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Specification information for No. 7

thread
rolling
heads—
stationary
and
revolving

[Specs./Ranges](#)

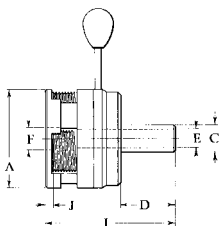
Specifications for No. 7 thread rolling heads—stationary and revolving

Specifications/Ranges

Head Model	Head Type*	Standard Range**	Maximum Oversize Range	Max. Thrd. Length Using Spec. Rolls & Std. Bore	Weight***
7	TRSB Stationary	7/16" to 7/8"—11 mm-22 mm	1"-12 Pitch—24 mm-2.0 mm P	3/4"-19 mm	12-1/2 lbs.
7	TRRB Revolving	7/16" to 7/8"—11 mm-22 mm	1"-12 Pitch—24mm-2.0 mm P	3/4"-19 mm	13-1/2 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

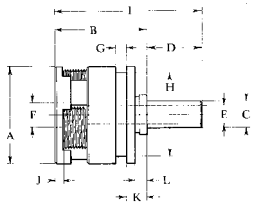
I	A	C	D	E	F	I	J*
No. 7	4-39/64"	1-1/2"	2-1/2"	15/16"	1-9/64"	6-1/16"	7/16"

*To face of rolls. †Rolls up to shoulder unless diameter exceeds 1-1/8" for the No. 3-1/2, 7/8" for the No. 5, 1-1/8" for the No. 7, 1-3/4" for the No. 10 and 3-1/2" for the No. 16.

TRRB Revolving Head

II	A	B	C	D	E	F	G	H	I	J*	K	L
No. 7	4-39/64"	4-9/32"	1-1/2"	2-1/2"	15/16"	1-9/64"	.375"-.385"	4-1/8"	6-25/32"	7/16"	1-1/64"	41/64"

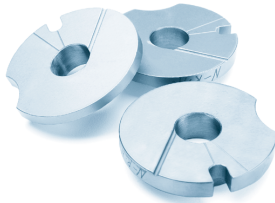
*To face of rolls. †Rolls up to shoulder unless diameter exceeds 1-1/8" for the No. 3-1/2, 7/8" for the No. 5



Replaceable Helix Angle Bushing Sets

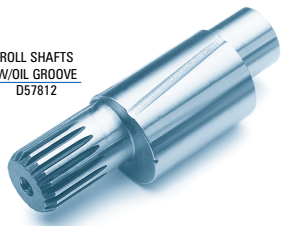
UNC BUSHINGS	UNF BUSHINGS	STD. M/M COARSE BUSHINGS	STD. M/M FINE BUSHINGS	STD. LH BUSHING
FRT.	FRT.	FRT.	FRT.	FRT.
B58526	B113541	B119853	B119863	B58631
REAR	REAR	REAR	REAR	REAR
B58527	B113542	B119854	B119864	B58632
3" 20"	2" 20"	3" 0"	2" 20"	2" 20"

††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 V/OIL GROOVE
INT. E54464 MID. E54465 EXT. E54466	SE130527	D116445	D133739	D57812





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Ordering Example:

One set of 7/16"-14 Pitch
UN/UNR, Identical Long
Throat, Thread Rolls, No.
B118563 for No. 7 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. 7 Head.

