



Specification information for No. 5

thread
rolling
heads—
stationary
and
revolving

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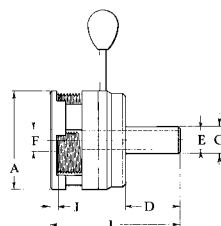
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Specifications for No. 5 thread rolling heads—stationary and revolving

Head Model	Head Type*	Standard Range**	Specifications/Ranges		Max. Thrd. Length Using Spec. Rolls & Std. Bore	Weight***
			Maximum Oversize Range			
5	TRSB Stationary	5/16" to 5/8"—8 mm-16 mm	3/4"-16 Pitch—20 mm-1.5 mm P	5/8"-16 mm	1- 1/8"-28 mm	6 lbs.
5	TRRB Revolving	5/16" to 5/8"—8 mm-16 mm	3/4"-16 Pitch—20 mm-1.5 mm P	5/8"-16 mm	2- 1/2"-63 mm	6 1/2 lbs.

*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.



TRSB Stationary Head

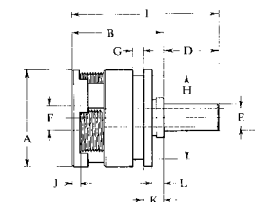
No. 5	A	C	D	E	F	I	J*
	3-1/2"	1"	2"	11-16"	57/64"	4-11/16"	11/32"

*To face of rolls. †Rolls up to shoulder unless diameter exceeds 7/8".

TRRB Revolving Head

No. 5	A	B	C	D	E	F	G	H	I	J*	K	L
	3-1/2"	3-13/32"	1"	2"	11/16"	57/64"	.375"-.385"	3"	5-13/32"	11/32"	13/16"	1/2"

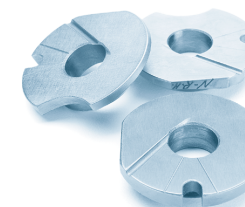
*To face of rolls. †Rolls up to shoulder unless diameter exceeds 7/8".



Replaceable Helix Angle Bushing Sets

UNC BUSHINGS	UNF BUSHINGS	STD. M/M COARSE BUSHINGS	STD. M/M FINE BUSHINGS	STD. LH BUSHING
FRT.	FRT.	FRT.	FRT.	FRT.
C64235	C113539	C119851	C119861	C58641
REAR	REAR	REAR	REAR	REAR
C64236	C113540	C119852	C119862	C58642
3" 40'	2" 45'	3" 15'	2" 30'	2" 40'

†† 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. E55356 MID. E55357 EXT. E55358	SE130526	D116819	D133738	D57811



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Ordering Example:

One set of 5/16"-18 Pitch
UN/UNR, Identical Long
Throat, Thread Rolls, No.
B118623 for No. 5 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. 5 Head.

