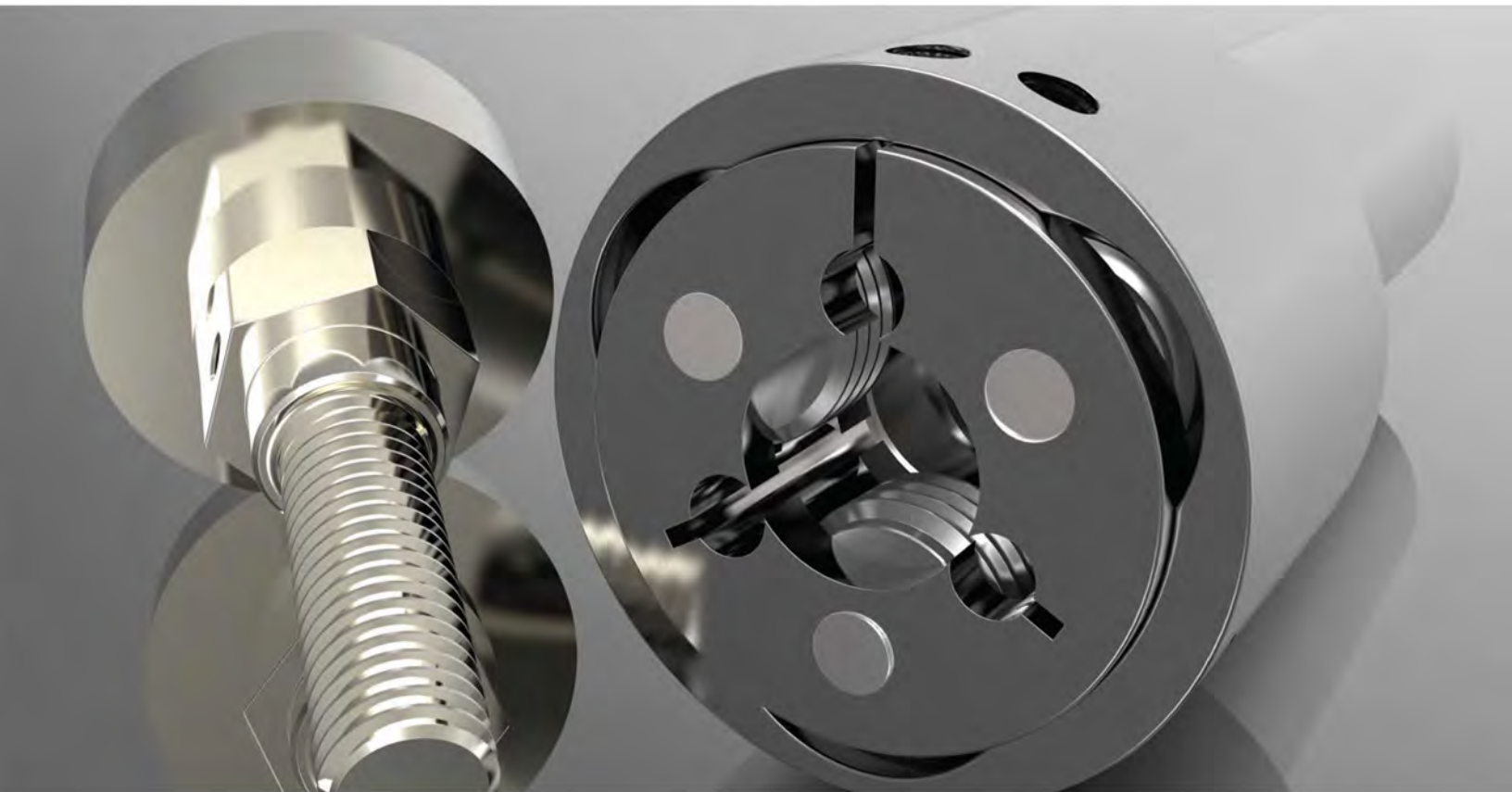




FIRST in Threading Tools

CNC EZ Roller



Any CNC – Lathe, Turning Center, Machining Center, Swiss Automatic
Uses Built-in CNC Control Tap Routines
Materials from Aluminum to Titanium

CNC EZ Roller Catalog

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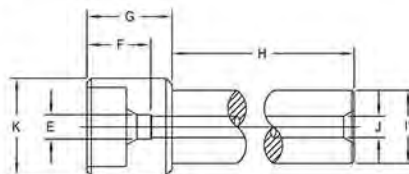




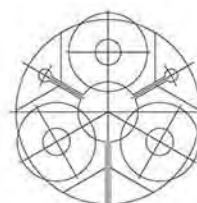
Landis Solutions LLC offers a line of thread rolling tools designed especially for CNC style machines. The Landis® CNC EZ Roller™ thread rolling tools offer a low cost, small tool envelope, alternative to the conventional opening style rolling heads. When married to CNC machines that run a Rigid or Synchronous tapping cycle to roll-on/roll-off, savings can be achieved by eliminating the extraneous moves necessary to reset the rolling head. Six sizes of CNC EZ Roller™ tools cover a standard thread range of #0 through 1-1/4" (M1.6 through M30) diameters. They can be furnished with plain cylindrical shanks in both inch and metric diameters, or other mountings available include CAT, BT, VDI, Morse Taper and Tap drive. Thread rolls are available in several die materials and thread leads to suit the application.



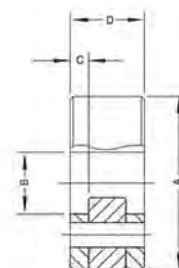
Die Holder



Die Body



Front View



Side View

#1.5 Tooling Dimensions

Dimensions	inches	mm
A	0.812	20.61
B	see thread size chart	
C	0.093	2.38
D	0.406	10.32
E	0.250	6.50
F	0.656	16.50
G	0.875	22.50
H	2.000	50.00
I*	0.750	20.00
J	0.218	6.00
K	0.997	26.00

Components

Part #	Description	Quantity
L0B066961	Die Holder - Inch	1
L0C143453	Die Holder - Metric	1
L0E059614	Thread Roll Shaft	3
L0E069852	Thread Roll Shaft - "A", "AA", "B", "BF"	3
L0E062986	Adjusting Screw	1
L0E143454	Adjusting Screw	1
L17SX#6X12	Adjusting and Retaining Set Screw	4
LFA001056	Adjusting and Retaining Set Screw	4
LGD000300	Socket Screw Wrench - 1/16	1
LGD001105	Hex Wrench - 2mm	1

Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
#0-80 UNF	LSB143535	L0B063650	A - 4°-35'	3.2	L0C063633
	LSB141819			0.125	
#1-64 UNC	LSB143536	L0B063645	AA - 4°-25'	4	L0C065380
	LSB141815			0.156	
#1-72 UNF	LSB143536	L0B063645	AA - 4°-25'	4	L0C063644
	LSB141815			0.156	
#2-56 UNC	LSB143537	L0B063312	B - 4°-25'	5.2	L0C063315
	LSB141817			0.203	
#2-64 UNF	LSB143538	L0B118675	BF - 3°-45'	5.2	L0C063314
	LSB141820			0.203	
#3-48 UNC	LSB143537	L0C063312	B - 4°-25'	5.2	L0C063317
	LSB141816			0.203	
#3-56 UNF	LSB143538	L0B118675	BF - 3°-45'	5.2	L0C063316
	LSB141820			0.203	

