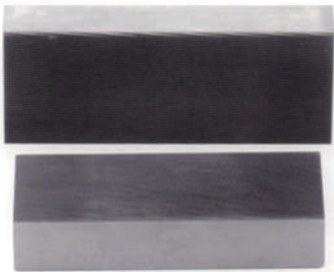
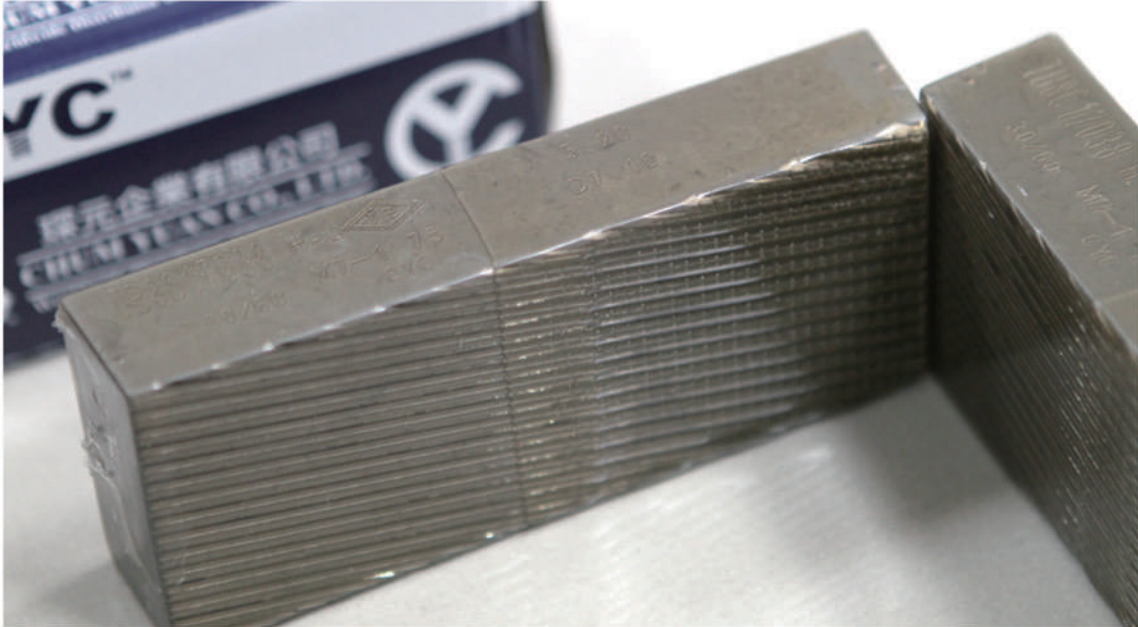


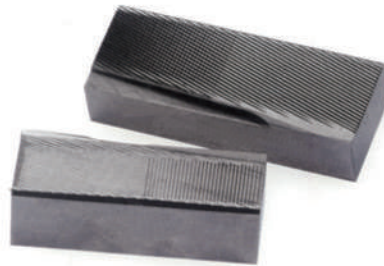


## 7. THREAD ROLLING FLAT DIE

### Types of Thread Rolling Dies



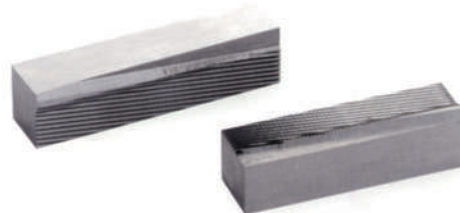
Machine Thread



Tapping Thread



Taptite Thread



Stainless Thread Point

## Common Thread Rolling Flat Die Size

| Machine Size | Thickness (S) | Height (H)                                    | Fixed Die Length (L1) | Moving Die Length (L2) |
|--------------|---------------|---|-----------------------|------------------------|
| 0            | 19            | 25  | 51                    | 65                     |
| 3/16         | 25            | 25 / 40 / 55 / 65                             | 78                    | 89                     |
| 1/4          | 25            | 25 / 40 / 45 / 55 / 65 / 80                   | 100                   | 115                    |
| 5/16         | 25            | 25 / 40 / 45 / 55 / 65 / 80 / 105 / 130 / 155 | 127                   | 140                    |
| 3/8          | 25            | 25 / 40 / 45 / 55 / 65 / 80 / 105 / 130 / 155 | 150                   | 165                    |
| 1/2          | 35            | 55 / 65 / 80 / 105 / 130 / 155                | 190                   | 215                    |
| 3/4          | 38            | 55 / 65 / 80 / 105 / 130 / 155                | 230                   | 265                    |
| 7/8          | 42            | 55 / 80 / 105 / 155                           | 290                   | 310                    |
| 1"           | 50            | 80 / 105 / 155                                | 380                   | 420                    |
| 003          | 15            | 20  | 45                    | 55                     |
| 004          | 20            | 25  | 65                    | 80                     |
| 4R           | 20            | 25  | 60                    | 70                     |
| 5R           | 20            | 25  | 65                    | 75                     |
| 6R           | 25            | 25 / 40 / 55 / 65                             | 90                    | 105                    |
| 8R           | 25            | 25 / 40 / 55 / 65 / 80                        | 108                   | 127                    |
| DR125        | 20.6          | 25 / 32 / 40                                  | 73.5(θ:5°)            | 76.2(θ:5°)             |
| DR200        | 20.6          | 25 / 32 / 40 / 45 / 55                        | 92.5(θ:5°)            | 105.2(θ:5°)            |
| DR250        | 23.8          | 25 / 32 / 40 / 45 / 55                        | 112.2(θ:5°)           | 131.2(θ:5°)            |

## Special Thread Rolling Flat Die Size

| Machine Size | Thickness (S) | Height (H)                        | Fixed Die Length (L1) | Moving Die Length (L2) |
|--------------|---------------|-----------------------------------|-----------------------|------------------------|
| TR0          | 20            | 20 / 25 / 32                      | 58                    | 66                     |
| TR1          | 25            | 25 / 32 / 40 / 45 / 55            | 85                    | 95                     |
| TR2          | 30            | 32 / 40 / 45 / 55 / 65 / 80 / 105 | 115                   | 130                    |
| TR3          | 35            | 32 / 40 / 45 / 55 / 65 / 80 / 105 | 130                   | 150                    |
| TR4          | 35            | 32 / 40 / 45 / 55 / 65 / 80 / 105 | 150                   | 170                    |
| TR5          | 40            | 32 / 40 / 45 / 55 / 65 / 80 / 105 | 150                   | 170                    |
| TR6          | 50            | 55 / 65 / 80 / 105                | 190                   | 210                    |