5 TRB Thread Rolls

SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT	SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT
5/16 - 18 UN/UNR	B118623	B118891	B118920	5/16 - 24 UNJF	B123618		
5/16 - 24 UN/UNR	B104624	B118897	B129681	3/8 - 16 UNJC		B138897	
5/16 - 32 UN/UNR	B118866			3/8 - 24 UNJF	B123619		B067965
3/8 - 16 UN/UNR	B118573	B118892	B118878	7/16 - 20 UNJF	B119799		
3/8 - 24 UN/UNR	B104625	B118898	B118921	1/2 - 13 UNJC	B138176	B138177	
3/8 - 32 UN/UNR	B118867	B118914		1/2 - 20 UNJF	B118880	B123617	B069813
3/8 - 40 UN/UNR	B118931			9/16 - 18 UNJF	B123620		
7/16 - 14 UN/UNR	B118569	B118893		5/8 - 18 UNJF	B123621	B108441	
7/16 - 16 UN/UNR	B119965			5/8 - 24 UNJEF	B135783		
7/16 - 20 UN/UNR	B118545	B118584	B118922				
7/16 - 24 UN/UNR	B129834		B135455	1/8 - 27 NPSM	B058221	B061688	B126568
7/16 - 27 UN/UNR	B118932			1/4 - 18 NPSM	B058223	B061690	
7/16 - 28 UN/UNR	B118868	B118915		3/8 - 18 NPSM	B058226	B061693	
7/16 - 32 UN/UNR			B118926				
1/2 - 12 UN/UNR	B128228			M8 - 1.25 I.S.O.	B124008		B124811
1/2 - 13 UN/UNR	B115110	B118894	B115252	M10 - 1.50 I.S.O.	B132498	B120613	B124812
1/2 - 16 UN/UNR	B118873			M10 - 1.25 I.S.O.	B129117		B129588
1/2 - 18 UN/UNR	B118934	B118940		M10 - 1.0 I.S.O.	B136045		
1/2 - 20 UN/UNR	B104626	B118577	B118923	M12 - 1.75 I.S.O.		B125521	B124813
1/2 - 28 UN/UNR		B120078		M12 - 1.50 I.S.O.	B137327		
1/2 - 32 UN/UNR	B118872		B118919	M12 - 1.25 I.S.O.	B123571	B128899	
1/2 - 40 UN/UNR	B118933			M14 - 2.0 I.S.O.		B120614	
9/16 - 12 UN/UNR	B118558	B118895		M14 - 1.50 I.S.O.	B124687		
9/16 - 18 UN/UNR	B118546	B118899	B118924	M16 - 2.0 I.S.O.		B139490	B124814
9/16 - 20 UN/UNR	B122847	B134403		M16 - 1.50 I.S.O.	B132893		
9/16 - 24 UN/UNR	B118869	B118916					
9/16 - 32 UN/UNR	B118874			5/16 - 18 BSW	B062427		B124815
19/32 - 24 UN/UNR	B118935	B118941		3/8 - 16 BSW	B060721	B061698	B124816
5/8 - 11 UN/UNR	B118566	B118896	B115251	3/8 - 20 BSF	B058230	B061697	
5/8 - 18 UN/UNR	B118585	B118575	B118925	7/16 - 14 BSW	B062428		
5/8 - 20 UN/UNR	B118918			1/2 - 12 BSW	B058236	B061806	B124817
5/8 - 24 UN/UNR	B118870	B118917		1/2 - 16 BSF	B058237	B061807	
5/8 - 28 UN/UNR	B118876			5/8 - 11 BSW	B058245	B061817	
5/8 - 32 UN/UNR	B118875						
				1/2 - 27 GAS		B061809	

†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.



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No. 5 TRRB Revolving Head

DR. NO.	PART NO.	No. PCS.	NAME	DR. NO.	PART NO.	No. PCS.	NAME
TRR-1	A54733	1	Head Body	TRR-15	A49829	1	Roll Retaining Cap
TRR-2	C49832	1	Closing Ring	TRR-16	FA710	3	Retaining Cap Screw
TRR-3	E49833	3	Closing Pin	TRR-17	See Chart On Page 13	3	Thread Roll
TRR-4	E49835	3	Head Opening Pin	TRR-18A*	E55358	3	External Bearing Bushing
TRR-5	E52337	3	Head Opening Spring	TRR-18B*	E55357	3	Middle Bearing Bushing
TRR-6	E49841	3	Spring Retaining Pin	TRR-18C*	E55356	3	Internal Bearing Bushing
TRR-7	B49839	1	Operating Ring	TRR-20	D57811	3	Thread Roll Shaft
TRR-8	C49836	1	Adjusting Ring	TRR-21	D53093	3	Shaft Adjusting Crank
TRR-9	18SF 1/4 x 1	2	Adjusting Screw	TRR-38	Specify Serial No. of Head	1	Retaining Ring (Specify Serial No. of Head)
TRR-10	E49838	3	Retaining Segment	TRR-39	17S #10 x 1/4	1	Retaining Screw
TRR-11	1S #10 x 1/2	3	Segment Screw	TRR-40	E54734	1	TRUARC Retaining Ring
TRR-12	See Chart On Page 13	3	Front Bushing				
TRR-13	See Chart On Page 13	3	Rear Bushing				
TRR-14	1 PH 5/32 x 1/4	6	Bushing Retaining Pin				

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.