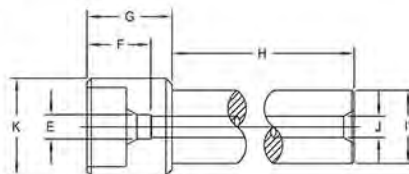


#1.5 Thread Rolls

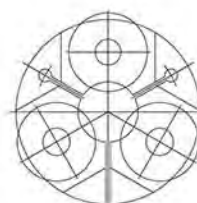
Thread Size	Sub- Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
#4-40 UNC	LSB143539	LOB059611	C - 4°-45'	6.7	LOC059613
	LSB141817			0.266	
#4-48 UNF	LSB143540	LOB118676	CF - 4°-0'	6.7	LOC063318
	LSB141821			0.266	
#5-40 UNC	LSB143539	LOB059611	C - 4°-45'	6.7	LOC063320
	LSB141817			0.266	
#5-44 UNF	LSB143540	LOB118676	CF - 4°-0'	6.7	LOC063319
	LSB141821			0.266	
#6-32 UNC	LSB143539	LOB059611	C - 4°-45'	6.7	LOC059612
	LSB141817			0.266	
#6-40 UNF	LSB143540	LOB118676	CF - 4°-0'	6.7	LOC063321
	LSB141821			0.266	
#8-32 UNC	LSB143541	LOB059624	D - 4°-45'	8	LOC063323
	LSB141818			0.312	
#8-36 UNF	LSB143542	LOB109833	DF - 3°-30'	8	LOC063322
	LSB141822			0.312	
#10-24 UNC	LSB143541	LOB059624	D - 4°-45'	8	LOC063324
	LSB141818			0.312	
#10-32 UNF	LSB143542	LOB109833	DF - 3°-30'	8	LOC062473
	LSB141822			0.312	
#12-24 UNC	LSB143541	LOB059624	D - 4°-45'	8	LOC063332
	LSB141818			0.312	
#12-28 UNF	LSB143542	LOB109833	DF - 3°-30'	8	LOC063348
	LSB141822			0.312	
M1.6 X .35 ISO	LSB143535	LOB063650	A - 4°-35'	3.2	LOC141599
	LSB141819			0.125	
M1.8 X .35 ISO	LSB143536	LOB063645	AA - 4°-25'	4	LOC141600
	LSB141815			0.156	
M2 X .4 ISO	LSB143537	LOB063312	B - 4°-25'	5.2	LOC065218
	LSB141816			0.203	
M2.2 X .45 ISO	LSB143537	LOB063312	B - 4°-25'	5.2	LOC141608
	LSB141816			0.203	
M2.5 X .45 ISO	LSB143538	LOB118675	BF - 3°-45'	5.2	LOC121521
	LSB141820			0.203	
M3 X .5 ISO	LSB143543	LOB106668	CX - 3°-30'	6.7	LOC063998
	LSB141823			0.266	
M3.5 X .6 ISO	LSB143543	LOB106668	CX - 3°-30'	6.7	LOC065953
	LSB141823			0.266	
M4 X .7 ISO	LSB143543	LOB106668	CX - 3°-30'	6.7	LOC064998
	LSB141823			0.266	
M4.5 X .75 ISO	LSB143542	LOB109833	DF - 3°-30'	8	LOC115099
	LSB141822			0.312	
M5 X .8 ISO	LSB143542	LOB109833	DF - 3°-30'	8	LOC065200
	LSB141822			0.312	



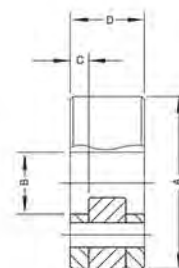
Die Holder



Die Body



Front View



Side View

#3 Tooling Dimensions

Dimensions	inches	mm
A	1.311	33.30
B	see thread size chart	
C	0.125	3.17
D	0.562	14.28
E	0.531	13.50
F	0.937	24.00
G	1.125	29.00
H	2.500	63.50
I*	1.000	25.00
J	0.406	10.50
K	1.622	42.00

Components

Part #	Description	Quantity
L0C066960	Die Holder - Inch	1
L0C143455	Die Holder - Metric	1
L0E062987	Thread Roll Shaft	3
L17SFX#10X25	Adjusting and Retaining Set Screw	5
LFA001057	Adjusting and Retaining Set Screw	5
LGD000302	Socket Screw Wrench - 3/32	1
LGD001106	Hex Wrench - 2.5mm	1

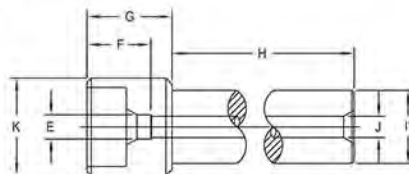
Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
#8 - 32 UNC	LSB143573	L0B141720	FX - 4°-0'	12	L0B141721
	LSB142532			0.468	
#10 - 24 UNC	LSB143544	L0B062984	F - 4°-45'	12	L0C118886
	LSB141824			0.468	
#10 - 32 UNF	LSB143545	L0B129458	FX - 3°-30'	12	L0B122271
	LSB141828			0.468	
#12 - 24 UNC	LSB143573	L0B141720	FX - 4°-0'	12	L0B140426
	LSB142532			0.468	
#12 - 28 UNF	LSB143545	L0B129458	FX - 3°-30'	12	L0B063313
	LSB141828			0.468	
1/4 - 20 UNC	LSB143544	L0B062984	F - 4°-45'	12	L0B063326
	LSB141824			0.468	
1/4 - 28 UNF	LSB143546	L0B068825	FF - 3°-0'	12	L0B063325
	LSB141826			0.468	



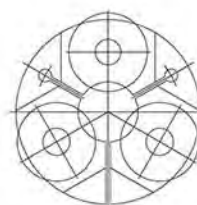
Thread Size	Sub- Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
5/16 - 18 UNC	LSB143547	LOB062988	G - 3°-45'	14	LOB063328
	LSB141825			0.547	
5/16 - 24 UNF	LSB143548	LOB109834	GF - 2°-45'	14	LOB063327
	LSB141827			0.547	
3/8 - 16 UNC	LSB143547	LOB062988	G - 3°-45'	14	LOB063330
	LSB141825			0.547	
3/8 - 24 UNF	LSB143548	LOB109834	GF - 2°-45'	14	LOB063329
	LSB141827			0.547	
M5 x 0.8	LSB143545	LOB129458	FX - 3°-30'	12	LOB141885
	LSB141828			0.468	
M6 x 1.0	LSB143545	LOB129458	FX - 3°-30'	12	LOB064254
	LSB141828			0.468	
M7 x 1.0	LSB143546	LOB068825	FF - 3°-0'	12	LOB064965
	LSB141826			0.468	
M8 x 1.0	LSB143548	LOB109834	GF - 2°-45'	14	LOB059144
	LSB141827			0.547	
M8 x 1.25	LSB143549	LOB141511	GX - 3°-15'	14	LOB064966
	LSB141829			0.547	
M10 x 1.25	LSB143548	LOB109834	GF - 2°-45'	14	LOB059145
	LSB141827			0.547	
M10 x 1.5	LSB143549	LOB141511	GX - 3°-15'	14	LOB064270
	LSB141829			0.547	



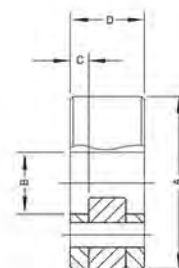
Die Holder



Die Body



Front View



Side View

#3.5 Tooling Dimensions

Dimensions	inches	mm
A	2.687	68.26
B	see thread size chart	
C	0.188	4.76
D	1.125	28.58
E	--	--
F	Thru Bore	
G	1.375	35.00
H	2.500	63.50
I*	1.000	25.00
J	0.532	13.50
K	3.250	83.00

Components

Part #	Description	Quantity
L0B142294	Die Holder - Inch	1
L0B143456	Die Holder - Metric	1
L0D142295	Thread Roll Shaft	3
LFA000974	Adjusting and Retaining Set Screw	5
LFA001058	Adjusting and Retaining Set Screw	5
LGD000323	Socket Screw Wrench - 1/8	1
LGD001107	Hex Wrench - 3mm	1

Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
1/4 - 20 UNC	LSB143551	L0B142296	T - 4°-15'	15.1	L0B142326
	LSB142315			0.593	
1/4 - 28 UNF	LSB143552	L0B142299	TF - 2°-40'	15.1	L0B142328
	LSB142319			0.593	
5/16 - 18 UNC	LSB143553	L0B142297	U - 3°-20'	22.6	L0B118808
	LSB142317			0.89	
5/16 - 24 UNF	LSB143554	L0B142300	UF - 2°-40'	22.6	L0B118812
	LSB142320			0.89	
3/8 - 16 UNC	LSB143555	L0B142298	V - 3°-10'	22.6	L0B118809
	LSB142318			0.89	
3/8 - 24 UNF	LSB143556	L0B142301	VF - 2°-0'	22.6	L0B118813
	LSB142321			0.89	

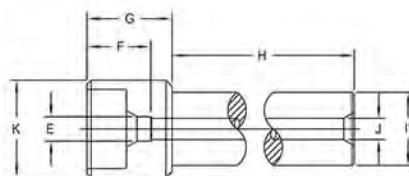


#3.5 Thread Rolls

Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch			mm inch	
7/16 - 14 UNC	LSB143555	LOB142298	V - 3°-10'	22.6	LOB118810
	LSB142318			0.89	
7/16 - 20 UNF	LSB143556	LOB142301	VF - 2°-0'	22.6	LOB118814
	LSB142321			0.89	
1/2 - 13 UNC	LSB143555	LOB142298	V - 3°-10'	22.6	LOB118853
	LSB142318			0.89	
1/2 - 20 UNF	LSB143556	LOB142301	VF - 2°-0'	22.6	LOB140479
	LSB142321			0.89	
M6 x 1.0	LSB143557	LOB142302	TX - 3°-20'	15.1	LOB142330
	LSB142316			0.593	
M6 X 0.75	LSB143552	LOB142299	TF - 2°-40'	15.1	LOB142332
	LSB142319			0.593	
M7 x 1.0	LSB143553	LOB142297	U - 3°-20'	22.6	LOB121074
	LSB142317			0.89	
M8 x 1.0	LSB143554	LOB142300	UF - 2°-40'	22.6	LOB140480
	LSB142320			0.89	
M8 x 1.25	LSB143553	LOB142297	U - 3°-20'	22.6	LOB121075
	LSB142317			0.89	
M10 x 1.0	LSB143556	LOB142301	VF - 2°-0'	22.6	LOB140481
	LSB142321			0.89	
M10 x 1.5	LSB143555	LOB142298	V - 3°-10'	22.6	LOB119706
	LSB142318			0.89	
M12 X 1.0	LSB143556	LOB142301	VF - 2°-0'	22.6	LOB142274
	LSB142321			0.89	
M12 x 1.75	LSB143555	LOB142298	V - 3°-10'	22.6	LOB121076
	LSB142318			0.89	



