

List of 70 pairs of thread rolls for use with 10 ton capacity thread rolling machines

All measurements are 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

Metric sizes				

M 4	0.70	125	30	D2
M 6	1.00	110	57	D2
M 8	1.25	122	57	D2
M 8	0.75	110	57	D2
M 8	1.25	115	63	M2
MJ 8	1.25	115	57	M2
M 9	1.00	120	30	D2
M10	1.50	115	57	D2
M10	1.50	125	85	D2
M21	1.50 - LH	118	50	M2
Imperial sizes				

UNF				

6	32 UNJF	130	57	M2
6	40 UNJF	120	57	M2
10	32 UNJF	130	57	M2
5/16"	24 UNF	125	57	D2
5/16"	24 UNJF	130	57	M2
3/8"	20 UNF	127	54	M2
3/8"	24 UNJF	127	55	M2
7/16"	20 UNJF	130	57	M2
7/16"	32 UNJF	130	57	M2
½"	28 UNJEF	130	57	M2
½"	20 UNF (LH)	127	57	M2
9/16"	18 UNJF	127	57	M2
5/8"	18 UNJF	130	57	D2 (2 pairs)
5/8"	24 UNJF	120	57	M2
¾"	20 UNJF	125	45	D2
¾"	20 UNEF	127	57	M2
7/8"	20 UNF	120	50	D2
1"	12 UNF	120	50	D2
1 1/8"	12 UNJF	100	57	D2
UNC				

2	56 UNC	122	20	D2
2	56 UNC	130	57	M2

4	40 UNC	127	57	M2
7/16"	14 UNC	125	57	D2
5/8"	11 UNJC	125	55	D2
3/4"	10 UNC	120	57	D2

BSW (Whitworth)

1/4"	20 BSW	125	57	M2
5/16"	18 BSW	110	57	D2
3/8"	24 BSW	120	57	D2
3/8"	24 BSW	125	57	D2
7/16"	20 BSW	110	25	D2
7/16"	20 BSW	125	55	D2
7/16"	24 BSW	122	38	D2
7/16"	24 BSW	123	40	D2
1/2"	12 BSW	120	85	D2
3/4"	10 BSW	100	57	D2
3/4"	16 BSW	123	57	D2
7/8"	11 BSW	110	57	D2

BSF (British Standard Fine)

1/4"	26 BSF	127	57	D2
5/16"	22 BSF	110	52	D2
3/8"	19 BSF	100	55	D2
3/8"	19 BSF	108	57	D2
3/8"	19 BSF	110	45	D2
3/8"	18 BSF	125	57	D2
1/2"	16 BSF	125	57	D2
5/8"	14 BSF	100	57	D2
11/16"	14 BSF	127	57	M2
3/4"	BSF	120	70	D2
7/8"	11 BSF	105	57	D2
7/8"	11 BSF (LH)	120	57	D2

BSP (British Standard Pipe)

1/4"	19 BSP	120	20	D2
1/4"	19 BSP	130	57	M2
3/8"	19 BSP	115	57	D2 (2 pairs)
1/2"	14 BSP	120	50	D2
1/2"	14 BSP	115	50	D2
3/4"	14 BSP	125	57	D2
1"	11 BSP	95	70	D2

BA

0	BA	120	20	D2
5	BA	127	57	D2

Other

3/8" 26 CEL (LH) 125 57 M2

Knurling rolls

Straight knurl 2.00 125 20 D2
Straight knurl .0346" 125 30 D2
Straight knurl - 125 25 D2
Straight knurl ½ x 36 125 57 D2
Straight knurl 3/8 x 36 130 45 D2

Price guide:

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

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

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

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