7 TRB Thread Rolls

SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT	SIZE	IDENTICAL LONG THROAT	IDENTICAL SHORT THROAT	NO THROAT
7/16 - 14 UN/UNR	B118563	B118970	B118991	7/8 - 12 UN/UNR	B118959		
7/16 - 20 UN/UNR	B116060	B118976	B118992	7/8 - 14 UN/UNR	B112566	B118582	B118996
7/16 - 32 UN/UNR	B118964	B118985		7/8 - 18 UN/UNR	B119105	B119134	B133923
1/2 - 13 UN/UNR	B115752	B118657	B134915	7/8 - 20 UN/UNR	B118963	B118983	
1/2 - 20 UN/UNR	B116061	B118977	B118993	7/8 - 32 UN/UNR		B118988	
1/2 - 28 UN/UNR		B118984					
9/16 - 12 UN/UNR	B118562	B118972		9/16 - 18 UNJF	B127232	B107340	
9/16 - 13 UN/UNR	B118999	B119127		5/8 - 18 UNJF		B098680	
9/16 - 18 UN/UNR	B116062	B118978	B118994	11/16 - 24 UNJEF		B107341	
9/16 - 20 UN/UNR	B118965						
9/16 - 24 UN/UNR	B118961	B118980		3/8 - 18 NPSM	B061898	B125330	
19/32 - 20 UN/UNR	B118971			1/2 - 14 NPSM	B124009		
43/64 - 11 UN/UNR	B119100						
5/8 - 11 UN/UNR	B118567	B118973	B128344	M12 - 1.75 I.S.O.	B129043		
5/8 - 12 UN/UNR	B118957			M12 - 1.50 I.S.O.	B134222		
5/8 - 18 UN/UNR	B112092	B118979	B118995	M12 - 1.25 I.S.O.	B133928		
5/8 - 24 UN/UNR		B118981		M14 - 2.0 I.S.O.	B115468		
11/16 - 11 UN/UNR	B119102	B119129		M14 - 1.50 I.S.O.	B134223		
11/16 - 12 UN/UNR	B127332			M16 - 2.0 I.S.O.	B112592	B134219	B136757
11/16 - 16 UN/UNR	B133962	B118986		M16 - 1.50 I.S.O.	B132163	B125329	
11/16 - 18 UN/UNR	B119101			M16 - 1.25 I.S.O.		B126480	
3/4 - 10 UN/UNR	B112091	B118974		M18 - 1.5 I.S.O.	B134224		
3/4 - 12 UN/UNR	B118958			M20 - 2.5 I.S.O.	B123573	B137344	
3/4 - 16 UN/UNR	B115236	B118578	B120021	M20 - 1.5 I.S.O.	B131276	B135799	
3/4 - 18 UN/UNR	B119104	B125493		M22 - 1.5 I.S.O.	B131211	B130685	
3/4 - 20 UN/UNR	B118962	B118982					
3/4 - 24 UN/UNR	B119103			7/16 - 14 BSW	B059383	B061822	
3/4 - 28 UN/UNR	B118968	B118987		1/2 - 12 BSW	B059382	B061825	
3/4 - 32 UN/UNR	B118967			1/2 - 16 BSF	B061170		
13/16 - 10 UN/UNR	B119109	B119132		5/8 - 11 BSW	B058257	B061832	
13/16 - 12 UN/UNR	B127774			5/8 - 14 BSF	B061169		
13/16 - 16 UN/UNR	B118960	B124886	B125638	3/4 - 10 BSW	B058261	B061837	
13/16 - 18 UN/UNR	B119108	B119131		3/4 - 12 BSF	B068074		
13/16 - 20 UN/UNR		B127234	B118998	7/8 - 9 BSW	B059381	B061842	
13/16 - 24 UN/UNR	B119107	B119130		7/8 - 11 BSF	B065222		
13/16 - 32 UN/UNR	B118969						
27/32 - 28 UN/UNR	B119110	B119133		3/8 - 19 BSPP	B121626		
7/8 - 9 UN/UNR	B118568	B118975	B118990	1/2 - 14 BSPP	B121099		

*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. 7 TRRB Revolving Head

DR. NO.	PART NO.	No. PCS.	NAME	DR. NO.	PART NO.	No. PCS.	NAME
TRR-1	A54750	1	Head Body	TRR-13	See Chart On Page 17	3	Rear Bushing - N.C.
TRR-2	B52457	1	Closing Ring	TRR-14	1 PH 3/16 x 3/8	6	Bushing Retaining Pin
TRR-3	D52466	3	Closing Pin	TRR-15	A52454	1	Roll Retaining Cap
TRR-4	E52463	3	Head Opening Pin	TRR-16	FA717	3	Retaining Cap Screw
TRR-5	E52465	3	Head Opening Spring	TRR-17	See Chart On Page 17	3	Thread Roll
TRR-6	E52464	3	Spring Retaining Pin	TRR-18A*	E54466	3	External Bearing Bushing
TRR-7	A52462	1	Operating Ring	TRR-18B*	E54465	3	Middle Bearing Bushing
TRR-8	B52460	1	Adjusting Ring	TRR-18C*	E54464	3	Internal Bearing Bushing
TRR-9	18SF 5/16 x 1	2	Adjusting Screw	TRR-20	D57812	3	Thread Roll Shaft
TRR-10	E52469	3	Locking Segment	TRR-21	D53218	3	Shaft Adjusting Crank
TRR-11	11S 1/4 x 5/8	3	Segment Screw	TRR-38	D54749	1	Retaining Ring
TRR-12	See Chart On Page 17	3	Front Bushing - N.C.	TRR-40	E54751	1	TRUARC Retaining Ring

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.