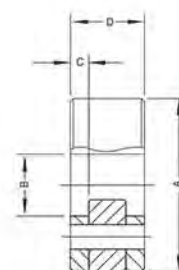
Die Holder



Die Body



Front View



Side View

#5 Tooling Dimensions		
Dimensions	inches	mm
A	3.375	85.73
B	see thread size chart	
C	0.188	4.76
D	1.125	28.58
E	-	-
F	Thru Bore	
G	1.375	35.00
H	2.500	63.50
I*	1.000	25.00
J	0.688	17.50
K	3.875	99.00

Components		
Part #	Description	Quantity
LOB141677	Die Holder - Inch	1
LOB143457	Die Holder - Metric	1
L0D141679	Thread Roll Shaft	3
L104SX37X50	Set Screw - Size Adjustment	1
LFA001055	Set Screw - Size Adjustment	1
L11SX25X50	Socket Head Cap Screw - Size Adjustment	1
LFA001053	Socket Head Cap Screw - Size Adjustment	1
LFA000665	Retaining Screw - Oval Point	3
LFA001054	Retaining Screw - Oval Point	3
LGD000305	Socket Screw Wrench - 3/16	1
LGD001108	Hex Wrench - 4mm	1
LGD001109	Hex Wrench - 5mm	1

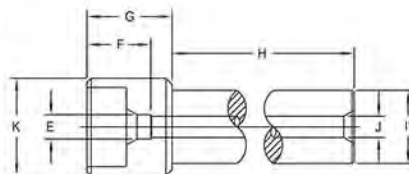
Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm	mm		mm	
	inch	inch		inch	
5/16 - 18 UNC	LSB143558	LOB141738M	H - 3°-20'	22.6	LOB118891
	LSB141830	LOB141738		0.891	
5/16 - 24 UNF	LSB143559	LOB141740M	HF - 2°-30'	22.6	LOB118897
	LSB141832	LOB141740		0.891	
3/8 - 16 UNC	LSB143558	LOB141738M	H - 3°-20'	22.6	LOB118892
	LSB141830	LOB141738		0.891	
3/8 - 24 UNF	LSB143559	LOB141740M	HF - 2°-30'	22.6	LOB118898
	LSB141832	LOB141740		0.891	
7/16 - 14 UNC	LSB143558	LOB141738M	H - 3°-20'	22.6	LOB118893
	LSB141830	LOB141738		0.891	
7/16 - 20 UNF	LSB143559	LOB141740M	HF - 2°-30'	22.6	LOB118584
	LSB141832	LOB141740		0.891	



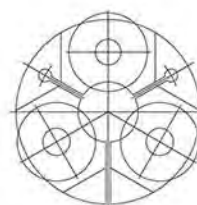
Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch	mm inch		mm inch	
1/2 - 13 UNC	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB118894
	LSB141831	LOB141739		0.891	
1/2 - 20 UNF	LSB143561	LOB141741M	IF - 1°-50'	22.6	LOB118577
	LSB141833	LOB141741		0.891	
9/16 - 12 UNC	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB118895
	LSB141831	LOB141739		0.891	
9/16 - 18 UNF	LSB143561	LOB141741M	IF - 1°-50'	22.6	LOB118899
	LSB141833	LOB141741		0.891	
5/8 - 11 UNC	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB141745
	LSB141831	LOB141739		0.891	
5/8 - 18 UNF	LSB143561	LOB141741M	IF - 1°-50'	22.6	LOB118585
	LSB141833	LOB141741		0.891	
M8 x .75	LSB143562	LOB141744M	HMF - 1°-45'	22.6	LOB140460
	LSB141834	LOB141744		0.891	
M8 x 1.0	LSB143559	LOB141740M	HF - 2°-30'	22.6	LOB140461
	LSB141832	LOB141740		0.891	
M8 x 1.25	LSB143558	LOB141738M	H - 3°-20'	22.6	LOB140605
	LSB141830	LOB141738		0.891	
M10 x .75	LSB143562	LOB141744M	HMF - 1°-45'	22.6	LOB142462
	LSB141834	LOB141744		0.891	
M10 x 1.0	LSB143562	LOB141744M	HMF - 1°-45'	22.6	LOB142077
	LSB141834	LOB141744		0.891	
M10 x 1.5	LSB143558	LOB141738M	H - 3°-20'	22.6	LOB120613
	LSB141830	LOB141738		0.891	
M12 x 1.25	LSB143562	LOB141744M	HMF - 1°-45'	22.6	LOB128899
	LSB141834	LOB141744		0.891	
M12 x 1.5	LSB143559	LOB141740M	HF - 2°-30'	22.6	LOB140463
	LSB141832	LOB141740		0.891	
M12 x 1.75	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB125521
	LSB141831	LOB141739		0.891	
M14 x 2.0	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB120614
	LSB141831	LOB141739		0.891	
M16 x 1.5	LSB143561	LOB141741M	IF - 1°-50'	22.6	LOB140464
	LSB141833	LOB141741		0.891	
M16 x 2.0	LSB143560	LOB141739M	I - 2°-45'	22.6	LOB139490
	LSB141831	LOB141739		0.891	



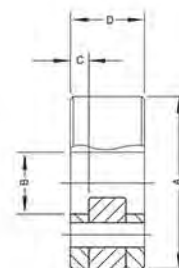
Die Holder



Die Body



Front View



Side View

#7 Tooling Dimensions		
Dimensions	inches	mm
A	3.875	98.43
B	see thread size chart	
C	0.375	9.53
D	1.750	44.45
E	--	--
F	Thru Bore	
G	2.125	54.00
H	2.500	63.50
I*	1.500	38.00
J	1.063	27.00
K	4.500	115.00

Components		
Part #	Description	Quantity
L0B142215	Die Holder - Inch	1
L0B143458	Die Holder - Metric	1
L0D142222	Thread Roll Shaft	3
L104SX37X50	Set Screw - Size Adjustment	1
LFA001055	Set Screw - Size Adjustment	1
L11SX25X50	Socket Head Cap Screw - Size Adjustment	1
LFA001053	Socket Head Cap Screw - Size Adjustment	1
LFA000665	Retaining Screw - Oval Point	1
LFA001054	Retaining Screw - Oval Point	1
LGD000305	Socket Screw Wrench - 3/16	3
LGD001108	Hex Wrench - 4mm	1
LGD001109	Hex Wrench - 5mm	1

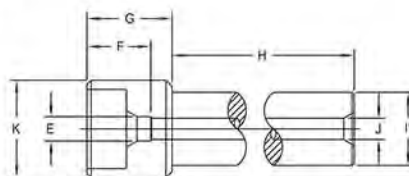
Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch	mm inch		mm inch	
7/16 - 14 UNC	LSB143563	L0B142216M	J - 3°-20'	33.4	L0B118563
	LSB142260	L0B142216		1.313	
7/16 - 20 UNF	LSB143564	L0B142218M	JF - 2°-15'	33.4	L0B116060
	LSB142262	L0B142218		1.313	
1/2 - 13 UNC	LSB143563	L0B142216M	J - 3°-20'	33.4	L0B115752
	LSB142260	L0B142216		1.313	
1/2 - 20 UNF	LSB143564	L0B142218M	JF - 2°-15'	33.4	L0B116061
	LSB142262	L0B142218		1.313	
9/16 - 12 UNC	LSB143563	L0B142216M	J - 3°-20'	33.4	L0B118562
	LSB142260	L0B142216		1.313	
9/16 - 18 UNF	LSB143564	L0B142218M	JF - 2°-15'	33.4	L0B116062
	LSB142262	L0B142218		1.313	



