Description
1311E	M14.0 x 1.0
1312E	M14.0 x 1.25
1323E	M14.0 x 1.5
1314E	M16.0 x 1.0
1315E	M16.0 x 1.5
1316E	M18.0 x 1.0
1317E	M18.0 x 1.5

Unified Fine UNF	
1K EDP	Description
1326E	7/16 x 14
1301E	7/16 x 20
1328E	7/16 x 28
1329E	1/2 x 13
1330E	1/2 x 20
1331E	1/2 x 28

Unified Fine UNF (Cont.)	
1K EDP	Description
1332E	9/16 x 18
1333E	9/16 x 20
1334E	9/16 x 24
1335E	5/8 x 18
1336E	5/8 x 24
1337E	11/16 x 24

National Pipe Thread NPT	
1K EDP	Description
1350E	1/8 x 27 NPT
1302E	1/4 x 18 NPT
1352E	3/8 x 18 NPT

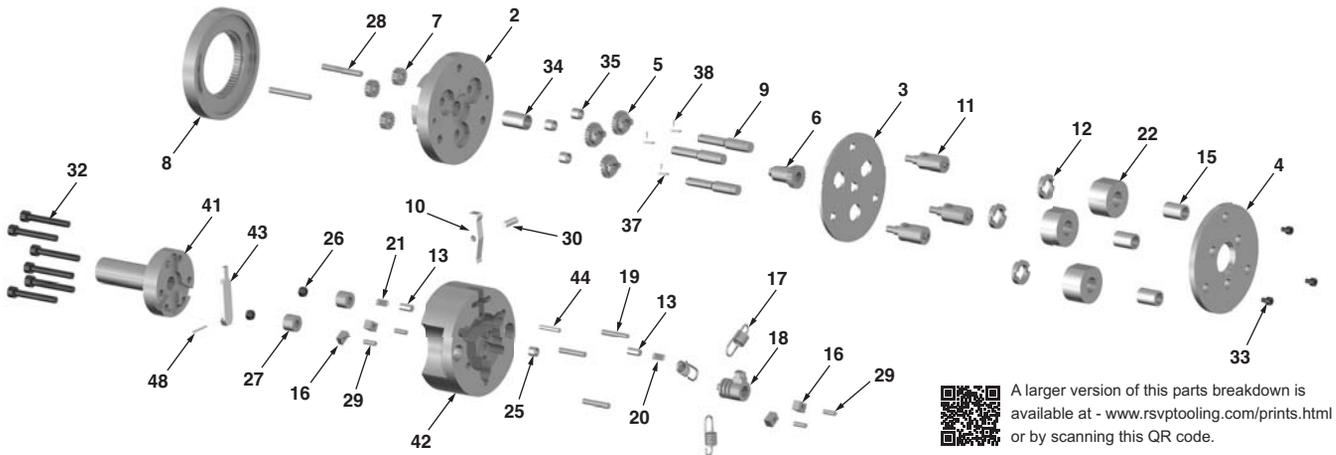
#### National Pipe Thread Dryseal NPTF

1K EDP	Description
1353E	1/8 x 27 NPTF
1354E	1/4 x 18 NPTF
1355E	3/8 x 18 NPTF

The range of sizes shown can normally be safely rolled on the RE-13 head. For thread forms other than those listed, please contact our technical department.

Thread rolls are supplied as standard to suit right hand heads. This refers to the direction of rotation of the spindle and not the thread itself. Both right and left hand threads can be rolled using the same head; only the rolls are changed.

