



Specification information for No. 3 1/2

thread
rolling
heads—
stationary
and
revolving

[Specs./Ranges](#)

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Specifications for No. 3 1/2 thread rolling heads—stationary and revolving

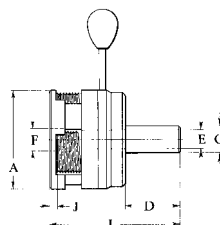
Specifications/Ranges

Head Model	Head Type*	Standard Range**	Maximum Oversize Range	Max. Thrd. Length Using Spec. Rolls & Std. Bore	& Spec. Bore	Weight***
3-1/2	TRSB Stationary	1/4" to 7/16"††—7 mm-11 mm	1/2"-20 Pitch—12 mm-1.25 mm P	5/8"-16 mm	7/8"-22 mm	3 lbs.
3-1/2	TRRB Revolving	1/4" to 7/16"††—7 mm-11 mm	1/2"-20 Pitch—12 mm-1.25 mm P	5/8"-16 mm	1"-25 mm	3 lb. 3 ozs.

*TRSB—Stationary head for turret lathes, etc. TRRB—Revolving head for multi-spindles, etc.

Both left- and right-hand when proper helix angle bushings are used. *Weight will vary slightly depending upon diameter and pitch rolls furnished.

††Rolling 1/4" x 20 pitch U.N.C. is subject to factory review and recommendations. Please give pitch diameter, material and its hardness and whether right or left hand. Special rolls and helix angle bushings may be required.



TRSB Stationary Head

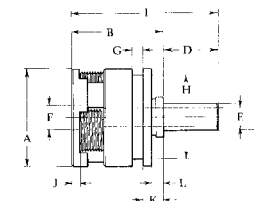
	A	C	D	E	F [†]	I	J*
No. 3-1/2	2-11/16"	3/4"	1-3/4"	15/32"	37/64"	4-3/16"	1/4"

*To face of rolls. †Rolls up to shoulder unless diameter exceeds 9/16".

TRRB Revolving Head

	A	B	C	D	E	F	G	H	I	J*	K	L
No. 3-1/2	2-3/4"	2-25/32"	3/4"	1-3/4"	15/32"	37/64"	.219"-.229"	2-3/8"	4-17/32"	1/4"	11/16"	13/32"

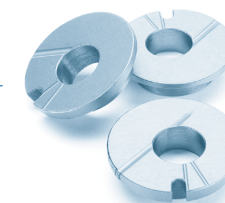
*To face of rolls. †Rolls up to shoulder unless diameter exceeds 9/16".



Replaceable Helix Angle Bushing Sets

UNC BUSHINGS	UNF BUSHINGS	STD. M/M COARSE BUSHINGS	STD. M/M FINE BUSHINGS	STD. LH BUSHING
FRT. C58522	FRT. C63966	FRT. C128586	FRT. C119859	FRT. C58662
REAR C58523	REAR C63967	REAR C128587	REAR C119860	REAR C58663
4° 0'	3° 0'	3° 15'	2° 30'	3° 0'

†† Bushings also available for special threads. Contact factory.



Roll Shaft/Bearing Sets

MULTIPLE BUSHING BEARINGS	MULTIPLE BUSHING SET	1 PC. BEARIUM BRONZE BUSHING	1 PC. CARBIDE	ROLL SHAFTS W/OIL GROOVE
INT. E61198 MID. E61199 EXT. E60732	SE130525	D116818	D133737	D60711



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Ordering Example:

One set of 1/4"-20 pitch
UN/UNR, Identical Long
Throat, Thread Rolls, No.
B118583 for No. 3-1/2
TRB Head.

When a choice must be
made between Identical
Long, Identical Short, and
No Throat Rolls, refer to
the ["Width of Relief"](#)
Chart for the No. 3-1/2
Head.