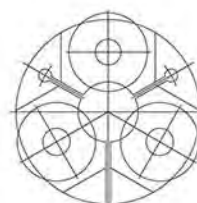
Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch	mm inch		mm inch	
5/8 - 11 UNC	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB118567
	LSB142261	LOB142217		1.313	
5/8 - 18 UNF	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB112092
	LSB142263	LOB142219		1.313	
3/4 - 10 UNC	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB112091
	LSB142261	LOB142217		1.313	
3/4 - 16 UNF	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB115236
	LSB142263	LOB142219		1.313	
7/8 - 9 UNC	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB118568
	LSB142261	LOB142217		1.313	
7/8 - 14 UNF	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB112566
	LSB142263	LOB142219		1.313	
1 - 8 UNC	LSB143567	LOB142220M	L - 2°-30'	33.4	LOB142231
	LSB142264	LOB142220		1.313	
1 - 12 UNF	LSB143568	LOB142221M	LF - 1°-30'	33.4	LOB142232
	LSB142265	LOB142221		1.313	
1 - 14 UN	LSB143568	LOB142221M	LF - 1°-30'	33.4	LOB142233
	LSB142265	LOB142221		1.313	
M12 x 1.75	LSB143563	LOB142216M	J - 3°-20'	33.4	LOB129043
	LSB142260	LOB142216		1.313	
M12 x 1.25	LSB143564	LOB142218M	JF - 2°-15'	33.4	LOB133928
	LSB142262	LOB142218		1.313	
M14 x 2.0	LSB143563	LOB142216M	J - 3°-20'	33.4	LOB115468
	LSB142260	LOB142216		1.313	
M14 x 1.5	LSB143564	LOB142218M	JF - 2°-15'	33.4	LOB134223
	LSB142262	LOB142218		1.313	
M16 x 2.0	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB112592
	LSB142261	LOB142217		1.313	
M16 x 1.5	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB132163
	LSB142263	LOB142219		1.313	
M20 x 2.5	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB123573
	LSB142261	LOB142217		1.313	
M20 x 1.5	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB131276
	LSB142263	LOB142219		1.313	
M22 x 2.5	LSB143565	LOB142217M	K - 2°-45'	33.4	LOB068827
	LSB142261	LOB142217		1.313	
M22 x 1.5	LSB143566	LOB142219M	KF - 1°-40'	33.4	LOB131211
	LSB142263	LOB142219		1.313	
M24 x 3.0	LSB143567	LOB142220M	L - 2°-30'	33.4	LOB142237
	LSB142264	LOB142220		1.313	
M24 x 1.5	LSB143568	LOB142221M	LF - 1°-30'	33.4	LOB142239
	LSB142265	LOB142221		1.313	



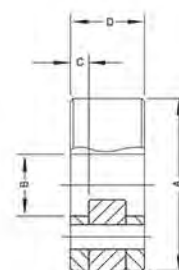
Die Holder



Die Body



Front View



Side View

#10 Tooling Dimensions

Dimensions	inches	mm
A	6.875	174.62
B	see thread size chart	
C	0.375	9.53
D	2.000	50.80
E	-	-
F	Thru Bore	
G	2.625	67.00
H	3.250	83.00
J*	2.000	50.00
J	1.312	34.00
K	7.750	197.00

Components

Part #	Description	Quantity
L0A142210	Die Holder - Inch	1
L0A143477	Die Holder - Metric	1
L0D142162	Thread Roll Shaft	3
LFA000666	Set Screw - Size Adjustment	1
LFA001060	Set Screw - Size Adjustment	1
LFA000973	Socket Head Cap Screw - Size Adjustment	1
LFA001059	Socket Head Cap Screw - Size Adjustment	1
LFA000665	Retaining Screw - Oval Point	3
LFA001054	Retaining Screw - Oval Point	3
LGD000595	T-Handle Wrench	1
LGD001109	Hex Wrench - 5mm	1

Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch	mm inch		mm inch	
5/8 - 11 UNC	LSB143569	L0B142192M	Q - 2°-45'	59.5	L0B118560
	LSB142203	L0B142192		2.344	
5/8 - 18 UNF	LSB143570	L0B142194M	QF - 1°-40'	59.5	L0B118624
	LSB142205	L0B142194		2.344	
3/4 - 10 UNC	LSB143569	L0B142192M	Q - 2°-45'	59.5	L0B118586
	LSB142203	L0B142192		2.344	
3/4 - 16 UNF	LSB143570	L0B142194M	QF - 1°-40'	59.5	L0B118570
	LSB142205	L0B142194		2.344	
7/8 - 9 UNC	LSB143569	L0B142192M	Q - 2°-45'	59.5	L0B118571
	LSB142203	L0B142192		2.344	
7/8 - 14 UNF	LSB143570	L0B142194M	QF - 1°-40'	59.5	L0B118572
	LSB142205	L0B142194		2.344	



Thread Size	Sub-Assembly Shank EDP	Die Body EDP	Die Body Size	B - Dimension	Thread Roll EDP
	mm inch	mm inch		mm inch	
1 - 8 UNC	LSB143571	LOB142193M	R - 2°-25'	59.5	LOB118550
	LSB142204	LOB142193		2.344	
1 - 12 UNF	LSB143572	LOB142195M	RF - 1°-20'	59.5	LOB118561
	LSB142206	LOB142195		2.344	
1-1/8 7 UNC	LSB143571	LOB142193M	R - 2°-25'	59.5	LOB118548
	LSB142204	LOB142193		2.344	
1-1/8 - 12 UNF	LSB143572	LOB142195M	RF - 1°-20'	59.5	LOB114092
	LSB142206	LOB142195		2.344	
1-1/4 - 7 UNC	LSB143571	LOB142193M	R - 2°-25'	59.5	LOB118547
	LSB142204	LOB142193		2.344	
1-1/4 - 12 UNF	LSB143572	LOB142195M	RF - 1°-20'	59.5	LOB118559
	LSB142206	LOB142195		2.344	
M16 x 2.0	LSB143569	LOB142192M	Q - 2°-45'	59.5	LOB139598
	LSB142203	LOB142192		2.344	
M20 x 2.5	LSB143569	LOB142192M	Q - 2°-45'	59.5	LOB132225
	LSB142203	LOB142192		2.344	
M24 x 3.0	LSB143569	LOB142192M	Q - 2°-45'	59.5	LOB067483
	LSB142203	LOB142192		2.344	
M24 x 2.0	LSB143570	LOB142194M	QF - 1°-40'	59.5	LOB135232
	LSB142205	LOB142194		2.344	
M30 x 3.5	LSB143571	LOB142193M	R - 2°-25'	59.5	LOB132298
	LSB142204	LOB142193		2.344	
M30 x 2.0	LSB143572	LOB142195M	RF - 1°-20'	59.5	LOB118782
	LSB142206	LOB142195		2.344	

Oil and Gas Industry Threads						
Sucker Rod Size	Sucker Rod Thread	Sub-Assembly Standard Shank EDP	Thread Rolls* EDP	Die Bodies EDP	Die Body Size	B-Dimension
						mm inch
5/8	15/16 - 10 API		LOB136461	LOA142208	SR - 2°-0'	59.5
						2.344
3/4	1-1/16 - 10 API	LSB142159	LOB135883	LOA142161	SR - 1°-40'	59.5
						2.344
7/8	1-3/16 - 10 API	LSB142159	LOB142293	LOA142161	SR - 1°-40'	59.5
						2.344
1	1-3/8 - 10 API	LSB142159	LOB136463	LOA142161	SR - 1°-40'	59.5
						2.344
1-1/8	1-9/16 - 10 API	LSB142159	LOB136464	LOA142161	SR - 1°-40'	59.5
						2.344

* Sucker Rod Thread Rolls have Truncated Progressive Long Threads

Using the Landis EZ Roller™ thread rolling tool begins with the application to the machine on which threads are to be rolled. They are ideally suited for use on CNC style machines that have a Rigid or Synchronous Tapping Cycle as part of their program selection. This cycle, normally used for tapping an internal thread, is a thread-on/thread-off operation that retracts the tap back out of the hole. It synchronizes the feed pitch to the spindle rotation, so that when the tool reaches its end-point, the feed matches the spindle speed as the spindle slows down to a stop and then reverses. This feature eliminates the old-style floating holder. So, applying an EZ Roller™ thread rolling tool to the same Rigid tapping cycle permits an external thread to be rolled in a similar manner. By utilizing this cycle, it allows for a simplified rolling tool design with no moving parts or mechanisms. Cycle times can be reduced by the elimination of extra turret movements in order to reset opening style thread cutting and rolling heads. All EZ Roller™ thread rolling tools can be furnished with inch or metric shanks for use in standard tool holders, which allows the tool to be applied to CNC machines with automatic tool changers.

While considerable time can be saved in the overall cycle when threading a part with an EZ Roller™ thread rolling tool, it may not be practical to do so if the length of the thread is excessively long. At some point, the cycle time to thread-on and thread-off will be longer than that time required to move and reset an opening style rolling head.

This determination will need to be made as part of the overall part run. Landis typically suggests that the thread length be limited to 2 to 3 times the thread diameter, however, longer length threads can be run under certain conditions.