### Component Parts Breakdown



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Ref	Qty	Description	EDP
2	1	Drive Gear Plate	13-002
3	1	Cover Plate	13-003
4	1	Front Plate	13-004
5	3	Synchronizing Gear w/Bushing	13-005
6	1	Center Gear	13-006
7	3	Adjusting Gear	13-007
8	1	Gear Rim	13-008
9	3	Eccentric Spindle	13-009
10	1	External Trip Release Lever	13-010
11	3	Spacer Pin	13-011
12	3	Drive Plate	13-012
13	2	Coupling Pin	10-013
15	3	Bushing	13-015

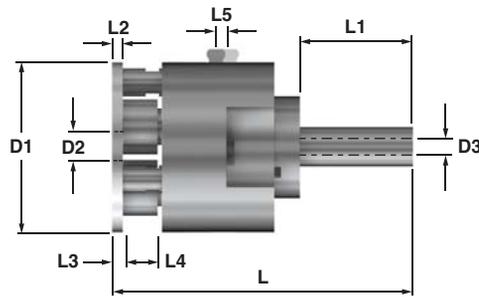
Ref	Qty	Description	EDP
16	4	Fitting Key	10-016
17	1	Tension Spring (3 pcs.)	13-017
18	1	Clutch Stop	13-018
19	3	Pin	10-019
20	1	Pressure Spring, Heavy	13-020
21	1	Pressure Spring, Light	13-021
22	3	Thread Roll (see chart for size and EDP)	
25	1	Bushing	10-025
26	2	Hex Nut	10-026
27	2	Washer	13-027
28	2	Stud	13-028
29	4	Pin	10-029
30	1	Pin	10-030

Ref	Qty	Description	EDP
32	6	Cap Screw	10-032
33	3	Cap Screw	13-033
34	1	Bushing	13-034
35	3	Bushing - see Item 5	13-035
37	3	Fitting Key	13-037
38	3	Pin	13-038
41	1	Shank 1-1/2	13-041
41A	1	Shank 1-1/4	13-041A
41B	1	Shank 30mm	13-041B
41C	1	Shank 40mm	13-041C
42	1	Spring Housing	13-042
43	1	Internal Trip Release Lever	13-043
44	1	Pin	10-044
48	1	Pin	13-048

## RE-16 Radial Head

Radial Thread Rolling Heads  
Standard Shank Style Illustrated  
Flange Mounting Also Available

EDP	Shank	EDP	Shank
1600E	1-1/2"	1600E-40	40mm
1600E-2	2"	1600E-50	50mm



### RE-16 Radial Head Dimensions

#### Dimensions

Shank Ø Options		D1	D2	D3	L	L1
1-1/2 - 2	inches	5.512	1.594	0.492	8.366	3.150
40 - 50	mm	140	40.5	12.5	212.5	80.0

#### Dimensions Continued

Shank Ø Options		L2	L3	L4max	L5
1-1/2 - 2	inches	0.394	0.402	1.165	0.173
40 - 50	mm	10	10.2	29.6	4.4

L4 = Maximum width of rolls  
L5 = Stroke to trip head

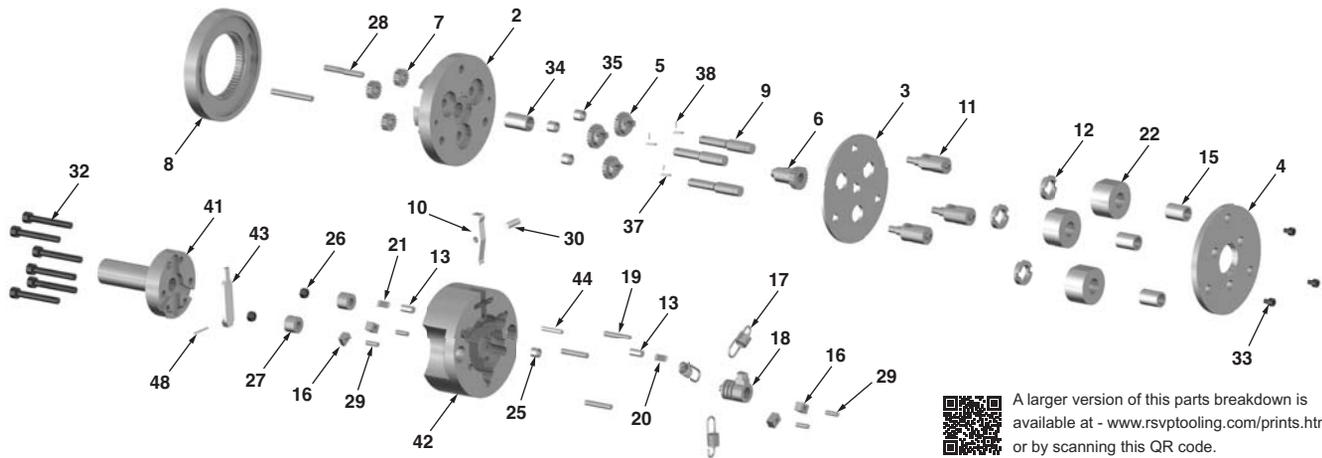
### The Following Thread Rolls May Be Ordered As Standard On The RE-16 Radial Head