3 1/2 TRB Thread Rolls

SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT	SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT
1/4 - 20 UN/UNR *	B118583	B118807	B118821	1/4 - 28 UNJF	B115455		B063970
1/4 - 20 UN/UNR **	B118801	B137314		5/16 - 24 UNJF	B123628		B063971
1/4 - 24 UN/UNR	B118833			3/8 - 24 UNJF	B123629		B067730
1/4 - 28 UN/UNR	B116027	B118811	B118823	7/16 - 20 UNJF	B123630		
1/4 - 32 UN/UNR	B118802	B118816	B118827				
1/4 - 36 UN/UNR	B118832	B118846		1/8 - 27 NPSM	B059339	B061669	
1/4 - 40 UN/UNR	B118831	B118845					
1/4 - 48 UN/UNR	B118830	B118844		M6 - 1.0 I.S.O.	B129237	B121073	
1/4 - 56 UN/UNR		B118843		M7 - 1.0 I.S.O.	B131088	B121074	
1/4 - 80 UN/UNR		B118842		M8 - 1.25 I.S.O.		B121075	
9/32 - 32 UN/UNR			B118855	M8 - 1.0 I.S.O.	B134902		
9/32 - 40 UN/UNR	B118834	B118848		M10 - 1.50 I.S.O.	B125318	B119706	
9/32 - 48 UN/UNR		B118847		M10 - 1.25 I.S.O.		B137776	
5/16 - 13 UN/UNR	B118836			M10 - 1.0 I.S.O.	B137490		
5/16 - 18 UN/UNR	B118576	B118808		M12 - 1.75 I.S.O.		B121076	
5/16 - 20 UN/UNR	B118877	B118818					
5/16 - 24 UN/UNR	B116058	B118812	B118824	1/4 - 20 BSW *	B059390	B061673	
5/16 - 28 UN/UNR	B131072	B118849		1/4 - 20 BSW **	B109327		
5/16 - 32 UN/UNR	B118803		B118828	5/16 - 18 BSW	B059395	B061678	
5/16 - 40 UN/UNR	B118835			3/8 - 16 BSW	B059399	B061682	
3/8 - 16 UN/UNR	B118579	B118809	B118822	7/16 - 14 BSW	B059380	B061683	
3/8 - 20 UN/UNR	B118805						
3/8 - 24 UN/UNR	B116059	B118813	B118825				
3/8 - 28 UN/UNR	B117922	B118819					
3/8 - 32 UN/UNR	B118804	B118817					
3/8 - 40 UN/UNR	B118837						
3/8 - 48 UN/UNR		B118850					
7/16 - 14 UN/UNR	B118564	B118810					
7/16 - 16 UN/UNR	B118806						
7/16 - 20 UN/UNR	B118565	B118814					
7/16 - 24 UN/UNR	B118839	B118852	B118839				
7/16 - 27 UN/UNR	B126537						
7/16 - 28 UN/UNR		B118815					
7/16 - 40 UN/UNR	B118838						

†For standard diameter and pitch combinations for UN, ISO and British
thread forms. Rolls also available for other forms, or for special diameter,
pitch and form threads.

Contact factory application engineering department for details.

** Indicates special helix angle bushings required for RH and LH.

* Indicates RH only.



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No. 3^{1/2} TRRB Revolving Head

DR. NO.	PART NO.	No. PCS.	NAME	DR. NO.	PART NO.	No. PCS.	NAME
TRR-1	A53543	1	Head Body	TRR-14	1PH 3/32x3/16	6	Bushing Retaining Pin
TRR-2	C53547	1	Closing Ring	TRR-15	B53544	1	Roll Retaining Cap
TRR-3	E53554	3	Closing Pin	TRR-16	FA706	3	Retaining Cap Screw
TRR-4	E53550	3	Head Opening Pin	TRR-17	See Chart On Page 9	3	Thread Roll
TRR-5	E53552	3	Head Opening Spring				(Specify Diam. Pitch-Thread Form)
TRR-6	E53551	3	Spring Retaining Pin	TRR-18A*	E60732	3	External Bushing Bearing
TRR-7	B53549	1	Operating Ring	TRR-18B*	E61199	3	Middle Bushing Bearing
TRR-8	C53548	1	Adjusting Ring	TRR-18C*	E61198	3	Internal Bushing Bearing
TRR-9	18SF #10X1/2	2	Adjusting Screw	TRR-20	D60711	3	Roll Shaft
TRR-10	E53556	3	Retaining Segment	TRR-21	D53557	3	Shaft Adjusting Crank
TRR-11	19S #6x1/2	3	Segment Screw	TRR-38	E53545	1	Truarc Retaining Ring
TRR-12	See Chart On Page 9	3	Front Bushing	TRR-40	E53546	1	Shank Retaining Ring
TRR-13	See Chart On Page 9	3	Rear Bushing				

NOTE: When ordering repair parts always designate part by letter, number, and name, in sequence, as listed.

IMPORTANT—Serial number and size of roll head must accompany order. *Bronze and Carbide Bearings available. See [Roll Shaft/Bearing Sets](#) Chart.