Another feature of the EZ Roller™ thread rolling tool is its capacity to be pre-set for a thread size off the machine. Spare or extra Die Bodies and Thread Rolls can be used for the same or additional sizes and then exchanged with the used one. With the #1.5, #3 and the #3.5, the unit cost is low enough to possibly justify exchanging the entire pre-set tool. Conversely, on the #5, #7 and #10 where the Die Body and Rolls are independent of the Die Holder, a Die Body unit can be exchanged without removing the Die Holder from the machine, in just a matter of minutes. Pre-setting the EZ Roller™ thread rolling tools on the bench can be accomplished by using either a thread set-gage or a master part, if one is available.

Or, on the smaller sizes, a plug gage equal to the thread minor diameter can be used by inserting it in between the Thread Rolls. In using either method of pre-setting, the tool is sized to just finger-tight on the gage. All 6 sizes of EZ Roller™ thread rolling tools are designed with enough size adjustment capacity to permit adjustment thru the Pitch Diameter tolerance ranges of all UN and Metric threads.



The Landis EZ ROLLER™ thread rolling tool is one of the most versatile thread rolling tools for CNC threading operations being made today. The refined design, that has eliminated all moving components, combined with a standardization of manufacturing processes, offers the flexibility to tailor the EZ Roller™ thread rolling tool to meet the customers' workpiece requirements and still fit within the machines tooling envelope.

For this purpose, Landis has developed the "T" version of the EZ Roller™ thread rolling tool. Landis can design a tool to fit your product and machine requirements. To illustrate the concept of the "T" version, we outlined two examples of tools that were designed and built for specific purposes.

- The #7T EZ Roller™ thread rolling tool, designed to thread roll a 3.125" - 12P UN thread on an automotive axle housing. The application was to a special-built CNC machine. This #7T utilizes 5 Thread Rolls per set. The Thread Roll is based on the smaller #5 EZ Roller™ thread rolling tool, in order to help keep the overall tool size to a minimum, yet still provide sufficient roll diameter for long life. The 5-roll design minimizes arch-length which helps insure stability during the rolling cycle.
- The #3T EZ Roller™ thread rolling tool was designed to thread roll a 3/4" - 20P UNEF thread on a 13/16" hex fitting. In this case, the tool envelop of the CNC machine dictated the size of the tool. The thread was to be rolled close to the hex shoulder, so thread rolls from a #3CNC were used in a tailor-made Die Body that would clear the hex. The Holder was then sized to fit within that required tooling envelop.



APPLICATIONS OF EZ ROLLER™ THREAD ROLLING TOOLS

Being round, the majority of threading operations are naturally done on lathes. However, in some instances, parts that are not round may also have a thread on them.

Eliminate the secondary threading operation by installing a Landis EZ Roller on your machining center using a direct-mount V-flange shank. With the EZ Roller, there is no resetting operation needed, so the machine cycle can index the tool into the spindle, roll the thread, and then index out. Landis can supply any size CAT or BT style shank on our full range of EZ Rollers.

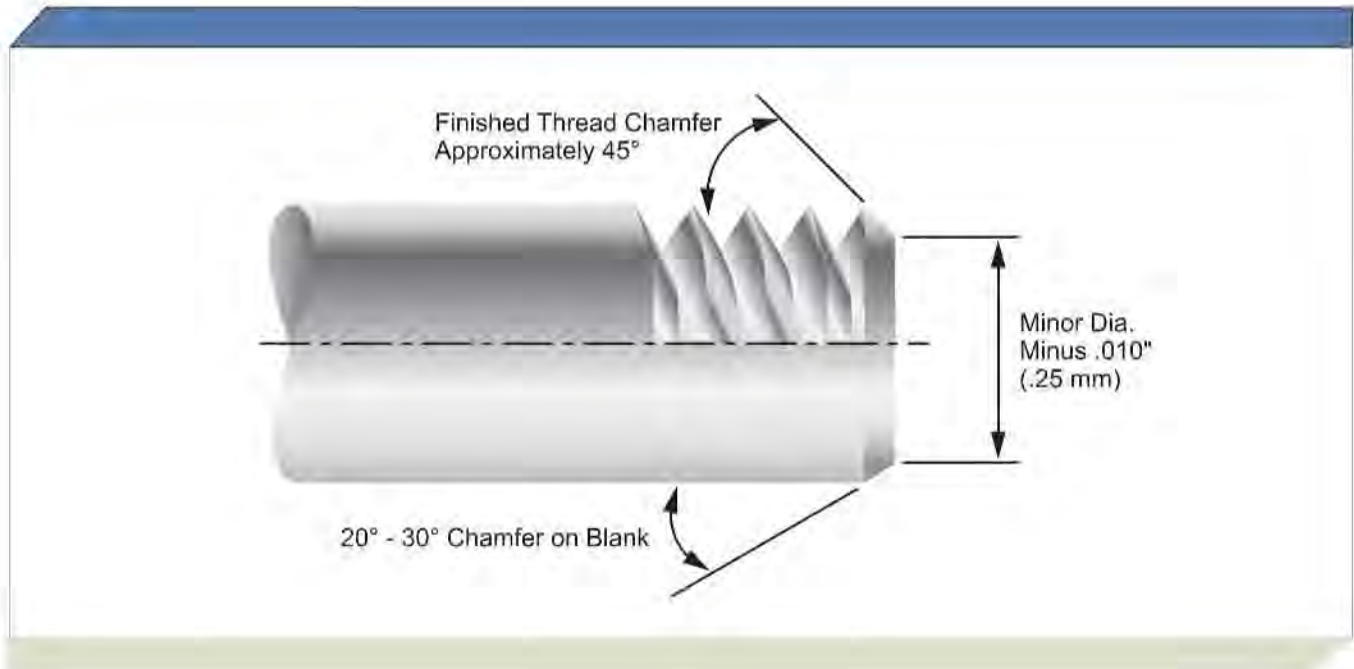
The Landis® CNC EZ roller can be supplied with specialized tool adaption systems such as the VDI system as well as those with through coolant.

Preparing and Controlling Blank Diameters

- The process of maintaining a properly sized blank diameter within specific limits is critical to forming a functionally correct thread
- Compressing excess material between thread rolls increases pressure on the roll thread form (over rolling). Causing roll breakage and/or oversized threads.
- Compressing little material causes thread to be incorrectly formed.
- To help eliminate these issues, Landis provides recommended starting blank diameter for both inch and metric threads
- Depending on the material and metallurgical makeup the final blank diameter must be established by actual rolling.

Preparing the blank

- Rolled Threads have a seam which results from material flowing from the root area up to and folded in at the crest. Seams will be more visible on some threads than others.
- Starting with the minimum acceptable blank diameter will increase roll life and result in a larger seam
- Seams have no bearing on thread strength but sometimes they are aesthetically objectionable. If this is the case, they can be rolled tighter if the decreased roll life is acceptable, or the thread can be rolled with an oversized addendum that can be ground away to remove the seam.
- Starting at minimum blank diameter also allows for blank growth due to tool wear and longer run times before the maximum allowable blank diameter is reached.