ISO Metric		ISO Metric (Continued)		Unified Fine UNF		Unified Fine UNF (Cont.)		National Pipe Thread NPT	
1K EDP	Description	1K EDP	Description	1K EDP	Description	1K EDP	Description	1K EDP	Description
1602E	M12.0 x 1.0	1651E	M16.0 x 2.0	1669E	7/16 x 20	1641E	5/8 x 18	1662E	1/4 x 18 NPT
1603E	M12.0 x 1.25	1652E	M18.0 x 1.0	1633E	1/2 x 13	1642E	5/8 x 24	1663E	3/8 x 18 NPT
1604E	M12.0 x 1.5	1617E	M18.0 x 1.5	1634E	1/2 x 20	1643E	11/16 x 24	1601E	1/2 x 14 NPT
1605E	M12.0 x 1.75	1618E	M18.0 x 2.0	1635E	1/2 x 28	1644E	3/4 x 16		
1606E	M14.0 x 1.0	1619E	M20.0 x 1.0	1636E	9/16 x 12	1645E	3/4 x 20		
1607E	M14.0 x 1.25	1620E	M20.0 x 1.5	1637E	9/16 x 18	1665E	13/16 x 20		
1608E	M14.0 x 1.5	1621E	M20.0 x 2.0	1638E	9/16 x 20	1646E	7/8 x 14		
1610E	M14.0 x 2.0	1622E	M22.0 x 1.0	1639E	9/16 x 24	1647E	7/8 x 20		
1650E	M16.0 x 1.0	1623E	M22.0 x 1.5	1640E	5/8 x 11				
1614E	M16.0 x 1.5	1624E	M22.0 x 2.0						

The range of sizes shown can normally be safely rolled on the RE-16 head. For thread forms other than those listed, please contact our technical department.

Thread rolls are supplied as standard to suit right hand heads. This refers to the direction of rotation of the spindle and not the thread itself. Both right and left hand threads can be rolled using the same head; only the rolls are changed.

### Component Parts Breakdown



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Ref	Qty	Description	EDP
2	1	Drive Gear Plate	16-002
3	1	Cover Plate	16-003
4	1	Front Plate	16-004
5	3	Synchronizing Gear w/Bushing	16-005
6	1	Center Gear	16-006
7	3	Adjusting Gear	16-007
8	1	Gear Rim	16-008
9	3	Eccentric Spindle	16-009
10	1	External Trip Release Lever	16-010
11	3	Spacer Pin	16-011
12	3	Drive Plate	16-012
13	2	Coupling Pin	16-013
15	3	Bushing	16-015

Ref	Qty	Description	EDP
16	4	Fitting Key	16-016
17	1	Tension Spring (3 pcs.)	16-017
18	1	Clutch Stop	16-018
19	3	Pin	16-019
20	1	Pressure Spring, Heavy	16-020
21	1	Pressure Spring, Light	16-021
22	3	Thread Roll (see chart for size and EDP)	
25	1	Bushing	16-025
26	2	Hex Nut	16-026
27	2	Washer	16-027
28	2	Stud	16-028
29	4	Pin	10-029
30	1	Pin	16-030

