

List of 50 pairs of thread rolls included with Herbert S10 – 10 ton Hydraulic Thread Rolling Machine

All measurements are in millimetres unless stated otherwise

All the thread rolls listed below are suitable for regrinding to other sizes.

Size:	Pitch	O.D.	Width	Material of rolls
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Metric sizes

M 3	0.50	120	25	M2
M 5	0.80	125	57	M2
M 5	0.50	125	47	D2
M 6	1.00	130	57	D2
M 8	1.25	130	57	M2
M10	1.25	127	57	M2
M10	1.50	123	57	M2
M10	1.50	124	78	M2
M12	1.25	130	57	M2
M12	1.75	120	57	M2
M14	1.50	127	57	M2
M16	2.00	130	57	M2
M16	1.50	117	57	M2
M20	1.50	130	57	M2
M20	2.50	125	50	M2
M23	1.50	127	57	M2
M24	2.00	130	57	M2

Imperial sizes

UNF

6	1 UNJF	120	35	M2
8	32 UN	120	57	M2
10	32 UNJF	130	57	M2
10	24 UNS	130	30	M2
¼"	28 UNF	127	57	D2
5/16"	24 UNJF	125	60	D2
7/16"	20 UNJF	130	57	M2
½"	20 UNF	127	50	D2
½"	20 UNF	127	85	D2
3/8"	20 UNF	127	54	M2
3/8"	24 UNF	130	55	M2
9/16"	16 UNF	127	57	BM2
¾"	16 UNJF	125	57	M2
1"	12 UNF	120	50	D2

UNC

¼"	20 UNC	120	45	D2
5/16"	18 UNC	130	57	M2
3/8"	16 UNC	130	57	M2
7/16"	14 UNC	125	57	M2
½"	13 UNC	130	63	M2
5/8"	11 UNC	125	57	M2
7/8"	9 UNC	120	50	D2

BSW (Whitworth)

¼"	28 BSW	122	20	D2
5/16"	28 BSW	115	25	D2
7/16"	20 BSW	118	25	D2
½"	12 BSW	120	57	D2

BSF (British Standard Fine)

¼"	26 BSF	117	55	D2
5/16"	22 BSF	125	57	BM2
7/16"	18 BSF	120	47	D2
9/16"	16 BSF	105	55	D2
7/8"	11 BSF	120	57	M2

BA

2	BA	117	57	D2
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BSP (British Standard Pipe)

¼" -	19 BSP	130	57	M2
½" -	14 BSP	115	55	D2

Price guide

One pair of new thread rolls 125mm o.d. x 55mm wide made from D2 steel: £350.00

One pair of new thread rolls 125mm o.d. x 55mm wide made from M2 (HSS) steel: £450.00

Estimated cost of regrinding one pair of above rolls: approx £125.00

N.B. The types & sizes on the above list may not be 100% accurate.