Blank Diameters for Parallel Rolled Metric Threads										
Size		Steels						Brass & Bronze	Aluminum Alloys	
		10-50 C Soft	30-50 C Soft	30-50 C or Alloy 15-25 RC	30-50 C or Alloy 26-32 RC	Stainless Chrome Nickel 300 Series	Stainless Chrome 400 Series		Soft	Hard
		Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.		Min. - Max.	Min. - Max.
		mm	mm	mm	mm	mm	mm		mm	mm
Size	Pitch	Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch
3	0.35	2.743 - 2.756	2.751 - 2.764	2.756 - 2.769	2.758 - 2.771	2.766 - 2.779	2.758 - 2.771	2.751 - 2.764	2.756 - 2.769	2.751 - 2.764
		0.108 - 0.1085	0.1083 - 0.1088	0.1085 - 0.1090	0.1086 - 0.1091	0.1089 - 0.1094	0.1086 - 0.1091	0.1083 - 0.1088	0.1085 - 0.1090	0.1083 - 0.1088
3	0.5	2.639 - 2.652	2.647 - 2.659	2.652 - 2.664	2.654 - 2.667	2.662 - 2.675	2.654 - 2.667	2.647 - 2.659	2.652 - 2.664	2.647 - 2.659
		0.1039 - 0.1044	0.1042 - 0.1047	0.1044 - 0.1049	0.1045 - 0.1050	0.1048 - 0.1053	0.1045 - 0.1050	0.1042 - 0.1047	0.1044 - 0.1049	0.1042 - 0.1047
3.5	0.35	3.244 - 3.256	3.249 - 3.261	3.254 - 3.266	3.256 - 3.269	3.264 - 3.277	3.256 - 3.269	3.249 - 3.261	3.254 - 3.266	3.249 - 3.261
		0.1277 - 0.1282	0.1279 - 0.1284	0.1281 - 0.1286	0.1282 - 0.1287	0.1285 - 0.1290	0.1282 - 0.1287	0.1279 - 0.1284	0.1281 - 0.1286	0.1279 - 0.1284
3.5	6	3.071 - 3.084	3.081 - 3.094	3.084 - 3.096	3.089 - 3.101	3.096 - 3.109	3.089 - 3.101	3.081 - 3.094	3.084 - 3.096	3.081 - 3.094
		0.1209 - 0.1214	0.1213 - 0.1218	0.1214 - 0.1219	0.1216 - 0.1221	0.1219 - 0.1224	0.1216 - 0.1221	0.1213 - 0.1218	0.1214 - 0.1219	0.1213 - 0.1218
4	0.5	3.64 - 3.653	3.647 - 3.660	3.65 - 3.663	3.655 - 3.668	3.663 - 3.675	3.655 - 3.668	3.647 - 3.660	3.650 - 3.663	3.647 - 3.660
		0.1433 - 0.1438	0.1436 - 0.1441	0.1437 - 0.1442	0.1439 - 0.1444	0.1442 - 0.1447	0.1439 - 0.1444	0.1436 - 0.1441	0.1437 - 0.1442	0.1436 - 0.1441
4	0.7	3.505 - 3.52	3.513 - 3.528	3.518 - 3.533	3.523 - 3.538	3.533 - 3.548	3.523 - 3.538	3.513 - 3.528	3.518 - 3.533	3.513 - 3.528
		0.138 - 0.1386	0.1383 - 0.1389	0.1385 - 0.1391	0.1387 - 0.1393	0.1391 - 0.1397	0.1387 - 0.1393	0.1383 - 0.1389	0.1385 - 0.1391	0.1383 - 0.1389
4.5	0.5	4.14 - 4.153	4.648 - 4.161	4.15 - 4.663	4.155 - 4.168	4.163 - 4.176	4.155 - 4.168	4.148 - 4.161	4.15 - 4.163	4.148 - 4.161
		0.163 - 0.1635	0.1633 - 0.1638	0.1634 - 0.1639	0.1636 - 0.1641	0.1639 - 0.1644	0.1636 - 0.1641	0.1633 - 0.1638	0.1634 - 0.1639	0.1633 - 0.1638
5	0.5	4.638 - 4.651	4.148 - 4.661	4.651 - 4.1630	4.653 - 4.666	4.663 - 4.676	4.653 - 4.666	4.648 - 4.661	4.6510 - 4.663	4.648 - 4.661
		0.1826 - 0.1831	0.183 - 0.1835	0.1831 - 0.1836	0.1832 - 0.1837	0.1836 - 0.1840	0.1832 - 0.1837	0.183 - 0.1835	0.1831 - 0.1836	0.1830 - 0.1835
5	0.8	4.437 - 4.455	4.448 - 4.463	4.453 - 4.468	4.458 - 4.473	4.465 - 4.483	4.463 - 4.473	4.468 - 4.483	4.4630 - 4.483	4.447 - 4.4627
		0.1747 - 0.1754	0.1751 - 0.1757	0.1753 - 0.1759	0.1755 - 0.1761	0.1758 - 0.1765	0.1755 - 0.1761	0.1751 - 0.1757	0.1753 - 0.1759	0.1751 - 0.1757
6	0.75	5.469 - 5.484	5.479 - 5.494	5.484 - 5.499	5.489 - 5.504	5.496 - 5.512	5.489 - 5.504	5.479 - 5.494	5.484 - 5.499	5.479 - 5.494
		0.2153 - 0.2159	0.2157 - 0.2163	0.2159 - 0.2165	0.2161 - 0.2167	0.2164 - 0.2170	0.2161 - 0.2167	0.2157 - 0.2163	0.2159 - 0.2165	0.2157 - 0.2163
6	1	5.293 - 5.314	5.306 - 5.326	5.314 - 5.334	5.319 - 5.339	5.331 - 5.352	5.319 - 5.339	5.306 - 5.326	5.314 - 5.334	5.306 - 5.326
		0.2084 - 0.2092	0.2089 - 0.2097	0.2092 - 0.21	0.2094 - 0.2102	0.2099 - 0.2107	0.2094 - 0.2102	0.2089 - 0.2097	0.2092 - 0.2100	0.2089 - 0.2097
7	0.75	6.469 - 6.485	6.48 - 6.495	6.485 - 6.5000	6.49 - 6.505	6.497 - 6.513	6.49 - 6.505	6.48 - 6.495	6.4890 - 6.5000	6.4800 - 6.495
		0.2547 - 0.2553	0.2551 - 0.2557	0.2553 - 0.2559	0.2555 - 0.2561	0.2558 - 0.2564	0.2561 - 0.1561	0.2551 - 0.2557	0.2553 - 0.2559	0.2551 - 0.2557
7	1	6.294 - 6.314	6.307 - 6.3270	6.314 - 6.335	6.32 - 6.340	6.332 - 6.353	6.32 - 6.340	6.307 - 6.327	6.314 - 6.335	6.307 - 6.327
		0.2478 - 0.2486	0.2483 - 0.2491	0.2486 - 0.2494	0.2488 - 0.2496	0.2493 - 0.2501	0.2488 - 0.2496	0.2483 - 0.2491	0.2486 - 0.2494	0.2483 - 0.2491
8	1	7.295 - 7.3150	7.308 - 7.328	7.315 - 7.336	7.32 - 7.341	7.333 - 7.353	7.320 - 7.341	7.308 - 7.328	7.315 - 7.336	7.308 - 7.328
		0.2872 - 0.288	0.2877 - 0.2885	0.288 - 0.2888	0.2882 - 0.2890	0.2887 - 0.2895	0.2882 - 0.2890	0.2877 - 0.2885	0.2880 - 0.2888	0.2877 - 0.2885
8	1.25	7.13 - 7.150	7.142 - 7.1630	7.148 - 7.168	7.155 - 7.1790	7.168 - 7.1880	7.155 - 7.176	7.142 - 7.163	7.1480 - 7.168	7.142 - 7.163
		0.2807 - 0.2815	0.2812 - 0.2820	0.2814 - 0.2822	0.2817 - 0.2825	0.2822 - 0.2830	0.2817 - 0.2825	0.2812 - 0.282	0.2814 - 0.2822	0.2812 - 0.2820
9	1	8.293 - 8.313	8.306 - 8.326	8.313 - 8.334	8.319 - 8.339	8.331 - 8.352	8.319 - 8.339	8.306 - 8.326	8.1310 - 8.334	8.306 - 8.326
		0.3265 - 0.3273	0.327 - 0.3278	0.3273 - 0.3281	0.3275 - 0.3283	0.328 - 0.3288	0.3275 - 0.3283	0.327 - 0.3278	0.3273 - 0.3281	0.327 - 0.3278
9	1.25	8.131 - 8.151	8.143 - 8.164	8.148 - 8.169	8.156 - 8.176	8.169 - 8.189	8.156 - 8.176	8.143 - 8.164	8.148 - 8.169	8.143 - 8.164
		0.3201 - 0.3209	0.3206 - 0.3214	0.3208 - 0.3216	0.3211 - 0.3219	0.3216 - 0.3224	0.3211 - 0.3219	0.3206 - 0.3214	0.3208 - 0.3216	0.3206 - 0.3214
10	1	9.294 - 9.314	9.307 - 9.327	9.314 - 9.335	9.319 - 9.340	9.332 - 9.352	9.319 - 9.34	9.307 - 9.327	9.314 - 9.335	9.307 - 9.327
		0.3659 - 0.3667	0.3664 - 0.3672	0.3667 - 0.3675	0.3669 - 0.3677	0.3674 - 0.3682	0.3669 - 0.3677	0.3664 - 0.3672	0.3667 - 0.3675	0.3664 - 0.3672
10	1.5	8.956 - 8.9840	8.971 - 8.999	8.979 - 9.007	8.989 - 9.014	9.004 - 9.030	8.989 - 9.014	8.971 - 8.999	8.979 - 9.007	8.971 - 8.999
		0.3526 - 0.3537	0.3532 - 0.3543	0.3535 - 0.3546	0.3539 - 0.3549	0.3545 - 0.3555	0.3539 - 0.3549	0.3532 - 0.3543	0.3535 - 0.3546	0.3532 - 0.3543