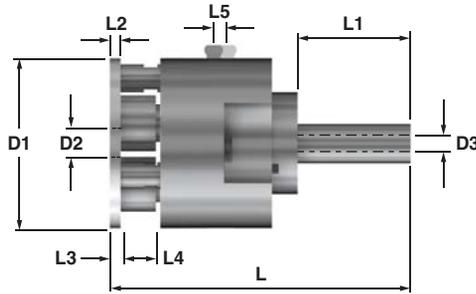
Ref	Qty	Description	EDP
32	6	Cap Screw	16-032
33	3	Cap Screw	16-033
34	1	Bushing	16-034
35	3	Bushing - see Item 5	16-035
37	3	Fitting Key	16-037
38	3	Pin	16-038
41	1	Shank 1-1/2	16-041
41A	1	Shank 2"	16-041A
41B	1	Shank 40mm	16-041B
41C	1	Shank 50mm	16-041C
42	1	Spring Housing	16-042
43	1	Internal Trip Release Lever	16-043
44	1	Pin	16-044
48	1	Pin	13-048

## RE-23 Radial Head

EDP	Shank	EDP	Shank
2300E	2"	2300E-50	50mm
2300E-2.5	2-1/2"	2300E-60	60mm

**Radial Thread Rolling Heads**  
Standard Shank Style Illustrated  
Flange Mounting Also Available

### RE-23 Radial Head Dimensions



#### Dimensions

Shank Ø Options		D1	D2	D3	L	L1
2 - 2-1/2	inches	6.693	1.968	0.492	10.295	3.937
50 - 60	mm	170	50.0	12.5	261.5	100.0

#### Dimensions Continued

Shank Ø Options		L2	L3	L4max	L5
2 - 2-1/2	inches	0.512	0.520	1.362	0.177
50 - 60	mm	13	13.2	34.6	4.5

L4 = Maximum width of rolls  
L5 = Stroke to trip head

### The Following Thread Rolls May Be Ordered As Standard On The RE-23 Radial Head

ISO Metric	
1K EDP	Description
2301E	M16.0 x 1.0
2302E	M16.0 x 1.5
2303E	M16.0 x 2.0
2304E	M18.0 x 1.0
2305E	M18.0 x 1.25
2306E	M18.0 x 1.5
2307E	M18.0 x 2.0
2308E	M18.0 x 2.5
2309E	M20.0 x 1.0
2310E	M20.0 x 1.5
2311E	M20.0 x 2.0
2312E	M20.0 x 2.5
2313E	M22.0 x 1.0

ISO Metric (Continued)	
1K EDP	Description
2314E	M22.0 x 1.5
2315E	M22.0 x 2.0
2316E	M22.0 x 2.5
2317E	M24.0 x 1.0
2318E	M24.0 x 1.5
2319E	M24.0 x 2.0
2320E	M26.0 x 1.5
2321E	M27.0 x 1.5
2322E	M27.0 x 2.0
2323E	M28.0 x 1.5
2324E	M30.0 x 1.5
2325E	M30.0 x 2.0

Unified Fine UNF	
1K EDP	Description
2334E	5/8 x 11
2335E	5/8 x 18
2336E	5/8 x 24
2337E	11/16 x 24
2338E	3/4 x 10
2339E	3/4 x 16
2340E	3/4 x 20
2341E	13/16 x 20
2370E	7/8 x 14

Unified Fine UNF (Cont.)	
1K EDP	Description
2369E	7/8 x 20
2344E	15/16 x 20
2345E	1 x 12
2871E	1 x 20
2347E	1-1/16 x 18
2348E	1-1/8 x 12
2349E	1-1/8 x 18
2350E	1-3/16 x 18

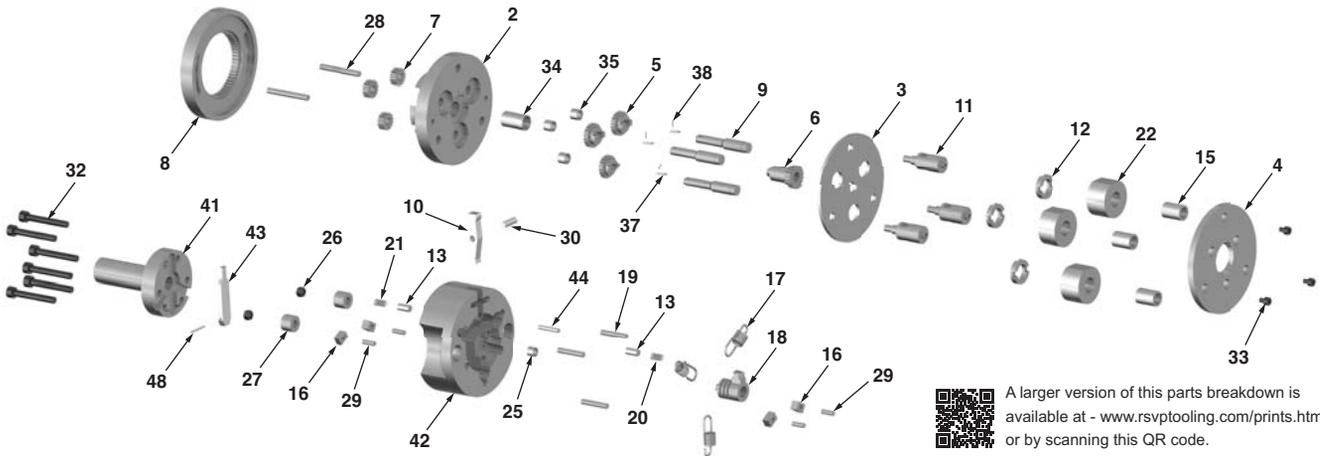
National Pipe Thread NPT	
1K EDP	Description
2363E	3/8 x 18 NPT
2364E	1/2 x 14 NPT
2365E	3/4 x 14 NPT

National Pipe Thread Dryseal NPTF	
1K EDP	Description
2366E	3/8 x 18 NPTF
2367E	1/2 x 14 NPTF
2368E	3/4 x 14 NPTF

Thread rolls are supplied as standard to suit right hand heads. This refers to the direction of rotation of the spindle and not the thread itself. Both right and left hand threads can be rolled using the same head; only the rolls are changed.

The range of sizes shown can normally be safely rolled on the RE-23 head. For thread forms other than those listed, please contact our technical department.

### 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
2	1	Drive Gear Plate	23-002
3	1	Cover Plate	23-003
4	1	Front Plate	23-004
5	3	Synchronizing Gear w/Bushing	23-005
6	1	Center Gear	23-006
7	3	Adjusting Gear	23-007
8	1	Gear Rim	23-008
9	3	Eccentric Spindle	23-009
10	1	External Trip Release Lever	23-010
11	3	Spacer Pin	23-011
12	3	Drive Plate	23-012
13	2	Coupling Pin	23-013
15	3	Bushing	23-015

Ref	Qty	Description	EDP
16	4	Fitting Key	23-016
17	1	Tension Spring (3 pcs.)	23-017
18	1	Clutch Stop	23-018
19	3	Pin	23-019
20	1	Pressure Spring, Heavy	23-020
21	1	Pressure Spring, Light	23-021
22	3	Thread Roll (see chart for size and EDP)	
25	1	Bushing	16-025
26	2	Hex Nut	16-026
27	2	Washer	16-027
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Ref	Qty	Description	EDP
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