Blank Diameters for Parallel Rolled Metric Threads										
Size		Steels						Brass & Bronze	Aluminum Alloys	
		10-50 C Soft	30-50 C Soft	30-50 C or Alloy 15-25 RC	30-50 C or Alloy 26-32 RC	Stainless Chrome Nickel 300 Series	Stainless Chrome 400 Series		Soft	Hard
Size	Pitch	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.
		mm	mm	mm	mm	mm	mm	mm	mm	mm
		Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch
11	1.5	9.954 - 9.982	9.97 - 9.997	9.977 - 10.005	9.987 - 10.012	10.003 - 10.027	9.987 - 10.012	9.97 - 9.997	9.977 - 10.005	9.97 - 9.997
		0.3919 - 0.3930	0.3925 - 0.3936	0.3928 - 0.3939	0.3932 - 0.3942	0.3938 - 0.3948	0.3932 - 0.3942	0.3925 - 0.3936	0.3928 - 0.3939	0.3925 - 0.3936
12	1.5	10.955 - 10.983	10.97 - 10.998	10.978 - 11.006	10.988 - 11.013	11.003 - 11.029	10.988 - 11.013	10.97 - 10.998	10.978 - 11.006	10.97 - 10.998
		0.4313 - 0.4324	0.4319 - 0.4330	0.4322 - 0.4333	0.4326 - 0.4336	0.4332 - 0.4342	0.4326 - 0.4336	0.4319 - 0.433	0.4322 - 0.4333	0.4319 - 0.4330
12	1.75	10.785 - 10.818	10.803 - 10.836	10.81 - 10.843	10.82 - 10.853	10.838 - 10.871	10.82 - 10.853	10.803 - 10.836	10.81 - 10.843	10.803 - 10.836
		0.4246 - 0.4259	0.4253 - 0.4266	0.4256 - 0.4269	0.426 - 0.4273	0.4267 - 0.4280	0.426 - 0.4273	0.4253 - 0.4266	0.4256 - 0.4269	0.4253 - 0.4266
14	1.5	1.2954 - 12.982	12.969 - 12.997	12.977 - 13.005	12.987 - 13.012	13.002 - 13.028	12.987 - 13.012	12.969 - 12.997	12.977 - 13.005	12.969 - 12.997
		0.51 - 0.5111	0.5106 - 0.5117	0.5109 - 0.5120	0.5113 - 0.5123	0.5119 - 0.5129	0.5113 - 0.5123	0.5106 - 0.5117	0.5109 - 0.5120	0.5106 - 0.5117
14	2	12.614 - 12.647	12.631 - 12.664	12.642 - 12.675	12.652 - 12.685	12.672 - 12.705	12.652 - 12.685	12.631 - 12.664	12.642 - 12.675	12.631 - 12.664
		0.4966 - 0.4979	0.4973 - 0.4986	0.4977 - 0.4990	0.4981 - 0.4994	0.4989 - 0.5002	0.4981 - 0.4994	0.4973 - 0.4986	0.4977 - 0.4990	0.4973 - 0.4986
16	1.5	14.956 - 14.983	14.971 - 14.999	14.987 - 15.006	14.989 - 15.014	15.004 - 15.029	14.989 - 15.014	14.971 - 14.999	14.978 - 15.006	14.971 - 14.999
		0.5888 - 0.5899	0.5894 - 0.5905	0.5897 - 0.5908	0.5901 - 0.5911	0.5907 - 0.5917	0.5901 - 0.5911	0.5894 - 0.5905	0.5897 - 0.5908	0.5894 - 0.5905
16	2	14.615 - 14.648	14.633 - 14.666	14.643 - 14.676	14.653 - 14.686	14.674 - 14.707	14.653 - 14.686	14.633 - 14.666	14.643 - 14.676	14.633 - 14.666
		0.5754 - 0.5767	0.5761 - 0.5774	0.5765 - 0.5778	0.5769 - 0.5782	0.5777 - 0.579	0.5769 - 0.5782	0.5761 - 0.5774	0.5765 - 0.5778	0.5761 - 0.5774
18	1.5	16.955 - 16.982	16.97 - 16.998	16.977 - 17.005	16.988 - 17.013	17.003 - 17.028	16.988 - 17.013	16.97 - 16.998	16.977 - 17.005	16.97 - 16.998
		0.6675 - 0.6686	0.6681 - 0.6692	0.6684 - 0.6695	0.6688 - 0.6698	0.6694 - 0.6704	0.6688 - 0.6698	0.6681 - 0.6692	0.6684 - 0.6695	0.6681 - 0.6692
18	2.5	16.274 - 16.312	16.297 - 16.335	16.307 - 16.345	16.32 - 16.358	16.342 - 16.380	16.320 - 16.358	16.297 - 16.335	16.307 - 16.345	16.297 - 16.335
		0.6407 - 0.6422	0.6416 - 0.6431	0.642 - 0.6435	0.6425 - 0.644	0.6434 - 0.6449	0.6425 - 0.644	0.6416 - 0.6431	0.642 - 0.6435	0.6416 - 0.6431
20	1.5	18.956 - 18.984	18.971 - 18.999	18.979 - 19.007	18.989 - 19.014	19.004 - 19.030	18.989 - 19.014	18.971 - 18.999	18.979 - 19.007	18.971 - 18.999
		0.7463 - 0.7474	0.7469 - 0.7480	0.7472 - 0.7483	0.7475 - 0.7486	0.7482 - 0.7492	0.7475 - 0.7486	0.7469 - 0.748	0.7472 - 0.7483	0.7469 - 0.7480
20	2.5	18.275 - 18.313	18.298 - 18.336	18.308 - 18.346	18.321 - 18.359	18.344 - 18.382	18.321 - 18.359	18.298 - 18.336	18.308 - 18.346	18.298 - 18.336
		0.7195 - 0.7210	0.7204 - 0.7219	0.7208 - 0.7223	0.7213 - 0.7228	0.7222 - 0.7237	0.7213 - 0.7228	0.7204 - 0.7219	0.7208 - 0.7223	0.7204 - 0.7219
22	1.5	20.955 - 20.983	20.97 - 20.998	20.978 - 21.006	20.988 - 21.013	21.003 - 21.029	20.988 - 21.013	20.97 - 20.998	20.978 - 21.006	20.970 - 20.998
		0.825 - 0.8261	0.8256 - 0.8267	0.8259 - 0.8270	0.8263 - 0.8273	0.8269 - 0.8279	0.8263 - 0.8273	0.8256 - 0.8267	0.8259 - 0.8270	0.8256 - 0.8267
22	2.5	20.274 - 20.312	20.297 - 20.335	20.307 - 20.345	20.32 - 20.358	20.343 - 20.381	20.320 - 20.358	20.297 - 20.335	20.307 - 20.345	20.297 - 20.335
		0.7982 - 0.7997	0.7991 - 0.8006	0.7995 - 0.8010	0.8000 - 0.8015	0.8009 - 0.8024	0.8000 - 0.8015	0.7991 - 0.8006	0.7995 - 0.8010	0.7991 - 0.8006
24	2	22.614 - 22.647	22.631 - 22.664	22.642 - 22.675	22.652 - 22.685	22.672 - 22.705	22.652 - 22.685	22.631 - 22.664	22.642 - 22.675	22.631 - 22.664
		0.8903 - 0.8916	0.891 - 0.8923	0.8927 - 0.8927	0.8918 - 0.8914	0.8926 - 0.8939	0.8918 - 0.8931	0.891 - 0.8923	0.8914 - 0.8927	0.891 - 0.8923
24	3	21.930 - 21.979	21.958 - 22.004	21.971 - 22.017	21.984 - 22.029	22.007 - 22.055	21.984 - 22.029	21.958 - 22.004	21.971 - 22.017	21.958 - 22.004
		0.8634 - 0.8653	0.8645 - 0.8663	0.865 - 0.8668	0.8655 - 0.8673	0.8664 - 0.8683	0.8655 - 0.8673	0.8645 - 0.8663	0.8650 - 0.8668	0.8645 - 0.8663
27	2	25.613 - 25.646	25.631 - 25.664	25.641 - 25.674	25.651 - 25.684	25.672 - 25.705	25.651 - 25.684	25.631 - 25.664	25.641 - 25.674	25.631 - 25.664
		1.0084 - 1.0097	1.0091 - 1.0104	1.0095 - 1.0108	1.0099 - 1.0112	1.0107 - 1.012	1.0099 - 1.0112	1.0091 - 1.0104	1.0095 - 1.0208	1.0091 - 1.0104
27	3	24.933 - 24.981	24.961 - 25.006	24.973 - 25.019	24.986 - 25.032	25.011 - 25.060	24.986 - 25.032	24.961 - 25.006	24.973 - 25.019	24.961 - 25.006
		0.9816 - 0.9835	0.9827 - 0.9845	0.9832 - 0.985	0.9837 - 0.9855	0.9847 - 0.9866	0.9837 - 0.9855	0.9827 - 0.9845	0.9832 - 0.985	0.9827 - 0.9848



Blank Diameters for Parallel Rolled Metric Threads										
Size		Steels						Brass & Bronze	Aluminum Alloys	
		10-50 C Soft	30-50 C Soft	30-50 C or Alloy 15-25 RC	30-50 C or Alloy 26-32 RC	Stainless Chrome Nickel 300 Series	Stainless Chrome 400 Series		Soft	Hard
		Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.		Min. - Max.	Min. - Max.
		mm	mm	mm	mm	mm	mm		mm	mm
Size	Pitch	Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch
30	2	28.613 - 28.646 1.1265 - 1.1278	28.631 - 28.664 1.1272 - 1.1285	28.641 - 28.679 1.1276 - 1.1289	28.651 - 28.684 1.128 - 1.1293	28.672 - 28.705 1.1288 - 1.1301	28.651 - 28.684 1.128 - 1.1293	28.631 - 28.664 1.1272 - 1.1285	28.641 - 28.674 1.1276 - 1.1289	28.631 - 28.664 1.1272 - 1.1285
30	3.5	27.595 - 27.643 1.0864 - 1.0883	27.623 - 27.763 1.0875 - 1.0895	27.638 - 27.689 1.0881 - 1.0901	27.653 - 27.704 1.0887 - 1.0907	27.683 - 27.732 1.0899 - 1.0918	27.653 - 27.704 1.0887 - 1.0907	27.623 - 27.673 1.0875 - 1.0895	27.638 - 27.689 1.0881 - 1.0901	27.623 - 27.673 1.0875 - 1.0895
33	2	31.615 - 31.648 1.2447 - 1.246	31.633 - 31.666 1.2454 - 1.2467	31.643 - 31.676 1.2458 - 1.2471	31.653 - 31.687 1.2462 - 1.2475	31.674 - 31.707 1.247 - 1.2483	31.653 - 31.687 1.2462 - 1.2475	31.633 - 31.666 1.2454 - 1.2467	31.643 - 31.676 1.2458 - 1.2471	31.633 - 31.666 1.2454 - 1.2467
33	3.5	30.594 - 30.643 1.2045 - 1.2064	30.622 - 30.673 1.2056 - 1.2076	30.637 - 30.688 1.2062 - 1.2082	30.653 - 30.704 1.2068 - 1.2088	30.683 - 30.731 1.208 - 1.2099	30.653 - 30.704 1.2068 - 1.2088	30.622 - 30.673 1.2056 - 1.2076	30.637 - 30.688 1.2062 - 1.2082	30.622 - 30.673 1.2056 - 1.2076
36	3	33.925 - 33.973 1.3356 - 1.3375	33.953 - 34.001 1.3392 - 1.3367	33.967 - 34.016 1.3397 - 1.3373	33.981 - 34.029 1.3408 - 1.3378	34.009 - 34.057 1.3397 - 1.3389	33.981 - 34.029 1.3386 - 1.3378	33.953 - 34.001 1.3392 - 1.3367	33.967 - 34.015 1.3386 - 1.3373	33.953 - 34.001 1.3367 - 1.3386
36	4	33.265 - 33.316 1.3096 - 1.3116	33.295 - 33.346 1.3108 - 1.3128	33.311 - 33.361 1.3114 - 1.3134	33.326 - 33.377 1.312 - 1.3140	33.356 - 33.407 1.3132 - 1.3152	33.326 - 33.377 1.312 - 1.3140	33.295 - 33.346 1.3108 - 1.3128	33.311 - 33.361 1.3114 - 1.3134	33.295 - 33.346 1.3108 - 1.3128
39	3	36.925 - 36.973 1.4537 - 1.4556	36.953 - 37.001 1.4548 - 1.4567	36.967 - 37.015 1.4554 - 1.4573	36.981 - 37.029 1.4559 - 1.4578	37.009 - 37.057 1.4569 - 1.4589	36.981 - 37.029 1.4559 - 1.4578	36.953 - 37.001 1.4548 - 1.4567	36.967 - 37.015 1.4554 - 1.4573	36.953 - 37.001 1.4548 - 1.4567
39	4	36.265 - 36.316 1.4277 - 1.4297	36.295 - 36.346 1.4289 - 1.4309	36.311 - 36.361 1.4295 - 1.4315	36.326 - 36.377 1.4301 - 1.4321	36.356 - 36.407 1.4313 - 1.4333	36.326 - 36.377 1.4301 - 1.4321	36.295 - 36.346 1.4289 - 1.4309	36.311 - 36.361 1.4295 - 1.4315	36.295 - 36.346 1.4289 - 1.4309
42	3	39.923 - 39.971 1.5829 - 1.5848	39.951 - 39.999 1.5841 - 1.586	39.966 - 40.014 1.5846 - 1.5865	39.98 - 40.028 1.5572 - 1.5591	40.008 - 40.056 1.5863 - 1.5882	39.980 - 40.028 1.5572 - 1.5591	39.951 - 39.999 1.5841 - 1.586	39.966 - 40.014 1.5846 - 1.5865	39.951 - 39.999 1.5841 - 1.586
42	4.5	38.928 - 38.987 1.5325 - 1.5348	38.9613 - 39.02 1.5338 - 1.5361	38.978 - 9.036 1.5345 - 1.5368	38.994 - 39.053 1.5351 - 1.5374	39.027 - 39.086 1.5364 - 1.5387	38.994 - 39.053 1.5351 - 1.5374	38.961 - 39.020 1.5338 - 1.5361	38.978 - 39.036 1.5345 - 1.5368	38.961 - 39.020 1.5338 - 1.5361
45	3	42.923 - 42.971 1.7010 - 1.7029	42.951 - 42.999 1.7022 - 1.7041	42.966 - 43.014 1.7027 - 1.7046	42.98 - 43.028 1.6753 - 1.6772	43.008 - 43.056 1.7044 - 1.7063	42.980 - 43.028 1.6753 - 1.6772	42.951 - 42.999 1.7022 - 1.7041	42.966 - 43.014 1.7027 - 1.7046	42.951 - 42.999 1.7022 - 1.7041
45	4.5	41.928 - 41.987 1.6506 - 1.6529	41.961 - 42.020 1.6519 - 1.6542	41.978 - 42.036 1.6526 - 1.6549	41.994 - 42.053 1.6532 - 1.6555	42.027 - 42.086 1.6545 - 1.6568	41.994 - 42.053 1.6532 - 1.6555	41.961 - 42.02 1.6519 - 1.6542	41.978 - 42.036 1.6526 - 1.6549	41.961 - 42.020 1.6519 - 1.6542
48	3	45.921 - 45.971 1.8079 - 1.8099	45.950 - 46.000 1.8091 - 1.8111	45.964 - 46.015 1.8097 - 1.8117	45.979 - 46.029 1.8103 - 1.8123	46.008 - 46.058 1.8115 - 1.8135	45.979 - 46.029 1.8103 - 1.8123	45.950 - 46.000 1.8091 - 1.8111	45.964 - 46.015 1.8097 - 1.8117	45.950 - 46.000 1.8091 - 1.8111
48	5	44.592 - 44.655 1.7556 - 1.7510	44.628 - 44.691 1.7570 - 1.7595	44.645 - 44.709 1.7577 - 1.7601	44.663 - 44.727 1.7584 - 1.7609	44.699 - 44.762 1.7598 - 1.7623	44.663 - 44.727 1.7584 - 1.7609	44.628 - 44.691 1.7570 - 1.7595	44.645 - 44.709 1.7577 - 1.7602	44.628 - 44.691 1.7570 - 1.7595
52	3	49.918 - 49.969 1.9653 - 1.9673	49.948 - 49.999 1.9665 - 1.9685	49.963 - 50.013 1.9671 - 1.9691	49.977 - 50.028 1.9677 - 1.9697	50.007 - 50.058 1.9689 - 1.9709	49.977 - 50.028 1.9677 - 1.9697	49.948 - 49.999 1.9665 - 1.9685	49.963 - 50.013 1.9671 - 1.9691	49.948 - 49.999 1.9665 - 1.9685
52	5	48.592 - 48.643 1.9131 - 1.9151	48.628 - 48.678 1.1945 - 1.9165	48.645 - 48.696 1.9152 - 1.9172	48.663 - 48.714 1.9159 - 1.9179	48.699 - 48.749 1.9173 - 1.9193	48.663 - 48.714 1.9159 - 1.9179	48.628 - 48.678 1.9145 - 1.9165	48.645 - 48.696 1.9152 - 1.9172	48.628 - 48.678 1.9145 - 1.9165



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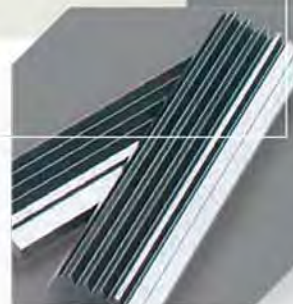
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